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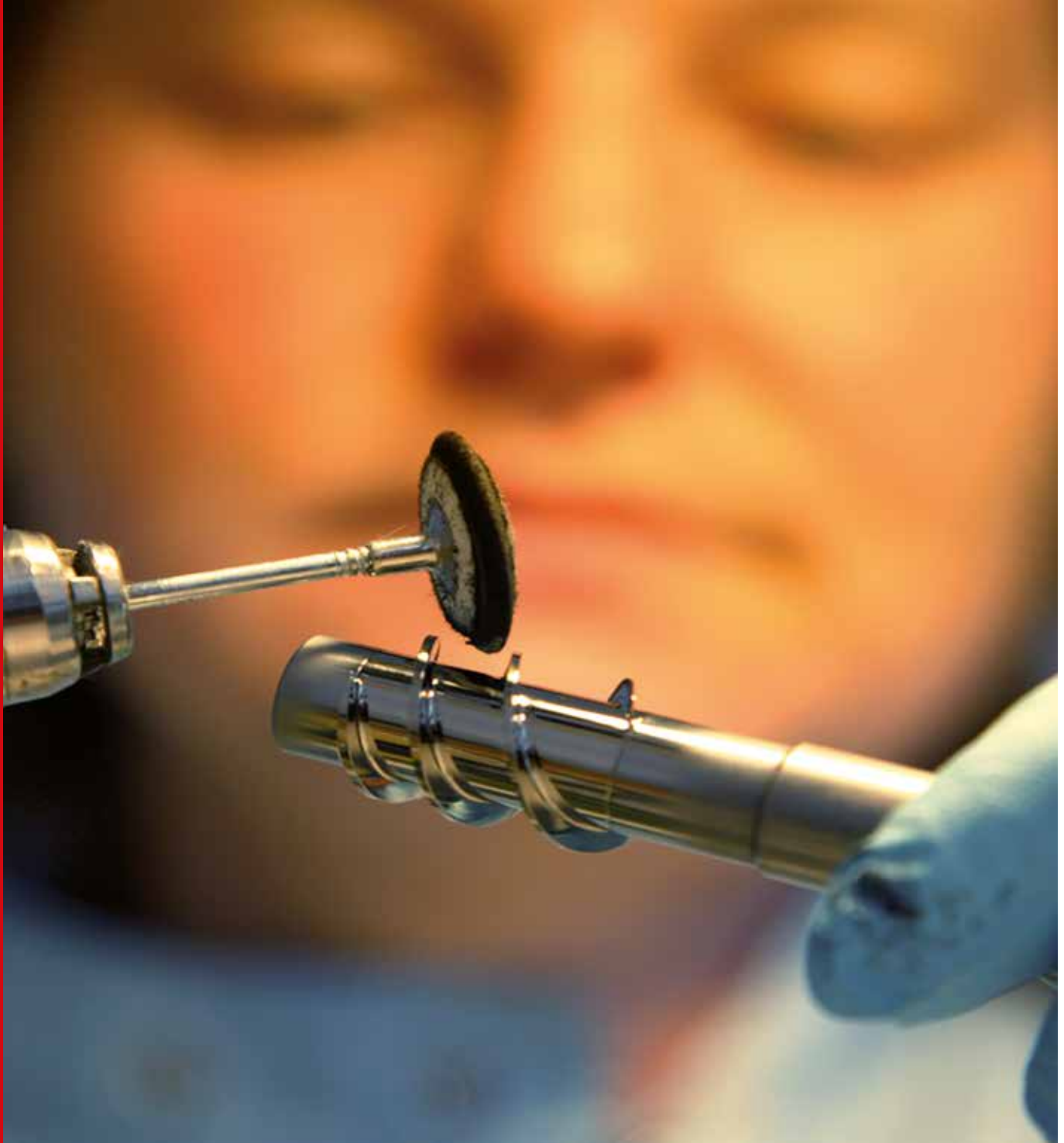
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# Grinding and polishing tools





**116 Compounds and fluids** .....  
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**168 Polishing brushes and buff wheels** .....  
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# 2 Grinding and polishing tools

## Basic principles

### Finest working processes in tool and mould making

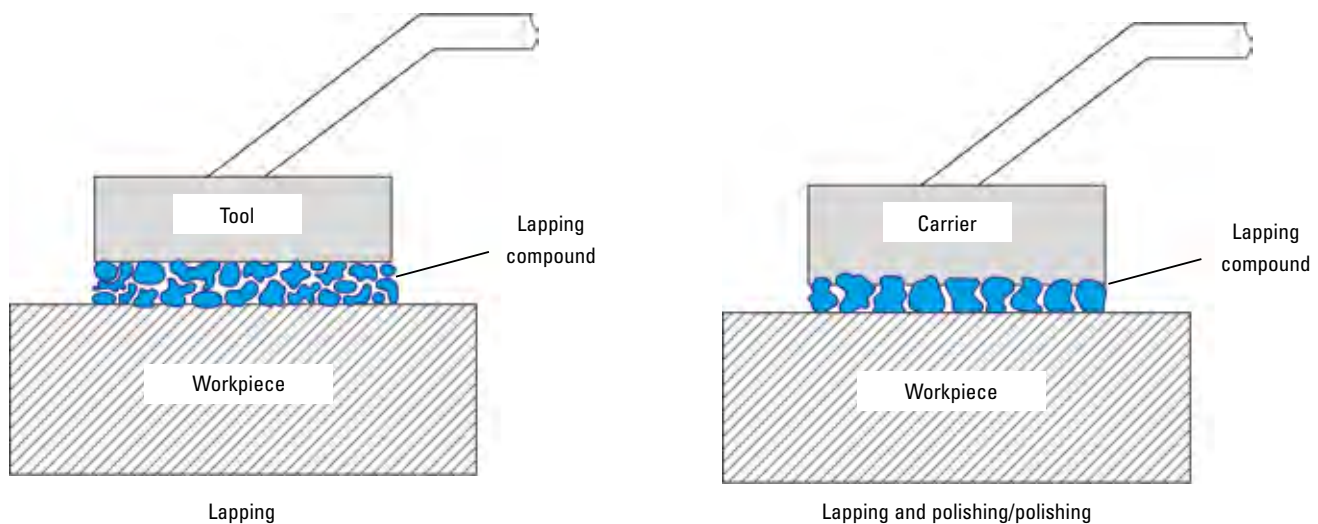
The border between grinding and polishing is not clear-cut and a clear distinction often difficult. Generally, three processes for the fine processing of surfaces can be identified: polishing, lapping and polishing/lapping, all of which are chipping processes with loose grit. These achieve the best roughness values (see page 116).

The surface quality achieved with these processes is mainly dependent on the following factors:

- Grit size of the abrasive
- Working pressure
- Work movement
- Grading of the various abrasives
- Choice of lapping and polishing agent carrier

### Grinding

During preliminary processing, these very fine working processes (finishing) are often preceded by (manual) grinding. This involves a chipping process with firmly bound grit. See on the right side for an overview of typical abrasives.



### Overview of work processes in tool and mould making

	Definition	Process	Result
<b>Manual grinding</b>	Chipping process with firmly bound grit	Directional movement, material is chipped by bound grit	Directional surface
<b>Polishing</b>	Chipping process with loose grit	Directional or undirectional, grit "embedded" in polishing cloth or felt	High-gloss surface
<b>Lapping</b>		Undirectional crossing movement, rolling grain	Matt surface
<b>Lapping and polishing</b>		Directional or undirectional movement, grit penetrates carrier	Shiny surface

#### Basic principles that should be adhered to:

- Always from coarse to fine
- Clean workpiece thoroughly after each grit change
- Change lapping or polishing medium carrier when changing grit

# Grinding and polishing tools

## Basic principles

The theoretical definition of abrasives includes all hard material grits, which are used to achieve stock removal. These are usually applied bound in grinding tools. A distinction is drawn made between natural grits such as quartz, corundum, emery, garnet and natural diamond and synthetic grits such as corundum, silicon carbide, chromium oxide, cubic boron nitride (CBN) and diamonds.

### Corundum (aluminium oxide $Al_2O_3$ )

The most widely used abrasive is classed according to its hardness and toughness:

**Regular aluminium oxide:** consists of approx. 95%  $Al_2O_3$  predominantly from non-alloy and low alloyed steels as well as cast steel and grey cast iron.

**Special fused aluminium oxide:** owing to a 99.9%  $Al_2O_3$  very hard and heat resistant up to 2,000 °C. Very suitable for tough unhardened steels of more than 60 HRC (tool steel), for working with glass and all steels that require cool grinding.

**Semi corundum:** mixture of the above. For steels with high hardness and toughness, that are not heat-sensitive.

### Silicon carbide

Silicon carbide is mainly characterised by its hard and sharp crystals. It is heat-resistant up to approx. 1,370 °C. An abrasive grit generally only consists of one or a few crystals. This material is harder and more brittle than corundum. Silicon carbide is mainly used on non ferrous metals, rust-free steels, ceramic and mineral materials such as carbonaceous steels. It is also used for dressing grinding tools.

### Cubic boron nitride (CBN)

Boron nitride is the second-toughest known material after diamond. It is only suitable as an abrasive in its cubic crystal form (CBN). It is produced synthetically from natural reserves of hexagonal crystalline boron nitride and is usually bound in resin or ceramic. It has a heat resistance of approx. 1,300 °C; from approx. 730 °C, it becomes even harder than diamond! It is used predominantly for grinding tough unhardened steels such as high-speed steel as well as hot- and coldwork steel. Not suitable for soft steels, tungsten carbides, nonferrous metals, chrome and nickel coatings as well as non-metals.

### Diamond

The diamonds used today are almost exclusively synthetic. The hardness and geometries for specific applications achieved are superior to those of natural diamonds. Even as the hardest known material, diamonds are only heat-resistant up to 800 °C and their scope of application is therefore somewhat limited. Diamond tools are mainly used for precision grinding on tungsten carbide, grey cast iron, glass, ceramic, porcelain, fire-proof stones, germanium, graphite, cutting ceramics, silicon, rubber, non-ferrous heavy metal, cementite alloys, nickel and chrome alloys, ball bearing steel, tool steels with high carbon and low vanadium content.



manual grinding



#### Abrasive hardness according to Knoop

Diamond	6000
Cubic boron nitride (CBN)	4700
Boron carbide	2800
Silicon carbide	2480
Corundum	2050
Zirconium corundum	1800



# 2 Surface roughness

## Overview of the surface roughness of the preliminary processing methods and the different grinding medium grit sizes in linear processing

When selecting the correct grit size, a surface improvement by 1.5 roughness classes (coarse surfaces) to 0.5 roughness classes (fine surfaces) should be taken into account.

The tips of the wedges of preliminary processing are max. attainable values under good working conditions. The stock removal dimensions are usually higher than the absolute surface roughness (errors in the macrostructure and removal of the erosion skin). It may therefore be advisable to begin with a coarser grit size.

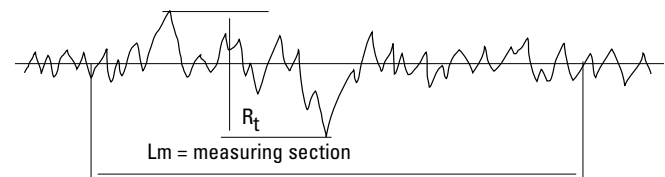
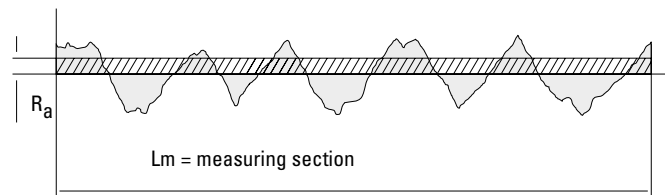
### Surface roughness in mould building

#### $R_a$

In by far the most cases, the surface roughness is indicated as an  $R_a$  value. The average roughness value finish  $R_a$  is the height of the fictitious surface over the midline, the magnitude of which corresponds to the sum of the individual surfaces above and below. The visual appearance may markedly deviate from the indication of the  $R_a$  value: e.g. smaller  $R_a$  value with visible isolated scratches.

#### $R_t$

The  $R_t$  value is considerably more meaningful for assessment of very fine surface finishes in mould making: the maximum peak-to-valley height  $R_t$  is the vertical distance between the highest and lowest point within the measuring section. For surface roughness indications in this catalogue, the maximum peak-to-valley height  $R_t$  is generally used.



### Roughness classes

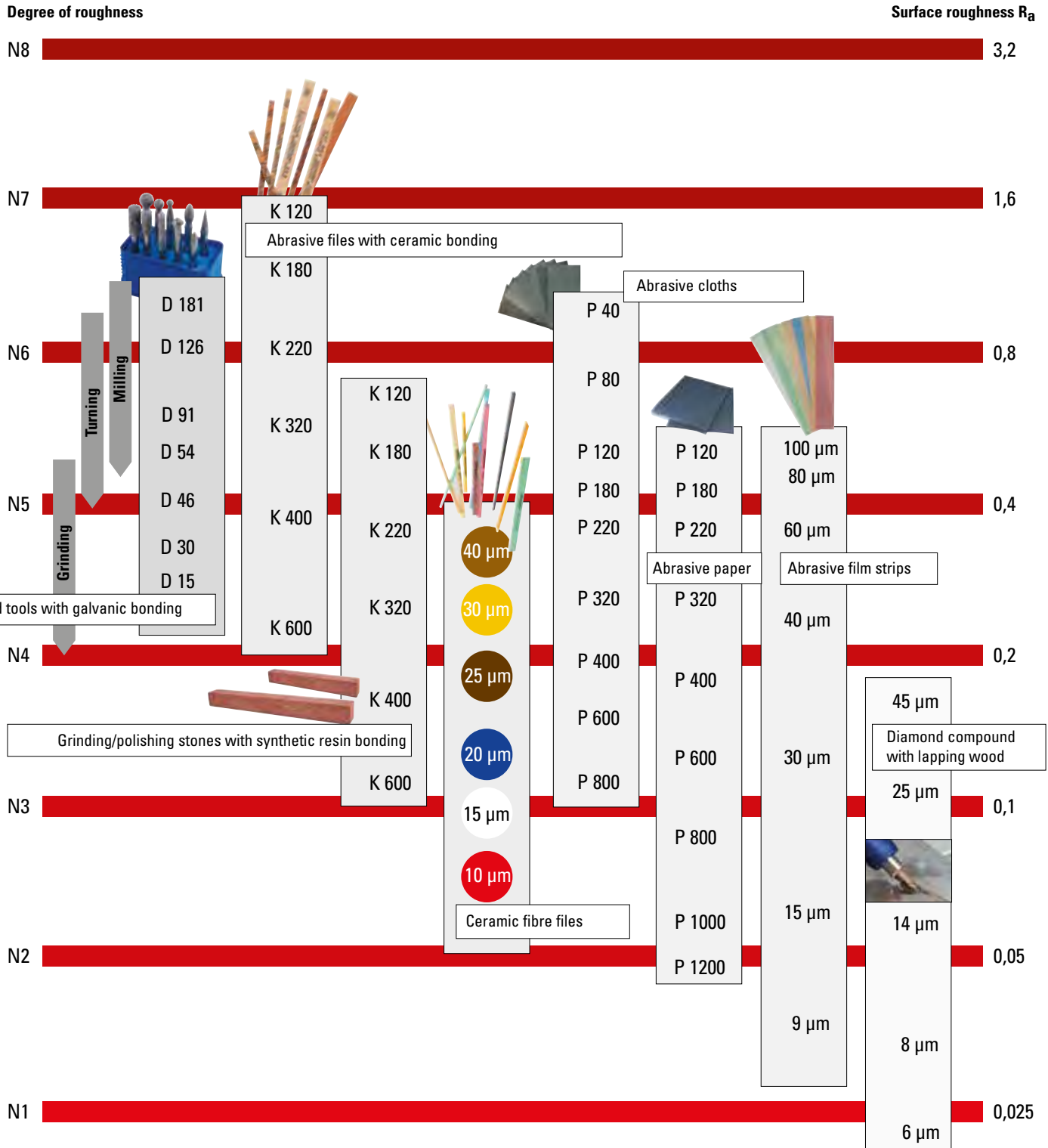
The roughness classes according to DIN/ISO 1302 are indicated as  $R_a$  values. The  $R_t$  values listed in the table are estimated values that are not contained in the standard. The ratio  $R_a:R_t$  corresponds to approx. 1:8 to 1:12 during manual working. As a result of the evenness of manual working and also less pressure and good lubrication, the ratio  $R_a:R_t$  can be reduced to 1:6. All the values indicated in this catalogue are empirically determined on steel 1.2767 with 53 HRC and represent non-binding guideline values.



#### Roughness classes according to DIN/ISO 1302

Degree of roughness No.	Roughness value $R_a$ ( $\mu\text{m}$ )	Roughness value $R_{\text{max}}$ ( $\mu\text{m}$ )
N 12	50	~ 500
N 11	25	~ 250
N 10	12.5	~ 125
N 9	6.3	~ 60
N 8	3.2	20 ... 40
N 7	1.6	10 ... 20
N 6	0.8	6 ... 10
N 5	0.4	2 ... 6
N 4	0.2	1.5 ... 2.5
N 3	0.1	0.75 ... 1.25
N 2	0.05	0.3 ... 0.7
N 1	0.025	0.1 ... 0.3

# Surface roughness 2



# 2 Diamond compound polishing system joke Magic

**joke Magic enables you to polish all types of steel, tungsten carbide, ceramics, aluminium and all non-ferrous metals. In no time at all. Reproducible. In material laboratory quality!**

### Diamond compound polishing system joke Magic

Everyone knows that many roads lead to Rome and there are just as many to the polishing result you want. Wouldn't it be nice to have a system that has been carefully devised to make sure you get the same highgloss finish on the workpiece every time? A system for achieving reproducible results on all types of steel, as well as on tungsten carbides, ceramics, nonferrous metals and aluminium.

### Welcome to joke Magic!

#### joke Magic saves time...

...because its components make sure you attain smoother surfaces quicker without orange peel effect or excavations. With joke Magic you polish in logical steps.

#### joke Magic saves money...

...because you achieve your goal using less "material". All its components give you the best results with optimised economy and longer life.

#### joke Magic just does it better...

...see for yourself what joke Magic can do. It's time to switch!



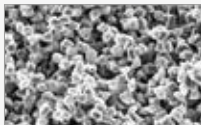
### joke Magic = unparalleled high diamond concentrations

**joke Magic strong:** the "strong" concentration of our Magic diamond compounds is already comparable to that of other compounds with concentrations indicated as "extra strong", "strong", "very strong", "SS", "K 100", "high", "heavy", etc.

**joke Magic extra strong:** Our Magic diamond compounds contain twice the quantity of diamonds in comparison to other compounds. Owing to a special manufacturing process, we have managed to rule out contact between the individual diamond grit particles in spite of twice the quantity. Consequently, an inimitable, extremely high stock removal is achieved.

**joke Magic ultra strong:** Even higher concentration compared to extra strong!

The diamond compounds from the joke Magic series have become the favourite compounds of many polishers, since they always yield a perfect result as innovative all-round diamond compounds. This is something you should not miss either.



joke Magic 6 µm diamond grit  
– closely calibrated with uniform grit shape –



Standard compound, 6 µm diamond grit  
– poorly calibrated with uneven grit shape –


# Compounds and fluids



# joke Magic Diamond compounds - overview

2

Diamond paste	Tool steel	Steel in general	Fine steel	Stainless steel	Titanium, cobalt and nickel alloys	Hard metal ceramic	Aluminium non-ferrous metals
joke Magic	very suitable	suitable	very suitable	suitable	suitable	suitable	
joke Eco Star	very suitable		very suitable				suitable
joke Magic Alu							very suitable
joke Magic FAS	suitable	very suitable	suitable	very suitable	very suitable	very suitable	
joke Magic HYBRID	very suitable	very suitable	suitable	very suitable	very suitable	very suitable	
joke Magic POWER	very suitable	suitable	very suitable	suitable	suitable	suitable	
joke Magic US	suitable		very suitable		suitable		suitable
joke Magic WS				suitable			very suitable

 very suitable

 suitable

## Diamond compounds joke Magic oil and alcohol soluble

Our best-selling diamond compound. Specially designed for the new types of steel that tools are manufactured in. To be used neat or with just two drops of diamond fluid. Normally, diamond compounds must be used with a large amount of fluid. Using a large amount of fluid, however, has the effect of making the diamond compound runny, so that a lot of it is simply projected away during polishing. joke Magic diamond compound effectively creates a precisely calibrated, blocky diamond grit, which guarantees top-quality polishing. The result is an incomparably high level of removal on all materials: From soft aluminium to the hardest ceramics as well as for unlimited use on all grades of steel and tungsten carbides.

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
<b>Diamond compounds joke Magic, oil and alcohol soluble</b>							
10 g	0.25 µm	extra high	grey	<b>0 590 109</b>			
	1 µm	extra high	blue	<b>0 590 101</b>			
	3 µm	extra high	green	<b>0 590 102</b>			
	6 µm	extra high	yellow	<b>0 590 103</b>			
	9 µm	extra high	red	<b>0 590 104</b>			
	14 µm	extra high	brown	<b>0 590 105</b>			
	25 µm	extra high	mahagony	<b>0 590 106</b>			
	45 µm	extra high	purple	<b>0 590 107</b>			
	70 µm	extra high	burgundy	<b>0 590 108</b>			
	20 g	0.25 µm	extra high	grey	<b>0 590 200</b>		
1 µm		extra high	blue	<b>0 590 201</b>			
3 µm		extra high	green	<b>0 590 202</b>			
6 µm		extra high	yellow	<b>0 590 203</b>			
9 µm		extra high	red	<b>0 590 204</b>			
14 µm		extra high	brown	<b>0 590 205</b>			
25 µm		extra high	mahagony	<b>0 590 206</b>			
45 µm		extra high	purple	<b>0 590 207</b>			
70 µm		extra high	burgundy	<b>0 590 208</b>			
0.25 µm		high	grey	<b>0 590 300</b>			
1 µm		high	blue	<b>0 590 301</b>			
3 µm		high	green	<b>0 590 302</b>			
6 µm		high	yellow	<b>0 590 303</b>			
9 µm		high	red	<b>0 590 304</b>			
14 µm		high	brown	<b>0 590 305</b>			
25 µm		high	mahagony	<b>0 590 306</b>			
45 µm		high	purple	<b>0 590 307</b>			
70 µm		high	burgundy	<b>0 590 308</b>			





## Diamond compounds joke Eco-Star the coloured

This diamond compound has been produced for all users who would like to work with a coloured compound. The compound is universally soluble and is recommended as a good alternative to other coloured diamond compounds owing to high stock removal and production of a good shine. Very good for wiping with polishing wool!

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
<b>Diamond compounds joke Eco-Star, the coloured</b>							
<b>universally soluble</b>							
20 g	0.25 µm	extra high	grey	<b>0 590 870</b>			
	1 µm	extra high	blue	<b>0 590 871</b>			
	3 µm	extra high	green	<b>0 590 872</b>			
	6 µm	extra high	yellow	<b>0 590 873</b>			
	9 µm	extra high	red	<b>0 590 874</b>			
	15 µm	extra high	brown	<b>0 590 875</b>			
	25 µm	extra high	mahogany	<b>0 590 876</b>			
	45 µm	extra high	purple	<b>0 590 877</b>			



**Each paste with individual identification colour!**

### *The perfect complement*

Stripe-free cleaning after polishing.  
Can also be used for cleaning lapped workpieces.  
Oil and silicone-free. Low odour.



Order No.	Price
<b>0 590 610</b>	



## 2 Diamond compounds joke Magic POWER oil soluble

**NEW!**


Ultra-high concentration of diamond particles for even faster removal, saving time and money.

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
<b>Diamond Compound joke Magic POWER</b>							
10 g	1 µm	ultra high	blue	<b>0 590 371</b>			
	3 µm	ultra high	green	<b>0 590 372</b>			
	6 µm	ultra high	yellow	<b>0 590 373</b>			
	9 µm	ultra high	red	<b>0 590 374</b>			
	14 µm	ultra high	brown	<b>0 590 375</b>			
	25 µm	ultra high	mahogany	<b>0 590 376</b>			
	45 µm	ultra high	purple	<b>0 590 377</b>			
	70 µm	ultra high	burgundy	<b>0 590 378</b>			



## Diamond Compound joke Magic HYBRID polycrystalline and monocrystalline diamonds

The joke Magic HYBRID compound consists of a combination of polycrystalline and monocrystalline diamonds. The friable polycrystalline diamond ensures rapid stock removal even on hard surfaces, while the monocrystalline diamond raises a high gloss. The diamond compound is universally soluble.

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
<b>Diamond Compound joke Magic HYBRID</b>							
 10 g	1 µm	extra high	blue	<b>0 590 881</b>			
	3 µm	extra high	green	<b>0 590 882</b>			
	6 µm	extra high	yellow	<b>0 590 883</b>			

# Polishing starter set

## Diamond pastes and more to get started

	Price from
Order No.	1 piece

### Polishing starter set

The set contains:


1004

- 1 x Storage box - twins
- 1 x Diamondpaste joke Magic sample extra strong 3 μ, 2g
- 1 x Diamondpaste joke - FAS, sample öllöslich, extra strong 6μ, 2g
- 1 x Diamondpaste joke Magic sample extra strong 9 μ, 2g
- 1 x Diamondpaste joke Magic sample extra strong 14μ, 2g
- 1 x Diamond fluid joke Magic, oil soluble 10 ml
- 1 x Super-fine polishing diamond suspension joke Magic, 1 μm, 10 ml, water- and alcohol soluble
- 1 x Grinding and polishing stone oil (fluid), 20 ml
- 1 x Rubber holder ROTAFLEX, Ø 18 mm, S.-Ø 3 x 26 mm, type RK 1
- 2 x Premium economy abrasive cloth rolls, corundum, KK114 F, 50 m x 50 mm, grit 320,
- 2 x Kleenex polishing cloths - white, 3-ply, 1 pack (72 cloths), 20 x 20cm
- 1 x Cleaning fluid joke X 73016-A, 500 ml spray can
- 2 x Polishing felt, cylinder, Ø 6 x 10 mm, standard, shank-Ø 3 x 40 mm
- 2 x Wooden lapping stick, hard, rectangular, 7 x 3 x 150 mm
- 2 x Wooden lapping stick, soft, rectangular, 7 x 3 x 150 mm
- 2 x Wooden lapping stick, hard, round Ø 3 x 150 mm
- 1 x Grinding and polishing stone Gesswein® DIEMAKER, type 2402, 6 x 6 x 150 mm, grit 400
- 1 x Grinding and polishing stone Gesswein® DIEMAKER, type 2602, 6 x 6 x 150 mm, grit 600
- 1 x Grinding and polishing stone Gesswein® DIEMAKER, type 2301, 6 x 3 x 150 mm, grit 400
- 1 x Grinding and polishing stone Gesswein® DIEMAKER, type 2601, 6 x 3 x 150 mm, grit 600
- 3 x Polishing felts, cylinder Ø 10 x 10 mm, S.-Ø 3 x 40 mm
- 5 x Polishing cloth, SAMBA-N, self adhesive, Ø 20 mm
- 1 x Workpiece for polishing course, material 1.2767, 80 x 40 mm
- 1 x Surfaces sample plate




## 2 Diamond compounds joke Magic ALU water and alcohol soluble

Special compound for aluminium and all non-ferrous metals. Can be used on all host materials, in either a rotating or a linear motion.

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
<b>Diamond compounds joke Magic ALU, water and alcohol soluble</b>							
 10 g	1 µm	extra high	blue	<b>0 591 101</b>			
	3 µm	extra high	green	<b>0 591 102</b>			
	6 µm	extra high	yellow	<b>0 591 103</b>			
	9 µm	extra high	red	<b>0 591 104</b>			
	14 µm	extra high	brown	<b>0 591 105</b>			


## Diamond compounds joke Magic FAS the polycrystalline

joke Magic FAS diamond compound consists of a low-viscosity, easily spreadable oil-soluble carrier with hard synthetic diamonds (PKD). The polycrystalline diamond is significantly stronger than the cheaper monocrystalline diamond. Owing to the high stock removal rates, this compound is particularly suitable for hard materials such as ceramic, carbide, cobalt, titanium or nickel.

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
<b>joke Magic FAS diamond compounds, the polycrystalline</b>							
 10 g	0.25 µm	extra high	grey	<b>0 590 820</b>			
	1 µm	extra high	blue	<b>0 590 821</b>			
	3 µm	extra high	green	<b>0 590 822</b>			
	6 µm	extra high	yellow	<b>0 590 823</b>			
	9 µm	extra high	red	<b>0 590 824</b>			
	15 µm	extra high	brown	<b>0 590 825</b>			
	25 µm	extra high	mahogany	<b>0 590 826</b>			
20 g	0.25 µm	extra high	grey	<b>0 590 820-1</b>			
	1 µm	extra high	blue	<b>0 590 821-1</b>			
	3 µm	extra high	green	<b>0 590 822-1</b>			
	6 µm	extra high	yellow	<b>0 590 823-1</b>			
	9 µm	extra high	red	<b>0 590 824-1</b>			
	15 µm	extra high	brown	<b>0 590 825-1</b>			
	25 µm	extra high	mahogany	<b>0 590 826-1</b>			


## Diamond compounds joke Magic US universally soluble

Can be mixed with water, oil or alcohol. Very smooth, very easy to clean.

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
<b>joke Magic US diamond compound, universally soluble</b>							
 10 g	1 µm	extra high	blue	<b>0 590 351</b>			
	3 µm	extra high	green	<b>0 590 352</b>			
	6 µm	extra high	yellow	<b>0 590 353</b>			
	9 µm	extra high	red	<b>0 590 354</b>			
	14 µm	extra high	brown	<b>0 590 355</b>			
	25 µm	extra high	mahagony	<b>0 590 356</b>			
	45 µm	extra high	purple	<b>0 590 357</b>			
	70 µm	extra high	burgundy	<b>0 590 358</b>			
	90 µm	extra high	grey	<b>0 590 359</b>			

## Diamond compounds joke Magic WS water and alcohol soluble

The compound you need to achieve very high gloss effects. Fantastic with high-speed steels!

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
<b>joke Magic WS diamond compound, water and alcohol soluble</b>							
 10 g	1 µm	extra high	blue	<b>0 590 701</b>			
	3 µm	extra high	green	<b>0 590 702</b>			
	6 µm	extra high	yellow	<b>0 590 703</b>			
	9 µm	extra high	red	<b>0 590 704</b>			
	14 µm	extra high	brown	<b>0 590 705</b>			
	25 µm	extra high	mahagony	<b>0 590 706</b>			
	45 µm	extra high	purple	<b>0 590 707</b>			
	70 µm	extra high	burgundy	<b>0 590 708</b>			
	90 µm	extra high	grey	<b>0 590 709</b>			

## Diamond sprays joke Magic alcohol soluble

These diamond sprays contain extremely hard, synthetically manufactured diamonds in an alcohol soluble carrier. Also ideal for hard materials such as ceramic and carbide.

**CFC-free**

Content	Grit size	Order No.	Price from
			1 piece
<b>Diamond spray joke Magic, alcohol soluble</b>			
200 ml	1 µm	<b>0 590 910</b>	
200 ml	3 µm	<b>0 590 913</b>	
200 ml	6 µm	<b>0 590 914</b>	
200 ml	9 µm	<b>0 590 915</b>	
200 ml	15 µm	<b>0 590 916</b>	





## 2 Diamond gels joke Magic water and alcohol soluble

The joke Magic diamond gels are "ready to use" and can be used without any other fluids. The viscosity of the gel is maintained even over a prolonged period. The diamond concentration within the gel is very high and thus enables economical use even on larger areas. Always take care to shake the gel well for sufficient time before use.

	Content	Grit size	Colour	Type	Order No.	Price from	
						1 piece	5 pieces
<b>Diamond gels joke Magic monocrystalline diamond</b>							
	20 g	1 µm	blue	WS	<b>0 590 650</b>		
	20 g	3 µm	green	WS	<b>0 590 651</b>		
	20 g	6 µm	yellow	WS	<b>0 590 652</b>		
	20 g	9 µm	red	WS	<b>0 590 653</b>		
	20 g	14 µm	brown	WS	<b>0 590 654</b>		
	20 g	25 µm	mahogany	WS	<b>0 590 655</b>		



Also available as „polycrystalline“ version.

Order example:  
**0 590 650-P** for 1µm polycrystalline

## Diamond fluids Diamond fluid joke Magic, oil soluble

Thinner for joke Magic diamond compounds, joke Magic US and joke Eco-Star

	Content	Order No.	Price from
			1 piece
<b>Diamond fluid joke Magic, oil soluble</b>			
	0.5 l	<b>0 590 451</b>	
	2.5 l	<b>0 590 451-1</b>	
	10 l	<b>0 590 452</b>	

## Diamond fluid joke Magic w/a water and alcohol soluble

Specially for joke Magic W/A diamond compounds, with 100% corrosion protection

Content	Order No.	Price from
		1 piece
<b>Diamond fluid joke Magic w/a, water and alcohol soluble</b>		
500 ml	<b>0 591 451</b>	



### Accessories / spare parts

	Order No.	Price from
		1 piece
<b>Dosing bottle with pipette, oilproof</b>		
30 ml	<b>0 590 491-1</b>	

## Super-fine polishing suspensions joke Magic water soluble

### joke Magic super-fine polishing suspension


joke Magic super-fine polishing suspension with combined anti-corrosion power gives workpieces that final, brilliant gloss. This thin suspension and the blocky, agglomerate-free diamonds enables totally scratch-free polishing. If necessary, you can use the super-fine polishing suspension together with the joke Magic „Clean“ cloth to remove any shadows created during final polishing.

	Content	Grit size	Order No.	Price from 1 piece
<b>Super-fine diamond plastic polishing medium joke Magic</b>				
	50 ml	1 µm	<b>0 590 901</b>	
	500 ml	1 µm	<b>0 590 902</b>	
	50 ml	3 µm	<b>0 590 903</b>	
	50 ml	6 µm	<b>0 590 904</b>	
<b>Super-fine diamond polishing suspension joke Magic</b>				
	50 ml	1 µm	<b>0 590 400-1</b>	
		3 µm	<b>0 590 401-1</b>	
		6 µm	<b>0 590 402-2</b>	
	500 ml	1 µm	<b>0 591 401</b>	
		3 µm	<b>0 590 401</b>	
		6 µm	<b>0 591 402</b>	


## Diamond compound polishing system joke Magic Grinding and polishing stones joke Magic STONES

### Magic STONES grinding stones

A complete system incorporating grinding stones for pretreatment purposes. The fixed connection to the connecting rod (click system) ensures that no edging takes place whenever the Magic STONES are fitted, which prevents the rat marks usually created otherwise. The spherical pressure load ensures that grinding is vibration-free and leads to a totally even grinding result. The Magic STONES guarantee that the subsequent steps in the process can be carried out error-free.




	Dimensions	Grit size	Packing quantity	Order No.	Price from 1 pack
<b>Grinding and polishing stones joke Magic STONES</b>					
<b>rectangular</b>					
	7 x 9 x 4 mm	220	10 pieces	<b>0 590 759</b>	
		320	10 pieces	<b>0 590 760</b>	
		400	10 pieces	<b>0 590 761</b>	
		600	10 pieces	<b>0 590 762</b>	

### Accessories / spare parts


	Dimensions	Order No.	Price from 1 piece
<b>Ball-ended rod for Magic STONES</b>			
	140 mm	<b>0 590 752</b>	

## 2 Polishing cloths self-adhesive



Polishing cloths are perfect for final polishing. Thanks to their self-adhesive backing, these cloths can be mounted on a wide variety of holders. Thus, for example, tools used during preparation can be reused simply by sticking the polishing cloth on them. You can choose between standard polishing cloths and Magic JOKER, FINAL and SHINE polishing cloths, which were specially designed for use with joke Magic diamond compound. JOKER and FINAL cloths can be used on 99% of materials. They are ideal for polishing all types of steel and aluminium. SHINE cloths were developed specially for polishing plastics. The cushioning base layer in these cloths means that they are very quiet to use and reduces score marks on the material. Breakouts and dimpling are prevented.

	Shape	Dimensions	Design	Type	Packing quantity	Order No.	Price from 1 pack	
<b>Polishing cloths joke Magic, self-adhesive</b>								
	<b>Magic JOKER</b> (synthetic fibre cloth) for diamond compound grit sizes 6 to 3 µm		round	Ø 20 x 1 mm	self-adhesive	Magic JOKER	50 pieces	<b>0 591 501</b>
	round	Ø 32 x 1 mm	self-adhesive	Magic JOKER	50 pieces	<b>0 591 502</b>		
	rectangular	9 x 11.5 x 1 mm	self-adhesive	Magic JOKER	50 pieces	<b>0 591 503</b>		
	square	100 x 100 mm	self-adhesive	Magic JOKER	50 pieces	<b>0 591 505</b>		
	<b>Magic FINAL</b> (short flocked cloth) for diamond compound grit sizes 3 to 1 µm		round	Ø 20 x 2 mm	self-adhesive	Magic FINAL	50 pieces	<b>0 591 601</b>
	round	Ø 32 x 2 mm	self-adhesive	Magic FINAL	50 pieces	<b>0 591 602</b>		
	rectangular	9 x 11.5 x 2 mm	self-adhesive	Magic FINAL	50 pieces	<b>0 591 603</b>		
	square	100 x 100 mm	self-adhesive	Magic FINAL	50 pieces	<b>0 591 605</b>		
	<b>Magic SHINE</b> especially for plastics. Diamond compound grit sizes 6, 3 and 1 µm		round	Ø 12 mm	self-adhesive	Magic SHINE	50 pieces	<b>0 591 707</b>
	round	Ø 18 x 2 mm	self-adhesive	Magic SHINE	50 pieces	<b>0 591 701</b>		
	round	Ø 32 x 2 mm	self-adhesive	Magic SHINE	50 pieces	<b>0 591 702</b>		
	rectangular	9 x 11.5 x 2 mm	self-adhesive	Magic SHINE	50 pieces	<b>0 591 703</b>		
	square	100 x 100 mm	self-adhesive	Magic SHINE	50 pieces	<b>0 591 706</b>		

### Accessories / spare parts

	Dimensions	Shank dimensions	Type	Suitable abrasive discs	Packing quantity	Order No.	Price from
							1 piece 1 pack 5 pieces 10 pieces
<b>Toggle rod for tool carrier</b>							
		Ø 3.5 mm				<b>0 411 008</b>	
<b>Supports for felts and cloths</b>							
	9 x 11.5				10 pieces	<b>0 411 009-2</b>	
<b>Rubber holder ROTAFLEX</b>							
	Ø 10 mm	Ø 3 x 26 mm	RK 0	R 0		<b>0 544 101</b>	
	Ø 18 mm	Ø 3 x 26 mm	RK 1	R 1		<b>0 544 103</b>	
	Ø 30 mm	Ø 3 x 26 mm	RK 2	R 2		<b>0 544 104</b>	

## Polishing cloths self-adhesive

	Shape	Dimensions	Design	Type	Packing quantity	Order No.	Price from	
							1 pack	5 packs
<b>Standard polishing cloths, self-adhesive</b>								
 <p><b>Type 450</b> for diamond compound grit sizes 6 to 3 µm</p>	round	Ø 12 x 0.8 mm	self-adhesive	450	10 pieces	<b>0 543 311</b>		
	round	Ø 20 x 0.8 mm	self-adhesive	450	10 pieces	<b>0 543 312</b>		
	round	Ø 33 x 0.8 mm	self-adhesive	450	10 pieces	<b>0 543 313</b>		
	round	Ø 50 x 0.8 mm	self-adhesive	450	10 pieces	<b>0 543 314</b>		
	round	Ø 78 x 0.8 mm	self-adhesive	450	10 pieces	<b>0 543 316</b>		
 <p><b>Type 432</b> for diamond compound grit sizes 3 to 1/4 µm</p>	round	Ø 12 x 1.0 mm	self-adhesive	432	10 pieces	<b>0 543 301</b>		
	round	Ø 20 x 1.0 mm	self-adhesive	432	10 pieces	<b>0 543 302</b>		
	round	Ø 33 x 1.0 mm	self-adhesive	432	10 pieces	<b>0 543 303</b>		
	round	Ø 50 x 1.0 mm	self-adhesive	432	10 pieces	<b>0 543 304</b>		
	round	Ø 78 x 1.0 mm	self-adhesive	432	10 pieces	<b>0 543 306</b>		

## Polishing cloths Kleenex

High quality 3-ply cloth for wiping after polishing and for applying joke Magic very fine polishing suspension (similar illustration).

Design	Content	Colour	Dimensions	Order No.	Price from
					1 piece
<b>Polishing cloths Kleenex</b>					
3 layers	72 cloths	white	20 x 20 cm	<b>0 590 602</b>	



# Diamond compounds Hyprez®



## Diamond compounds Hyprez®

### The diamonds

Our Hyprez® diamond compounds contain only special, tested and approved diamonds, ("Advanced Technology Diamonds") from brand manufacturers. They are selected with the greatest care for their size, purity and shape. The diamonds are very pressure-resistant and stay "aggressive" for as long as it is needed. Decades of use of Hyprez® diamond products in industrial mould-making as well as electronics and nanotechnology demonstrate that these products can meet the toughest requirements.

### The host material

The host material will not separate from the diamond content and does not dry out. Its compatibility with the various solvents and the solubility of the compounds is also monitored closely.

### Continuity thanks to quality

Hyprez® compounds deliver consistent, optimum polishing results. The durability of the diamond compounds is outstanding. The production process, which is continually improved and checked, ensures that their extremely high quality really lasts.



## All Hyprez® diamond compounds at a glance

<b>F - Versatile compound</b>	The widest and most varied range of concentrations.
<b>S - Economy compound</b>	Developed for simple, cost-effective jobs.
<b>W - Eco-compound</b>	Water-based W compound developed for environment-friendly and oil-sensitive tasks.
<b>OS - Oil-soluble compound</b>	The ideal compound for high stock removal requirements.
<b>L - for hard cases</b>	Especially for working on tungsten carbide, ceramics and hardened steel.
<b>Super-L - finishing compound</b>	Finest grits for finishing hardened steels and ceramics.
<b>C11 - Stabilised compound</b>	The best compound for direct use on hot moulds or upright walls. Special host material providing optimum tool adhesion.
<b>SC-HT</b>	For high-temperature-areas up to 250°C.





## Diamond compounds Hyprez® F oil and water soluble

For maximum flexibility the Hyprez® F series offers both water and oil soluble hosts and a large selection of diamond concentrations. 5 g in Hyplicator® or 10 g syringe.

Content	Grit size	Concentration	Colour	Type	Order No.	Price from		
						1 piece	3 pieces	6 pieces
<b>Diamond compounds Hyprez® F, oil and water soluble</b>								
5 g 	0.10 µm	high	grey	1/10-F 2	<b>0 580 002</b>			
	0.25 µm	high	grey	1/4-F 2	<b>0 580 004</b>			
	1 µm	low	blue	1-F 1	<b>0 580 005</b>			
	1 µm	high	blue	1-F 3	<b>0 580 006</b>			
	1 µm	extra high	blue	1-F 4	<b>0 580 007</b>			
	3 µm	medium	green	3-F 3	<b>0 580 009</b>			
	3 µm	high	green	3-F 4	<b>0 580 010</b>			
	3 µm	extra high	green	3-F 6	<b>0 580 011</b>			
	6 µm	medium	yellow	6-F 4	<b>0 580 012</b>			
	6 µm	high	yellow	6-F 5	<b>0 580 013</b>			
	6 µm	extra high	yellow	6-F 7	<b>0 580 014</b>			
	8 µm	medium	red	8-F 6	<b>0 580 015</b>			
	8 µm	high	red	8-F 8	<b>0 580 016</b>			
	14 µm	medium	brown	14-F 6	<b>0 580 018</b>			
	14 µm	high	brown	14-F 8	<b>0 580 019</b>			
	14 µm	extra high	brown	14-F 9	<b>0 580 020</b>			
	25 µm	medium	mahagony	25-F 6	<b>0 580 021</b>			
	25 µm	high	mahagony	25-F 8	<b>0 580 022</b>			
	45 µm	medium	purple	45-F 6	<b>0 580 024</b>			
	45 µm	high	purple	45-F 8	<b>0 580 025</b>			
60 µm	extra high	orange	60-F 9	<b>0 580 027</b>				
10 g 	0.10 µm	high	grey	1/10-F 2	<b>0 580 032</b>			
	0.25 µm	high	grey	1/4-F 2	<b>0 580 034</b>			
	1 µm	low	blue	1-F 1	<b>0 580 035</b>			
	1 µm	high	blue	1-F 3	<b>0 580 036</b>			
	1 µm	extra high	blue	1-F 4	<b>0 580 037</b>			
	3 µm	medium	green	3-F 3	<b>0 580 039</b>			
	3 µm	high	green	3-F 4	<b>0 580 040</b>			
	3 µm	extra high	green	3-F 6	<b>0 580 041</b>			
	6 µm	medium	yellow	6-F 4	<b>0 580 042</b>			
	6 µm	high	yellow	6-F 5	<b>0 580 043</b>			
	6 µm	extra high	yellow	6-F 7	<b>0 580 044</b>			
	8 µm	medium	red	8-F 6	<b>0 580 045</b>			
	8 µm	high	red	8-F 8	<b>0 580 046</b>			
	14 µm	medium	brown	14-F 6	<b>0 580 048</b>			
	14 µm	high	brown	14-F 8	<b>0 580 049</b>			
	14 µm	extra high	brown	14-F 9	<b>0 580 050</b>			
	25 µm	medium	mahagony	25-F 6	<b>0 580 051</b>			
	25 µm	high	mahagony	25-F 8	<b>0 580 052</b>			
	45 µm	medium	purple	45-F 6	<b>0 580 054</b>			
	45 µm	high	purple	45-F 8	<b>0 580 055</b>			
60 µm	extra high	orange	60-F 9	<b>0 580 057</b>				

## 2 Diamond compounds Hyprez® OS oil soluble

This oil-based compound is ideal for all uses that require a high level of stock removal.

Content	Grit size	Concentration	Colour	Type	Order No.	Price from		
						1 piece	3 pieces	6 pieces
<b>Diamond compounds Hyprez® OS, oil soluble</b>								
5 g 	1 µm	high	blue	1-OS 3	<b>0 580 206</b>			
	1 µm	extra high	blue	1-OS 4	<b>0 580 207</b>			
	3 µm	medium	green	3-OS 3	<b>0 580 209</b>			
	3 µm	high	green	3-OS 4	<b>0 580 210</b>			
	3 µm	extra high	green	3-OS 6	<b>0 580 211</b>			
	6 µm	medium	yellow	6-OS 4	<b>0 580 212</b>			
	6 µm	high	yellow	6-OS 5	<b>0 580 213</b>			
	6 µm	extra high	yellow	6-OS 7	<b>0 580 214</b>			
	8 µm	medium	red	8-OS 6	<b>0 580 215</b>			
	8 µm	high	red	8-OS 8	<b>0 580 216</b>			
	8 µm	extra high	red	8-OS 9	<b>0 580 217</b>			
	14 µm	medium	brown	14-OS 6	<b>0 580 218</b>			
	14 µm	high	brown	14-OS 8	<b>0 580 219</b>			
	14 µm	extra high	brown	14-OS 9	<b>0 580 220</b>			
	25 µm	medium	mahogany	25-OS 6	<b>0 580 221</b>			
	25 µm	high	mahogany	25-OS 8	<b>0 580 222</b>			
	25 µm	extra high	mahogany	25-OS 9	<b>0 580 223</b>			
	45 µm	medium	purple	45-OS 6	<b>0 580 224</b>			
	45 µm	extra high	purple	45-OS 9	<b>0 580 226</b>			
10 g 	1 µm	high	blue	1-OS 3	<b>0 580 236</b>			
	1 µm	extra high	blue	1-OS 4	<b>0 580 237</b>			
	3 µm	medium	green	3-OS 3	<b>0 580 239</b>			
	3 µm	high	green	3-OS 4	<b>0 580 240</b>			
	3 µm	extra high	green	3-OS 6	<b>0 580 241</b>			
	6 µm	medium	yellow	6-OS 4	<b>0 580 242</b>			
	6 µm	high	yellow	6-OS 5	<b>0 580 243</b>			
	6 µm	extra high	yellow	6-OS 7	<b>0 580 244</b>			
	8 µm	medium	red	8-OS 6	<b>0 580 245</b>			
	8 µm	high	red	8-OS 8	<b>0 580 246</b>			
	8 µm	extra high	red	8-OS 9	<b>0 580 247</b>			
	14 µm	medium	brown	14-OS 6	<b>0 580 248</b>			
	14 µm	high	brown	14-OS 8	<b>0 580 249</b>			
	14 µm	extra high	brown	14-OS 9	<b>0 580 250</b>			
	25 µm	medium	mahogany	25-OS 6	<b>0 580 251</b>			
	25 µm	high	mahogany	25-OS 8	<b>0 580 252</b>			
	25 µm	extra high	mahogany	25-OS 9	<b>0 580 253</b>			
	45 µm	medium	purple	45-OS 6	<b>0 580 254</b>			
	45 µm	extra high	purple	45-OS 9	<b>0 580 256</b>			

## Diamond compounds Hyprez® S oil and water soluble

2

This compound consists of "Advanced Technology" diamonds which are used in more economical doses than F series compounds, for example. They are ideal for simple, economical uses.

	Content	Grit size	Concentration	Colour	Order No.	Price from		
						1 piece	3 pieces	6 pieces
	<b>Diamond compounds Hyprez® S, oil and water soluble</b>							
	10 g	1 µm	medium	blue	<b>0 580 381</b>			
		3 µm	medium	green	<b>0 580 382</b>			
		6 µm	medium	yellow	<b>0 580 383</b>			
		8 µm	medium	red	<b>0 580 384</b>			
		14 µm	medium	brown	<b>0 580 385</b>			
		25 µm	medium	mahagony	<b>0 580 386</b>			
		45 µm	medium	purple	<b>0 580 387</b>			
	20 g	1 µm	medium	blue	<b>0 580 391</b>			
		3 µm	medium	green	<b>0 580 392</b>			
		6 µm	medium	yellow	<b>0 580 393</b>			
		8 µm	medium	red	<b>0 580 394</b>			
		14 µm	medium	brown	<b>0 580 395</b>			
		25 µm	medium	mahagony	<b>0 580 396</b>			
45 µm		medium	purple	<b>0 580 397</b>				

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## Diamond compounds Hyprez® W water soluble

The compound for environmentally friendly and oil-sensitive jobs. It is water soluble and contains exclusively natural diamonds.

	Content	Grit size	Concentration	Colour	Type	Order No.	Price from		
							1 piece	3 pieces	6 pieces
	<b>Diamond compounds Hyprez® W, water soluble</b>								
	5 g	1 µm	high	blue	1-W 3	<b>0 580 106</b>			
		1 µm	extra high	blue	1-W 4	<b>0 580 107</b>			
		3 µm	medium	green	3-W 3	<b>0 580 109</b>			
		3 µm	extra high	green	3-W 6	<b>0 580 111</b>			
		6 µm	low	yellow	6-W 4	<b>0 580 112</b>			
		6 µm	extra high	yellow	6-W 7	<b>0 580 114</b>			
		14 µm	medium	brown	14-W 6	<b>0 580 118</b>			
		10 g	1 µm	high	blue	1-W 3	<b>0 580 136</b>		
	1 µm		extra high	blue	1-W 4	<b>0 580 137</b>			
	3 µm		medium	green	3-W 3	<b>0 580 139</b>			
	3 µm		extra high	green	3-W 6	<b>0 580 141</b>			
	6 µm		low	yellow	6-W 4	<b>0 580 142</b>			
	6 µm		extra high	yellow	6-W 7	<b>0 580 144</b>			
		14 µm	medium	brown	14-W 6	<b>0 580 148</b>			


## 2 Diamond compounds Hyprez® SC-HT oil soluble - up to 250 °C

Newly developed diamond compound with quick-cutting, sharp-cutting diamond particles for rapid, high stock removal. The diamond particles are embedded in an innovative carrier with excellent sliding characteristics and extremely high temperature resistance. Workpieces with a surface temperature of up to max. 250 °C can easily be processed with this compound without the compound melting.

Content	Grit size	Concentration	Colour	Order No.	Price from		
					1 piece	3 pieces	6 pieces
<b>Diamond compounds Hyprez® SC-HT, oil soluble</b>							
 5 g	1 µm	extra high	white	<b>0 580 270</b>			
	3 µm	extra high	yellow	<b>0 580 271</b>			
	6 µm	extra high	orange	<b>0 580 272</b>			
	9 µm	extra high	green	<b>0 580 273</b>			
	20 µm	extra high	blue	<b>0 580 274</b>			
	30 µm	extra high	red	<b>0 580 275</b>			
	45 µm	extra high	brown	<b>0 580 276</b>			
	60 µm	extra high	black	<b>0 580 277</b>			

## Diamond compounds Hyprez® C11 water soluble

Especially for difficult applications on hot moulds or standing walls. The uneven surfaces of high-strength diamond grits ensure a high level of material removal, even in difficult situations.

Content	Grit size	Concentration	Colour	Type	Order No.	Price from		
						1 piece	3 pieces	6 pieces
<b>Diamond compounds Hyprez® C11, water soluble</b>								
 5 g	1 µm	high	light yellow	1-C 11	<b>0 580 701</b>			
	3 µm	high	yellow	3-C 11	<b>0 580 702</b>			
	6 µm	high	ochre	6-C 11	<b>0 580 703</b>			
	14 µm	high	light blue	14-C 11	<b>0 580 704</b>			
	25 µm	high	red	25-C 11	<b>0 580 705</b>			
	45 µm	high	brown	45-C 11	<b>0 580 706</b>			
20 g	1 µm	high	light yellow	1-C 11	<b>0 580 711</b>			
	3 µm	high	yellow	3-C 11	<b>0 580 712</b>			
	6 µm	high	ochre	6-C 11	<b>0 580 713</b>			
	14 µm	high	light blue	14-C 11	<b>0 580 714</b>			
	25 µm	high	red	25-C 11	<b>0 580 715</b>			

## Diamond compounds Hyprez® Super-L oil soluble

Very fine grits and extremely stable diamonds for final finishing of tungsten, ceramics and powder metallurgic steels.

Content	Grit size	Concentration	Order No.	Price from		
				1 piece	3 pieces	6 pieces
<b>Diamond compounds Hyprez® Super L, oil soluble</b>						
5 g	0.10 µm	high	<b>0 580 260</b>			
	0.25 µm	high	<b>0 580 261</b>			
	0.75 µm	high	<b>0 580 262</b>			
	1 µm	high	<b>0 580 263</b>			
	2 µm	high	<b>0 580 264</b>			
	3 µm	high	<b>0 580 265</b>			



## Diamond compounds Hyprez® L oil soluble

Hyprez® L compound was developed for particularly hard materials. It is oil soluble and the best choice for treating tungsten carbide, ceramics, hardened and powder metalurgic steels. 5 g in Hyplicator® or 10 g spray.


Content	Grit size	Concentration	Colour	Type	Order No.	Price from		
						1 piece	3 pieces	6 pieces
<b>Diamond compounds Hyprez® L, oil soluble</b>								
5 g	1 µm	extra high	blue	1-L 2	<b>0 580 302</b>			
	3 µm	high	green	3-L 3	<b>0 580 304</b>			
	6 µm	high	yellow	6-L 4	<b>0 580 306</b>			
	14 µm	medium	brown	14-L 3	<b>0 580 309</b>			
	14 µm	high	brown	14-L 5	<b>0 580 310</b>			
	25 µm	medium	mahagony	25-L 4	<b>0 580 311</b>			
	25 µm	high	mahagony	25-L 6	<b>0 580 312</b>			
	45 µm	medium	purple	45-L 4	<b>0 580 313</b>			
	45 µm	high	purple	45-L 5	<b>0 580 314</b>			
	60 µm	high	orange	60-L 6	<b>0 580 316</b>			
10 g	1 µm	extra high	blue	1-L 2	<b>0 580 322</b>			
	3 µm	high	green	3-L 3	<b>0 580 324</b>			
	6 µm	high	yellow	6-L 4	<b>0 580 326</b>			
	14 µm	medium	brown	14-L 3	<b>0 580 329</b>			
	14 µm	high	brown	14-L 5	<b>0 580 330</b>			
	25 µm	medium	mahagony	25-L 4	<b>0 580 331</b>			
	25 µm	high	mahagony	25-L 6	<b>0 580 332</b>			
	45 µm	medium	purple	45-L 4	<b>0 580 333</b>			
	45 µm	high	purple	45-L 5	<b>0 580 334</b>			
	60 µm	high	orange	60-L 6	<b>0 580 336</b>			






## 2 Diamond fluids Hyprez® OS oil soluble

Thinner for all oil soluble diamond compounds Hyprez®

	Content	Type	Order No.	Price from 1 piece
<b>Diamond fluid Hyprez® OS, oil soluble</b>				
	1 litre	OS	<b>0 580 504</b>	
	2 litres	OS	<b>0 580 507</b>	
	5 litres	OS	<b>0 580 510</b>	

## Diamond fluids Hyprez® W water soluble

Thinner for all water soluble diamond compounds Hyprez®

	Content	Type	Order No.	Price from 1 piece
<b>Diamond fluid Hyprez® W, water soluble</b>				
	1 litre	W	<b>0 580 505</b>	
	2 litre	W	<b>0 580 508</b>	

### Accessories / spare parts


	Order No.	Price from 1 piece
<b>Pump spray bottle, 250 ml</b>	<b>0 580 455</b>	
<b>Spray bottle, 100 ml</b>	<b>0 580 515-2</b>	



## Diamond gels Hyprez®


Hyprez® diamond gels combine the advantages of diamond compounds and diamond emulsions in one efficient product – ideal for polishing large surface areas. They work in the conventional way but need no additional fluid or other substances. The gel retains its viscosity even for longer periods. The diamond grits are always uniformly distributed. The practical dispensing bottle is simple to use and enables economical dosing. Please be careful not to apply too much diamond gel - one drop is generally enough for the entire surface to be polished.

**Tip: to thoroughly clean the tool after polishing, we recommend X 73016-A cleaner.**

	Content	Grit size	Colour	Type	Order No.	Price from	
						1 piece	5 pieces
<b>Diamond gels Hyprez®</b>							
	20 g	1 µm	red	HYG 450	<b>0 580 371</b>		
		3 µm	yellow	HYG 430	<b>0 580 372</b>		
		6 µm	yellow	HYG 420	<b>0 580 373</b>		
		8 µm	green	HYG 410	<b>0 580 374</b>		
		15 µm	blue	HYG 320	<b>0 580 375</b>		
		30 µm	blue	HYG 310	<b>0 580 376</b>		
		45 µm	blue	HYG 300	<b>0 580 377</b>		


## Diamond sprays Hyprez®

For efficient, economic polishing and lapping of large surfaces as well as impregnating polishing cloths and plates. The solvent contained in the diamond spray ensures the even distribution of diamond grits. Diamond particles do not clump together, which guarantees the full cutting power of every individual particle.

	Content	Grit size	Order No.	Price from	
				1 piece	5 pieces
<b>Diamond spray Hyprez®</b>					
	75 g	0.10 µm	<b>0 580 361</b>		
		0.25 µm	<b>0 580 362</b>		
		1 µm	<b>0 580 363</b>		
		3 µm	<b>0 580 364</b>		
		6 µm	<b>0 580 365</b>		
		8 µm	<b>0 580 366</b>		
		14 µm	<b>0 580 367</b>		
		25 µm	<b>0 580 368</b>		
		45 µm	<b>0 580 369</b>		


## 2 Polishing compounds Dialux

Ranging from “normal” polishing to superfinishing. The right compound for every application. Owing to the very good adhesive properties, the Dialux polishing compounds are perfectly suited to work with polishing felts and brushes.

	Content	Colour	Order No.	Price from		
				1 piece	5 pieces	10 pieces
<b>Polishing compounds Dialux</b>						
	for polishing metals, chromium etc.	140 g	green	<b>0 580 560</b>		
	high-gloss polishing for all metals	125 g	white	<b>0 580 561</b>		
	for super-finishing of all metals	120 g	blue	<b>0 580 562</b>		
	for eliminating scratches and streaks (high-gloss polish white is additionally required for this purpose)	145 g	orange	<b>0 580 563</b>		
	for refreshing stainless steels	125 g	grey	<b>0 580 564</b>		
	for polishing or refreshing non-ferrous metals and aluminium	110 g	yellow	<b>0 580 565</b>		
	Polishing compound type 462 – without particles of animal origin • Specially designed for use in the food and chemical industry!	700 g	blue	<b>0 580 566</b>		


## Polishing compounds Dipo

The “classic” product uses corundum as abrasive for polishing unhardened steels and aluminium. Available as a tube (50 ml) or in the large canister (1,000 ml).

	Content	Grit size	Order No.	Price from	
				1 piece	25 pieces
<b>Lapping and polishing compounds Dipo</b>					
	50 ml tube	5 - 8 µm, very fine	<b>0 580 571</b>		
		10 - 15 µm, fine	<b>0 580 572</b>		
		30 - 50 µm, coarse	<b>0 580 573</b>		
		80 - 100 µm, very coarse	<b>0 580 574</b>		
	1,000 ml can	5 - 8 µm, very fine	<b>0 580 575</b>		
		10 - 15 µm, fine	<b>0 580 576</b>		
		30 - 50 µm, coarse	<b>0 580 577</b>		
		80 - 100 µm, very coarse	<b>0 580 578</b>		

## Marking compounds


For controlling surfaces. The parts to be controlled are covered in marking compound after processing. The movement of components on a surface plate or against each other results in a colour layer, which provides information regarding the surface quality. Can be easily removed with a cleaning agent.

	Content	Colour	Order No.	Price from 1 piece
<b>Marking compounds</b>				
<b>heat resistant up to 60 °C</b>				
	60 g tube	blue	<b>0 202 252</b>	
	225 g can	blue	<b>0 202 251-1</b>	

<b>heat resistant up to 200 °C</b>				
	60 g tube	blue	<b>0 202 255</b>	
	225 g can	blue	<b>0 202 257-1</b>	

## Special grinding compounds

For fine grinding, lapping and dressing work. Also suitable for plastics. The paste with SiC abrasive can be diluted and removed with oil, petroleum or petroleum spirit.

	Content	Grit size	Order No.	Price from 1 piece
<b>Special grinding compounds</b>				
	220 ml can	8 - 11 µm, very fine	<b>0 580 581-1</b>	
		16 - 20 µm, fine	<b>0 580 582-1</b>	
		27 - 31 µm, medium fine	<b>0 580 583-1</b>	
		42 - 47 µm, medium	<b>0 580 584-1</b>	
		88 - 105 µm, very coarse	<b>0 580 586-1</b>	

## 2 Polishing compounds

### Elsterglanz polishing compound

Original Elsterglanz safely cleans, polishes and preserves surfaces of different materials. Elsterglanz is non-corrosive, acidfree and completely material-friendly. Special ingredients have a water-repellant and preserving effect, thereby providing long-lasting protection against tarnishing and resoiling.

	Content	Application	Order No.	Price from	
				1 piece	10 pieces
<b>Elsterglanz polishing compound</b>					
	150 ml tube	Universal, particularly for stainless steels	<b>0 580 630</b>		
		Copper, brass, bronze	<b>0 580 631</b>		



## Polishing compounds

### Simichrome polishing compound

Suitable for almost all metals such as stainless steel, chrome, copper, tin, aluminium, brass, magnesium, gold and silver.

- Extremely fine metal polish
- Removes small scratches and aging layers
- Leaves an absolutely tremendous shine
- Additionally forms an ultrafine and lasting protective film



	Content	Order No.	Price from
			1 piece
<b>Simichrome polishing compound</b>			
	50 g tube	<b>0 580 638-1</b>	
	250 g can	<b>0 580 642-1</b>	



## Polishing compounds

### Polishing compound Dur-Plastic-Polish


Care from a tube for all ungrained hard plastics. Returns clarity to dull Plexiglas and Macrolon panes and creates a shine on polyester and Plexiglas products. In paste form; use undiluted with a soft cloth.

	Content	Order No.	Price from 1 piece
<b>Dur-Plastic-Polish</b>			
 	125 ml tube	<b>0 960 024-1</b>	
	1,000 ml can	<b>0 960 014</b>	

## Polishing compounds

### Polishing medium METAREX


A polishing medium consisting of impregnated cotton for use on metals. Very well suited for repolishing PET bottle moulds. Gently eliminates everything that may have accumulated on the material (rust, verdigris, sulphide and oxide blackening) gently without leaving traces (scratches, white residues). Protects against premature oxidation.

	Content	Suitable for materials	Order No.	Price from 1 piece
<b>Polishing medium METAREX</b>				
	100 g can	Metal	<b>0 960 028</b>	
	200 g can	Metal	<b>0 960 029</b>	



## 2 Polishing pad Micro-Mesh® ideal for small polishing work

The polishing pads are the ideal partner for minor repairs and polishing work on smaller workpieces. The abrasive is applied on both sides and a larger surface area of the grinding points is achieved by the flexible carrier. The pads can be used wet or dry. Also very good for processing aluminium; an appropriate cooling fluid should be used in this case and the processing speed should be reduced.

	Dimensions	Grit size	Design	Packing quantity	Order No.	Price from		
						1 piece	30 pieces	50 pieces
<b>Polishing pads Micro-Mesh®, Ultra-Flex</b>								
	50 x 50 mm	60	Ultra-Flex	10 pieces	<b>0 402 091</b>			
		80	Ultra-Flex	10 pieces	<b>0 402 092</b>			
		100	Ultra-Flex	10 pieces	<b>0 402 093</b>			
		120	Ultra-Flex	10 pieces	<b>0 402 094</b>			
		150	Ultra-Flex	10 pieces	<b>0 402 095</b>			
		180	Ultra-Flex	10 pieces	<b>0 402 096</b>			
		240	Ultra-Flex	10 pieces	<b>0 402 097</b>			
		320	Ultra-Flex	10 pieces	<b>0 402 098</b>			
		360	Ultra-Flex	10 pieces	<b>0 402 099</b>			
		400	Ultra-Flex	10 pieces	<b>0 402 100</b>			
		600	Ultra-Flex	10 pieces	<b>0 402 101</b>			
		800	Ultra-Flex	10 pieces	<b>0 402 102</b>			
		1200	Ultra-Flex	10 pieces	<b>0 402 103</b>			

### ↓ matching set

	Dimensions	Content	Order No.	Price from	
				1 set	3 set
<b>Polishing pad set Micro-Mesh®, Ultra-Flex</b>					
	50 x 50 mm	13 pads	<b>0 402 090</b>		



#### Know-how!

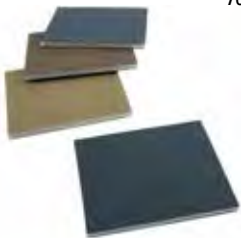
60 MX corresponds to approx. grit size P 240

#### Material

60 MX – 600 MX = SiC

800 MX – 1200 MX = corundum

## Polishing pad Micro-Mesh® ideal for small polishing work

Dimensions	Grit size	Design	Packing quantity	Order No.	Price from		
					1 pieces	30 pieces	50 pieces
<b>Polishing pads Micro-Mesh®, Ultra-Flex</b>							
 76 x 102 mm	60	Ultra-Flex	10 pieces	<b>0 402 065</b>			
	80	Ultra-Flex	10 pieces	<b>0 402 066</b>			
	100	Ultra-Flex	10 pieces	<b>0 402 067</b>			
	120	Ultra-Flex	10 pieces	<b>0 402 068</b>			
	150	Ultra-Flex	10 pieces	<b>0 402 069</b>			
	180	Ultra-Flex	10 pieces	<b>0 402 070</b>			
	240	Ultra-Flex	10 pieces	<b>0 402 071</b>			
	320	Ultra-Flex	10 pieces	<b>0 402 072</b>			
	360	Ultra-Flex	10 pieces	<b>0 402 073</b>			
	400	Ultra-Flex	10 pieces	<b>0 402 075</b>			
	600	Ultra-Flex	10 pieces	<b>0 402 076</b>			
	800	Ultra-Flex	10 pieces	<b>0 402 077</b>			
	1200	Ultra-Flex	10 pieces	<b>0 402 078</b>			

## Schmitzol's Wiener Kalk

Look it up in a German dictionary and you will find that the German word "Wienern" means polishing, buffing and raising a shine. That is what this original has been producing for more than 125 years: brilliance. Excellent for caring for and cleaning stainless steel, chrome, brass, copper, nickel, gold, silver, aluminium, glass, varnish and plastic. Even tiles, baths, washbasins and hobs are given a shine. Wiener Kalk is very well suited for cleaning moulds polished with up to 6 µm diamond. As a pure natural product, it is completely free of organic substances, phosphates and heavy metals. It does not contain any lime (Kalk) either; the name has merely grown up historically over the years.

Schmitzol's Wiener Kalk	Content	Order No.	Price from
			1 piece
	125 g can	<b>0 960 020</b>	



## 2 Quator polishing medium

Cotton wool balls for gentle polishing of aluminium, metal and plastic. The cotton wool is impregnated with a polishing medium and can be plucked piecewise from the ball. This allows very economical use, all the more so in that the individual pieces can easily be reused several times (keep in a bag after use!).

A deep gloss can be achieved on all materials with this cotton wool - perfect for cleaning and raising a shine. Furthermore, the surface is slightly sealed, which protects against water droplets and corrosion.

Content	Type	Colour	Suitable for materials	Order No.	Price from 1 piece
<b>Quator polishing medium</b>					
250 g can	A	pink	Aluminium	<b>0 960 025</b>	
	M	blue	Metal	<b>0 960 026</b>	
	MPT	white	Plastic	<b>0 960 027</b>	



## Polishing wool

If it is good for human skin, it cannot fail to be right for technical surfaces. Cotton wool is a universal cleaning aid. A choice between cotton and viscose (rayon) in addition to a "50/50 blend" of both is available. Rayon very rapidly absorbs liquid, whereas cotton stores it longer and offers better cohesion of the fibres. Cotton wool pads (100 % cotton) are available in addition to the loose cotton wool balls.

Design	Material	Content	Packing quantity	Order No.	Price from 1 pack
<b>Polishing wool</b>					
Cotton wool	50 % viscose / 50 % cotton	100 g in the bag		<b>0 960 010</b>	
	100 % cotton	100 g in the bag		<b>0 960 011</b>	
	100 % viscose	1000 g in the bag		<b>0 960 013-5</b>	
Cotton wool pads	100 % cotton	40 pieces in the bag	40 pieces	<b>0 960 015</b>	



## Polishing cloths Kleenex



High quality 3-ply cloth for wiping after polishing and for applying joke Magic very fine polishing suspension (similar illustration).

Design	Content	Colour	Dimensions	Order No.	Price from 1 piece
<b>Polishing cloths Kleenex</b>					
3 layers	72 cloths	white	20 x 20 cm	<b>0 590 602</b>	



## Cleaning wires **2**

Flexible and firm at the same time. Particularly suitable for detaching and removing simple soiling in the drilling holes. Trimming made of soft cotton, with and without incorporated bristles (for maximum cleaning power). The wires are resistant against cleaning media and can be used both wet and dry. Available in long (150 mm) and longer (300 mm), conically wound respectively.

	Material	Dimensions	Packing quantity	Order No.	Price from 1 pack
<b>Cleaning wires</b>					
	Cotton wool without bristles	Ø 4/5 x 150 mm	80 pieces	<b>0 960 005</b>	
	Cotton wool with bristles	Ø 4/5 x 150 mm	80 pieces	<b>0 960 006</b>	
		Ø 3.5/5.5 x 300 mm	50 pieces	<b>0 960 007</b>	



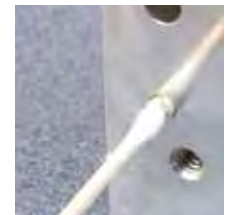
Cotton wool without bristles




Cotton wool with bristles

## Cotton buds

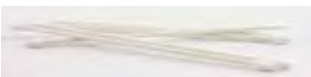
Familiar in principle to any child. The joke cotton buds have a very dense and firm cotton wool head trimming (small and large version available). With their long wooden shanks, they are markedly superior to PP sticks, since more rigid and resistant to cleaners. Furthermore, their diameter also fits in the collets of our handpieces. Use wet or dry for cleaning and with compound for polishing.



	Design	Dimensions	Packing quantity	Order No.	Price from 1 pack
<b>Cotton buds on wooden sticks</b>					
	small head (Ø approx. 4 – 5.5 mm)	Ø 2.3 x 150 mm	100 pieces	<b>0 960 001</b>	
	large head (Ø approx. 10 – 12 mm)	Ø 3 x 200 mm	50 pieces	<b>0 960 002</b>	

## Cleaning stick

The lint-free cleaning sticks are highly absorbent and owing to their pointed shape, ideal for use in model and mould making as well as in areas such as optics, laser and microtechnology. The rods have a very dense and firm head made of highest-quality cotton. They are therefore super absorbent, suitable for solvents and retain their shape when wet. Perfect for all cleaning tasks in hard-to-reach areas or for precise application of liquids (e. g. adhesives, resins, alcohols).

		Packing quantity	Order No.	Price from 1 pack
<b>Cleaning stick</b>				
	Sharp head on both sides, Ø 5 x 13 mm, hard, head and stick made of cotton	100 pieces	<b>0 960 003</b>	

# Felts and cloths

Our polishing felt selection is the result of long, practical experience. All common shapes, dimensions and grades of hardness are available. Joke polishing felts are distinguished both by the high stability and outstanding elasticity of their material. In order to no need for new paragraph results at all times, they should always be used in conjunction with Magic and/or Hyprez® diamond compounds available from Joke. Polishing felts from our company enable you to polish safely, cleanly and efficiently even the most complicated moulds, such as die-casting and injection moulds, cutting tools, dies etc.

**Shank-Ø:**

- Ø 2.35 x 40 mm
- Ø 3 x 40 mm
- Ø 6 x 40 mm

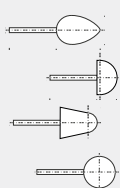
**Hardness grades:**

Soft: felt on its own without any impregnation (< 0.65 g/cm³ density)

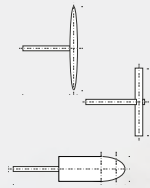
Standard: light impregnation means greater stability (< 0.65 g/cm³ density)

Super-hard: total shape stability due to special, additional impregnation (0.65 g/cm³ density)

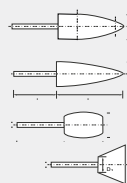
**15 different shapes:**



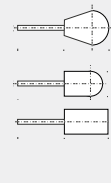
- Pear
- Halfround
- Cone
- Sphere



- Lens
- Wheel
- Rings
- Tree



- Tree with pointed end
- Pointed cone
- Barrel
- Trapezium



- Drop
- Rounded cylinder
- Cylinder

**145 Polishing felts with shank**

**152 Felt lamellas on shank**

**149 Polishing felt rings and lenses**












**153 Felt sticks • Felt sheets**



# Polishing felts









## shank Ø 2.35 x 40 mm

2



	Head dimensions	Hardness	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from	
							1 pieces	50 pieces
<b>Polishing felts, shank Ø 2.35 x 40 mm</b>								
<b>cylinder</b>								
	Ø 4 x 10 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 107</b>		
	Ø 4 x 12 mm	super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 494</b>		
	Ø 8 x 12 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 105</b>		
<b>sphere</b>								
	Ø 6 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 104</b>		
<b>pointed cone</b>								
	Ø 6 x 18 mm	super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 490</b>		
	Ø 7 x 15 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 109</b>		
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 451</b>		
<b>pear</b>								
	Ø 8 x 11 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 114</b>		
	Ø 9 x 13 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 110</b>		
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 452</b>		
<b>cone</b>								
	Ø 7 x 15 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 116</b>		
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 454</b>		
<b>lens</b>								
	Ø 17 x 5 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 121</b>		
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 458</b>		
	Ø 22 x 5 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 120</b>		
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 457</b>		
<b>wheel</b>								
	Ø 17 x 5 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 119</b>		
	Ø 22 x 5 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 118</b>		
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 456</b>		
<b>barrel</b>								
	Ø 8 x 11 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 112</b>		
	Ø 9 x 13 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 111</b>		
<b>trapeze</b>								
	Ø 12 / 8 x 12 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 117</b>		
		super-hard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 455</b>		
<b>drop</b>								
	Ø 8 x 11 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 115</b>		
	Ø 9 x 13 mm	standard	Ø 2.35 x 40 mm	10 m/s	10 pieces	<b>0 570 113</b>		



## 2 Polishing felts shank Ø 3 x 40 mm

	Head dimensions	Hardness	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from	
							1 pieces	50 pieces
<b>Polishing felts, shank Ø 3 x 40 mm</b>								
<b>cylinder</b>								
	♣ Ø 6 x 10 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 301</b>		
	♣ Ø 6 x 10 mm	super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 461</b>		
	♣ Ø 6 x 10 mm	soft	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 315</b>		
	♣ Ø 6 x 13 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 322</b>		
	♣ Ø 8 x 10 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 302</b>		
	♣ Ø 8 x 10 mm	super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 462</b>		
	♣ Ø 8 x 12 mm	soft	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 317</b>		
	♣ Ø 10 x 10 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 303</b>		
	♣ Ø 10 x 10 mm	super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 463</b>		
	♣ Ø 10 x 12 mm	soft	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 319</b>		
	♣ Ø 10 x 13 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 323</b>		
	♣ Ø 10 x 15 mm	soft	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 320</b>		
	♣ Ø 10 x 20 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 354</b>		
	♣ Ø 13 x 20 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 324</b>		
	♣ Ø 15 x 20 mm	standard	Ø 3 x 30 mm	10 m/s	10 pieces	<b>0 570 355</b>		
	♣ Ø 15 x 32 mm	soft	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 347</b>		
	♣ Ø 16 x 30 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 325</b>		
	♣ Ø 20 x 20 mm	soft	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 498</b>		
♣ Ø 20 x 40 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 326</b>			
<b>rounded cylinder</b>								
	♣ Ø 6 x 10 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 312</b>		
	♣ Ø 8 x 12 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 313</b>		
<b>sphere</b>								
	♣ Ø 6 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 356</b>		
	♣ Ø 8 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 357</b>		
	♣ Ø 10 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 358</b>		
	♣ Ø 12 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 359</b>		
<b>pointed cone</b>								
	♣ Ø 6 x 18 mm	super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 328</b>		
	♣ Ø 7 x 16 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 327</b>		
	♣ Ø 10 x 18 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 304</b>		
<b>lens</b>								
	♣ Ø 21 x 4 mm	super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 459</b>		
<b>wheel</b>								
	♣ Ø 21 x 4 mm	standard	Ø 3 x 37 mm	10 m/s	10 pieces	<b>0 570 489</b>		
<b>rounded arch</b>								
	♣ Ø 6 x 10 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 308</b>		
	♣ Ø 6 x 10 mm	super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 466</b>		
	♣ Ø 8 x 12 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 311</b>		
<b>tree with pointed end</b>								
	♣ Ø 6 x 10 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 310</b>		
	♣ Ø 7 x 15 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 314</b>		
	♣ Ø 8 x 12 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 309</b>		
	♣ Ø 8 x 12 mm	super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 465</b>		

## Polishing felts shank Ø 3 x 40 mm

	Head dimensions	Hardness	Shank dimensions	Cutting speed max.	Packing quantity	Order No.	Price from	
							1 pieces	50 pieces
<b>trapeze</b>								
	Ø 9 / 6 x 15 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 491</b>		
	Ø 10 / 7 x 15 mm	super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 469</b>		
	Ø 15 / 10 x 15 mm	soft	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 321</b>		
	☒ Ø 15 / 10 x 15 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 305</b>		
	Ø 15 / 10 x 15 mm	super-hard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 464</b>		
<b>drop</b>								
	☒ Ø 6 x 10 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 306</b>		
	☒ Ø 8 x 12 mm	standard	Ø 3 x 40 mm	10 m/s	10 pieces	<b>0 570 307</b>		

### matching set



	Order No.	Price from	
		1 set	
<b>Set Polishing felts, shank Ø 3 x 40 mm</b>			
☒ Content: 14 pieces contains the marked felts from the table above		<b>0 570 300</b>	

### Accessories / spare parts


**NEW!**

	Order No.	Price from	
		1 piece	5 pieces
<b>Extension for shank tools</b>			
Shank Ø 3 mm, receptacle Ø 3 mm, 75 mm long	<b>0 571 650</b>		
Shank Ø 6 mm, receptacle Ø 3 mm, 105 mm long	<b>0 571 651</b>		
Shank Ø 8 mm, receptacle Ø 6 mm, 340 mm long	<b>0 571 652</b>		-




## Polishing felts with extra long shaft Ø 3 mm

**NEW!**

	Head dimensions	Hardness	Shank dimensions	Packing quantity	Order No.	Price from		
						1 pack	5 packs	10 packs
<b>Polishing felts, shank Ø 3 mm</b>								
<b>cylinder</b>								
	Ø 6 x 15 mm	hard	Ø 3 x 80 mm	5 pieces	<b>0 573 004</b>			
		soft	Ø 3 x 80 mm	5 pieces	<b>0 573 005</b>			
	Ø 6 x 15 mm	hard	Ø 3 x 80 mm	5 pieces	<b>0 573 006</b>			
		soft	Ø 3 x 80 mm	5 pieces	<b>0 573 007</b>			
	Ø 10 x 20 mm	hard	Ø 3 x 80 mm	5 pieces	<b>0 573 008</b>			
		soft	Ø 3 x 80 mm	5 pieces	<b>0 573 009</b>			
	Ø 6 x 15 mm	hard	Ø 3 x 80 mm	5 pieces	<b>0 573 010</b>			
		soft	Ø 3 x 80 mm	5 pieces	<b>0 573 011</b>			

## 2 Polishing felts

### shank Ø 6 x 40 mm

	Head dimensions	Hardness	Shank dimensions	Cutting speed max.	Order No.	Price from	
						1 piece	50 pieces
<b>Polishing felts, shank Ø 6 x 40 mm</b>							
<b>cylinder</b>							
	☒ Ø 10 x 12 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 331</b>		
	Ø 12 x 12 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 332</b>		
	☒ Ø 15 x 20 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 333</b>		
	Ø 15 x 20 mm	super-hard	Ø 6 x 40 mm	10 m/s	<b>0 570 471</b>		
	☒ Ø 15 x 30 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 334</b>		
	☒ Ø 20 x 20 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 335</b>		
	Ø 20 x 20 mm	super-hard	Ø 6 x 40 mm	10 m/s	<b>0 570 472</b>		
	☒ Ø 20 x 30 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 336</b>		
	Ø 25 x 30 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 337</b>		
	☒ Ø 30 x 35 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 338</b>		
	Ø 30 x 35 mm	super-hard	Ø 6 x 40 mm	10 m/s	<b>0 570 473</b>		
<b>sphere</b>							
	Ø 12 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 360</b>		
	Ø 20 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 362</b>		
<b>cone</b>							
	☒ Ø 20 x 30 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 339</b>		
	Ø 20 x 30 mm	super-hard	Ø 6 x 40 mm	10 m/s	<b>0 570 474</b>		
<b>rounded arch</b>							
	☒ Ø 15 x 20 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 340</b>		
	Ø 15 x 20 mm	super-hard	Ø 6 x 40 mm	10 m/s	<b>0 570 475</b>		
<b>tree, XL</b>							
	☒ Ø 20 x 70 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 342</b>		
<b>trapeze</b>							
	Ø 30 / 22 x 25 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 493</b>		
<b>halfround</b>							
	☒ Ø 30 x 20 mm	standard	Ø 6 x 40 mm	10 m/s	<b>0 570 341</b>		



#### Other polishing felts on request!

We will also be pleased to supply polishing felts in other shapes, hardnesses, head and shank dimensions. Please consult **Markus Abstoß**: Tel. +49 2204 839-0 | [m.abstoss@joke.de](mailto:m.abstoss@joke.de)

## Polishing felts shank Ø 6 x 40 mm

↓ matching set

	Order No.	Price from 1 set
<b>Set of polishing felts, shank Ø 6 x 40 mm</b>		
Content: 12 pieces contains the marked felts from the table above	<b>0 570 330</b>	



## Polishing felts with extra long shaft

**NEW!**

	Head dimensions	Hardness	Shank dimensions	Packing quantity	Order No.	Price from		
						1 pack	5 packs	10 packs
<b>Polishing felts, shank Ø 6 mm</b>								
<b>cylinder</b>								
	Ø 10 x 20 mm	hard	Ø 6 x 100 mm	5 pieces	<b>0 573 000</b>			
		soft	Ø 6 x 100 mm	5 pieces	<b>0 573 001</b>			
	Ø 13 x 20 mm	hard	Ø 6 x 100 mm	5 pieces	<b>0 573 002</b>			
		soft	Ø 6 x 100 mm	5 pieces	<b>0 573 003</b>			





## Polishing felt rings

	Exterior Ø	Interior Ø	Height	Hardness	Cutting speed max.	Packing quantity	Order No.	Price from	
								1 pack	10 packs
<b>Polishing felt rings</b>									
<b>non-self-adhesive</b>									
	18 mm	7 mm	4 mm	standard	10 m/s	10 pieces	<b>0 570 412</b>		
	30 mm	12 mm	4 mm	standard	10 m/s	10 pieces	<b>0 570 414</b>		
	45 mm	18 mm	4 mm	standard	10 m/s	10 pieces	<b>0 570 415</b>		
<b>self-adhesive</b>									
	18 mm	7 mm	4 mm	standard	10 m/s	10 pieces	<b>0 570 422</b>		
	30 mm	12 mm	4 mm	standard	10 m/s	10 pieces	<b>0 570 424</b>		
	45 mm	18 mm	4 mm	standard	10 m/s	10 pieces	<b>0 570 425</b>		


## 2 Polishing felts rings • lenses • holders


### Magic polishing felts – with barrier layer

A newly developed special impregnation technique ensures you get the best polishing results when using Magic polishing felts. It means you to get less moisture absorption than with normal felts, which enables the diamonds to provide their best cutting performance. joke Magic polishing felts have a wavy surface and are not impregnated, yet they need up to 40% less diamond compound than normal felts. Their precise, smooth surface creates a rapid, even surface on the material being worked and consistently prevents dimpling. A barrier located on the rear side of the felts prevents the ingress of liquid adhesive whenever the felts are glued to the rubber holders. It also prevents the felts from being affected by the adhesive and the adhesive from softening due to the polish used on the felts.



	Dimensions	Hardness	Packing quantity	Order No.	Price from			
					1 piece	5 pieces	1 pack	5 packs
<b>Polishing felts joke Magic, non-self adhesive</b>								
	Ø 30 / 12 x 4 mm	standard	10 pieces	<b>0 590 501</b>	-	-		
	100 x 30 x 2 mm	standard	10 pieces	<b>0 590 502</b>	-	-		
	290 x 280 x 2 mm	standard	-	<b>0 411 370</b>			-	-

### Accessories / spare parts

	Order No.	Price from	
		1 piece	10 pieces
<b>Adhesive Pattex, 125 g tube</b>			
 for fixing polishing felt rings to rubber supports	<b>0 570 420-1</b>		

 <b>Hardness grades</b>	
Soft	0.48 g/cm <sup>3</sup>
Medium	0.56 g/cm <sup>3</sup>
Standard	0.64 g/cm <sup>3</sup>
Super-hard	0.64 g/cm <sup>3</sup> (with impregnation!)

## Felt sheets

	Dimensions	Hardness	Order No.	Price from	
				1 piece	5 pieces
<b>Felt sheets</b>					
	6 x 250 x 250 mm	soft	<b>0 411 341</b>		
		medium	<b>0 411 351</b>		
		standard	<b>0 411 361</b>		
	10 x 250 x 250 mm	soft	<b>0 411 342</b>		
		medium	<b>0 411 352</b>		
		standard	<b>0 411 362</b>		
	12 x 250 x 250 mm	medium	<b>0 411 353</b>		
		standard	<b>0 411 363</b>		
	25 x 250 x 250 mm	soft	<b>0 411 345</b>		
medium		<b>0 411 355</b>			
standard		<b>0 411 365</b>			
<b>Felt sheets, self-adhesive</b>					
	3 x 250 x 250 mm	standard	<b>0 411 368</b>		

## Polishing felts

### Polishing felt bodies

Dimensions	Hardness	Shank dimensions	Cutting speed max.	Order No.	Price from	
					1 piece	10 pieces
<b>Polishing felt bodies (rubber holders with attached felt ring)</b>						
Ø 18 mm	standard	Ø 3 x 26 mm	10 m/s	<b>0 570 403</b>		
Ø 30 mm	standard	Ø 3 x 26 mm	10 m/s	<b>0 570 404</b>		
Ø 45 mm	standard	Ø 6 x 32 mm	10 m/s	<b>0 570 405</b>		



## Polishing felt rolls

**NEW!**

Dimensions	Order No.	Price from	
		1 piece	5 pieces
<b>Polishing felt roll, 25 mm wide, 1500 mm</b>			
1 mm	<b>0 411 390</b>		
3 mm	<b>0 411 391</b>		

## Polishing felt lenses

Dimensions	Drilling dimension	Hardness	Suitable mounting shank	Cutting speed max.	Order No.	Price from	
						1 piece	50 pieces
<b>Polishing felt lenses</b>							
<b>without shank</b>							
Ø 13 x 4 mm	2 mm	standard	Type 21, 22, 23	10 m/s	<b>0 570 431</b>		
Ø 19 x 5 mm	2 mm	standard	Type 26, 27	10 m/s	<b>0 570 433</b>		
Ø 25 x 6 mm	2 mm	standard	Type 26, 27	10 m/s	<b>0 570 434</b>		
Ø 38 x 6 mm	2 mm	standard	Type 26, 27	10 m/s	<b>0 570 435</b>		
Ø 51 x 8 mm	6 mm	standard	Type 41	10 m/s	<b>0 570 436</b>		



### Accessories / spare parts

	for bore dimensions	Shank dimensions	Type	Max. disc size	Order No.	Price from	
						1 piece	10 pieces
<b>CRATEX® grinding wheel holder</b>							
	Ø 1.5 – 1.8 mm	Ø 2.35 x 40/28 mm	21	Ø 38 x 4.5 mm	<b>0 545 275</b>		
	Ø 1.5 – 1.8 mm	Ø 3 x 42 mm	22	Ø 38 x 4.5 mm	<b>0 545 276</b>		
	Ø 1.5 – 1.8 mm	Ø 6 x 42 mm	23	Ø 38 x 4.5 mm	<b>0 545 277</b>		
	Ø 1.5 – 1.8 mm	Ø 3 x 40 mm	26	Ø 25 x 8.5 mm	<b>0 545 280</b>		
	Ø 1.5 – 1.8 mm	Ø 6 x 40 mm	27	Ø 25 x 8.5 mm	<b>0 545 281</b>		
	Ø 6 mm	Ø 6 x 25 mm	41	Ø 75 x 9.5 mm	<b>0 545 282</b>		



## 2 Felt lamellas shank Ø 3 and 6 mm

### Felt lamellas


The main strength of these polishing felts is their elasticity. They fit perfectly onto the contours of the tool being used. In particular, their "slit shape" is a must-have for this type of work. Because these felts fit tool contours, you need less working pressure and that means less "scoring" on the workpiece. Essentially you just get better results. Ideal for use with jokeFlex Premium Plus or Power Motor Systems.

**Recommended speed: 3,000 – 6,000 rpm**


	Head dimensions	Hardness	Felt thickness	Shank dimensions	Cutting speed max.	Order No.	Price from	
							1 piece	10 pieces
<b>Felt lamellas on shank</b>								
<b>standard</b>								
	20 x 10 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	<b>0 411 701</b>		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 721</b>		
	20 x 20 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	<b>0 411 702</b>		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 722</b>		
	25 x 10 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	<b>0 411 703</b>		
	25 x 20 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	<b>0 411 704</b>		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 724</b>		
	25 x 30 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	<b>0 411 705</b>		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 725</b>		
	30 x 5 mm	H 40	3 mm	Ø 3 x 40 mm	10 m/s	<b>0 411 710</b>		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 712</b>		
	40 x 5 mm	H 40	3 mm	Ø 3 x 40 mm	10 m/s	<b>0 411 711</b>		
		H 40	3 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 713</b>		
	50 x 5 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 714</b>		
<b>slit</b>								
	30 x 10 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	<b>0 411 706</b>		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 726</b>		
	30 x 20 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	<b>0 411 707</b>		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 727</b>		
	30 x 30 mm	H 40	2 mm	Ø 3 x 40 mm	10 m/s	<b>0 411 708</b>		
		H 40	2 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 728</b>		
	40 x 10 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 733</b>		
	40 x 20 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 734</b>		
	40 x 30 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 735</b>		
	40 x 40 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 736</b>		
	50 x 20 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 741</b>		
	50 x 30 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 742</b>		
	50 x 40 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 743</b>		
	50 x 50 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 744</b>		
	60 x 40 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 751</b>		
	60 x 50 mm	H 40	3 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 752</b>		
	80 x 30 mm	H 40	5 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 765</b>		
	80 x 50 mm	H 40	5 mm	Ø 6 x 40 mm	10 m/s	<b>0 411 767</b>		

## Felt sticks

### Felt sticks without shank


	Dimensions	Hardness	Order No.	Price from	
				1 piece	10 pieces
<b>Felt sticks</b>					
<b>square</b>					
	6 x 6 x 150 mm	medium	<b>0 411 301</b>		
		standard	<b>0 411 304</b>		
	10 x 10 x 150 mm	medium	<b>0 411 302</b>		
		standard	<b>0 411 305</b>		
	12 x 12 x 150 mm	medium	<b>0 411 303</b>		
		standard	<b>0 411 306</b>		

 *matching set*

	Order No.	Price from
		1 set
<b>Assorted felt sticks</b>		
 Content: 18 felt sticks, three in each hardness and design	<b>0 411 300</b>	

## Felt sticks

### shank Ø 3.2 mm

	Dimensions	Hardness	Shank dimensions	Order No.	Price from	
					1 piece	10 pieces
<b>Felt sticks with shank, 30° slant</b>						
	6 x 6 x 37 mm	medium	Ø 3.2 x 30 mm	<b>0 411 321</b>		
		standard	Ø 3.2 x 30 mm	<b>0 411 324</b>		
		super-hard	Ø 3.2 x 30 mm	<b>0 411 327</b>		
10 x 10 x 45 mm		medium	Ø 3.2 x 30 mm	<b>0 411 322</b>		
		standard	Ø 3.2 x 30 mm	<b>0 411 325</b>		
12 x 12 x 45 mm		medium	Ø 3.2 x 30 mm	<b>0 411 323</b>		
		standard	Ø 3.2 x 30 mm	<b>0 411 326</b>		

 *matching set*

	Order No.	Price from
		1 set
<b>Assorted felt sticks with shank</b>		
 Content: 6 pieces	<b>0 411 320</b>	

# Lapping tools

**155** Lapping and polishing points made of wood

**157** Lapping sticks made of Plexiglas

**158** Lapping and polishing tools

**164** HELICAL LAP

Discover the entire range of abrasives and grinding tools.

Regardless of whether rotating on a shank, cap and sleeve-shaped, as belts, sheets, discs, emery papers and/or strips...we've got the right tool to match your grinding task!

## Lapping and polishing points made of wood shank Ø 3 mm

### Lapping and polishing points made of wood

These points made of hard and soft wood can be used rotating or linear (in hand-filing machines). These points can also be shaped for processing radii and the like. Use mainly with compounds.

	Design	Shape	Head dimensions	Shank dimensions	Order No.	Price from	
						1 piece	10 pieces
<b>Lapping and polishing points made of wood, shank Ø 3 mm</b>							
	hard wood	cylinder	Ø 6 x 15 mm	Ø 3 x 30 mm	<b>0 570 174</b>		
		cylinder	Ø 10 x 20 mm	Ø 3 x 30 mm	<b>0 570 173</b>		
		cylinder	Ø 15 x 25 mm	Ø 3 x 30 mm	<b>0 570 172</b>		
		cylinder	Ø 20 x 30 mm	Ø 3 x 30 mm	<b>0 570 171</b>		
		sphere	Ø 10 x 10 mm	Ø 3 x 30 mm	<b>0 570 176</b>		
	soft wood	flame	Ø 10 x 30 mm	Ø 3 x 30 mm	<b>0 570 178</b>		
		cylinder	Ø 6 x 15 mm	Ø 3 x 30 mm	<b>0 570 184</b>		
		cylinder	Ø 10 x 20 mm	Ø 3 x 30 mm	<b>0 570 183</b>		
		cylinder	Ø 15 x 25 mm	Ø 3 x 30 mm	<b>0 570 182</b>		
		cylinder	Ø 20 x 30 mm	Ø 3 x 30 mm	<b>0 570 181</b>		
	soft wood	sphere	Ø 10 x 10 mm	Ø 3 x 30 mm	<b>0 570 186</b>		
		flame	Ø 10 x 30 mm	Ø 3 x 30 mm	<b>0 570 188</b>		

## Lapping and polishing points made of wood shank Ø 6 mm














### Lapping and polishing points made of wood

These points made of hard and soft wood can be used rotating or linear (in hand-filing machines). These points can also be shaped for processing radii and the like. Use mainly with compounds.

	Design	Shape	Head dimensions	Shank dimensions	Order No.	Price from	
						1 piece	10 pieces
<b>Lapping and polishing points made of wood, shank Ø 6 mm</b>							
	hard wood	cylinder	Ø 15 x 25 mm	Ø 6 x 30 mm	<b>0 570 272</b>		
		cylinder	Ø 20 x 30 mm	Ø 6 x 30 mm	<b>0 570 271</b>		
	soft wood	cylinder	Ø 15 x 25 mm	Ø 6 x 30 mm	<b>0 570 282</b>		
		cylinder	Ø 20 x 30 mm	Ø 6 x 30 mm	<b>0 570 281</b>		

## 2 Wooden lapping sticks hard and soft

These sticks are made from laminated hard wood. The individual layers are pressed together crossways to their grain under very high pressure. This results in a long service life with very high structural stability. Use with diamond compounds before final polishing and whenever high stock removal is required.

	Dimensions	Hardness	Order No.	Price from	
				1 piece	10 pieces
<b>Wooden lapping sticks, hard (beech laminated)</b>					
<b>round, pointed</b>					
	 Ø 3 x 150 mm	hard	<b>0 411 277</b>		
	 Ø 4.5 x 150 mm	hard	<b>0 411 278</b>		
	 Ø 6.5 x 150 mm	hard	<b>0 411 279</b>		
<b>round, unpointed</b>					
	Ø 10 x 300 mm	hard	<b>0 411 290</b>		
<b>square, with chamfer</b>					
	 3 x 3 x 150 mm	hard	<b>0 411 271</b>		
	 4.5 x 4.5 x 150 mm	hard	<b>0 411 272</b>		
	 6.5 x 6.5 x 150 mm	hard	<b>0 411 273</b>		
<b>rectangular, with chamfer</b>					
	 7 x 3 x 150 mm	hard	<b>0 411 274</b>		
	 12.5 x 8 x 150 mm	hard	<b>0 411 275</b>		
	 19 x 8 x 150 mm	hard	<b>0 411 276</b>		

### matching set

	Order No.	Price from
		1 set
<b>Wooden lapping stick set, hard (9 pcs)</b>		<b>0 411 270</b>



## Wooden lapping sticks hard and soft **2**

These soft wooden lapping sticks are used as carriers for fine diamond compounds during polishing. Precision is therefore a must. That is why only carefully selected, clean and absolutely inclusion-free wood is able to complete its career as a soft wood lapping stick at joke.

	Dimensions	Hardness	Order No.	Price from	
				1 piece	10 pieces
<b>Wooden lapping sticks, soft (lime)</b>					
<b>round, pointed</b>					
	☒ Ø 3 x 150 mm	soft	<b>0 411 287</b>		
	☒ Ø 4.5 x 150 mm	soft	<b>0 411 288</b>		
	☒ Ø 6.5 x 150 mm	soft	<b>0 411 289</b>		
<b>square, with chamfer</b>					
	☒ 3 x 3 x 150 mm	soft	<b>0 411 281</b>		
	☒ 4.5 x 4.5 x 150 mm	soft	<b>0 411 282</b>		
	☒ 6.5 x 6.5 x 150 mm	soft	<b>0 411 283</b>		
<b>rectangular, with chamfer</b>					
	☒ 7 x 3 x 150 mm	soft	<b>0 411 284</b>		
	☒ 12.5 x 8 x 150 mm	soft	<b>0 411 285</b>		
	☒ 19 x 8 x 150 mm	soft	<b>0 411 286</b>		

☒ matching set

	Order No.	Price from
		1 set
<b>Wooden lapping stick set, soft (9 pcs)</b>	<b>0 411 280</b>	



## Plexiglas lapping sticks

We offer these Plexiglas lapping sticks for all those unable to choose between hard and soft wood for their lapping sticks. Their hardness falls right between both wood versions. Likewise used with diamond compounds.

	Dimensions	Hardness	Order No.	Price from	
				1 piece	10 pieces
<b>Plexiglas lapping sticks</b>					
<b>square, with chamfer</b>					
	3 x 3 x 150 mm	medium	<b>0 411 251</b>		
	4.5 x 4.5 x 150 mm	medium	<b>0 411 252</b>		
	6.5 x 6.5 x 150 mm	medium	<b>0 411 253</b>		
<b>rectangular, with chamfer</b>					
	7 x 3 x 150 mm	medium	<b>0 411 254</b>		
	12.5 x 8 x 150 mm	medium	<b>0 411 255</b>		
	19 x 8 x 150 mm	medium	<b>0 411 256</b>		



## 2 Lapping and polishing tools flex-poli-snap

These lapping and polishing tools are linked to the ball-ended rod via a clever snap-mechanism. This prevents the ball-ended rod from slipping during processing and damaging the material. Simply “snap in” and get down to work.

	Design	Dimensions	Suitable ball-ended rod	Packing quantity	Order No.	Price from	
						1 pack	3 packs
<b>Lapping and polishing tools flex-poli-snap</b>							
<b>square</b>							
	▾ plastic	4 x 4 mm	0 411 174 / 170	50 pieces	<b>0 411 610-50</b>		
	▾	5 x 5 mm	0 411 175 / 171	50 pieces	<b>0 411 611-50</b>		
	▾	6 x 6 mm	0 411 176 / 172	50 pieces	<b>0 411 612-50</b>		
	▾	8 x 8 mm	0 411 177 / 173	50 pieces	<b>0 411 613-50</b>		
	▾ brass	4 x 4 mm	0 411 174 / 170	50 pieces	<b>0 411 630-50</b>		
	▾	5 x 5 mm	0 411 175 / 171	50 pieces	<b>0 411 631-50</b>		
	▾	6 x 6 mm	0 411 176 / 172	50 pieces	<b>0 411 632-50</b>		
	▾	8 x 8 mm	0 411 177 / 173	50 pieces	<b>0 411 633-50</b>		
<b>ring</b>							
	▾ plastic	Ø 4 mm	0 411 174 / 170	50 pieces	<b>0 411 600-50</b>		
	▾	Ø 5 mm	0 411 175 / 171	50 pieces	<b>0 411 601-50</b>		
	▾	Ø 6 mm	0 411 176 / 172	50 pieces	<b>0 411 602-50</b>		
	▾	Ø 8 mm	0 411 177 / 173	50 pieces	<b>0 411 603-50</b>		
	▾ brass	Ø 4 mm	0 411 174 / 170	50 pieces	<b>0 411 620-50</b>		
	▾	Ø 5 mm	0 411 175 / 171	50 pieces	<b>0 411 621-50</b>		
	▾	Ø 6 mm	0 411 176 / 172	50 pieces	<b>0 411 622-50</b>		
	▾	Ø 8 mm	0 411 177 / 173	50 pieces	<b>0 411 623-50</b>		

### matching set



	Order No.	Price from	
		1 set	3 set
<b>Set flex-poli-snap lapping and polishing tool set</b>			
10 tools each in brass and plastic, Ø or edge length: 4, 5, 6 and 8 mm	<b>0 411 189</b>		

The flex-poli-snap ball-ended rods are available with angular and straight heads (only in the set!). Both versions offer the “click” for a secure snap-on connection between tool and rod.

	Head dimensions	for lapping tool size	Design	Shank dimensions	Order No.	Price from
						1 piece
<b>Ball-ended rods flex-poli-snap</b>						
	Ø 1.9 mm	Ø 4 / 4 x 4 mm	angular	Ø 3.5 mm	<b>0 411 174</b>	
	Ø 2.4 mm	Ø 5 / 5 x 5 mm	angular	Ø 3.5 mm	<b>0 411 175</b>	
	Ø 2.9 mm	Ø 6 / 6 x 6 mm	angular	Ø 3.5 mm	<b>0 411 176</b>	
	Ø 3.9 mm	Ø 8 / 8 x 8 mm	angular	Ø 3.5 mm	<b>0 411 177</b>	





### matching set



	Order No.	Price from
		1 set
<b>flex-poli-snap ball-ended rod set</b>		
The set contains 4 straight and 4 angular flex-poli-snap ball-ended rods, rod holder, allen key and a hand rest including suitable stopper.	<b>0 411 169</b>	


## Lapping and polishing rings for rotating processing

Lapping and polishing rings for driving by the corresponding articulated handle and an angle handpiece.  
**Tip: the Ø 12 mm can also be used for linear movement with a ball-ended rod, for example in hand-filing machines.**


	Design	Dimensions	Packing quantity	Order No.	Price from 1 pack
<b>Lapping and polishing rings</b>					
	plastic	Ø 8 mm	10 pieces	<b>0 570 045</b>	
		Ø 12 mm	10 pieces	<b>0 570 055-10</b>	
		Ø 20 mm	10 pieces	<b>0 570 075</b>	
	plastic collar ring	Ø 12 mm	5 pieces	<b>0 570 063</b>	
	brass	Ø 8 mm	10 pieces	<b>0 570 044</b>	
		Ø 12 mm	10 pieces	<b>0 570 054-10</b>	
		Ø 20 mm	10 pieces	<b>0 570 074</b>	
	brass collar ring	Ø 12 mm	5 pieces	<b>0 570 062</b>	

## Lapping and polishing rings for rotating processing

Diamond lapping and polishing rings with metalbound diamonds for lapping of copied, milled, turned and eroded surfaces with peak-to-valley heights greater than 5 µm. Ring and workpiece must be free of oil. Build-up edges must be removed with the ring on abrasive paper of grit size 80-120.




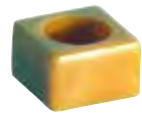


	Dimensions	Grit size	Order No.	Price from 1 piece
<b>Diamond lapping and polishing rings</b>				
	Ø 8 mm	D 151	<b>0 570 041</b>	
	Ø 12 mm	D 151	<b>0 570 051</b>	
	Ø 20 mm	D 151	<b>0 570 071</b>	

### Accessories / spare parts

	Dimensions	Shank dimensions	Order No.	Price from 1 piece
<b>suitable articulated handles for lapping and polishing rings</b>				
	Ø 8 mm	Ø 3 mm	<b>0 570 050</b>	
	Ø 12 mm	Ø 3 mm	<b>0 570 060</b>	
	Ø 20 mm	Ø 3 mm	<b>0 570 080</b>	
		Ø 6 mm	<b>0 570 081</b>	

## 2 Lapping and polishing tools for linear processing

Rings, squares and triangles made of brass and plastic for lapping and polishing of small faces, corners and edges (particularly triangles). Linear movement through ball-ended rods, which are clamped into hand-filing machines.

Design	Dimensions	Suitable ball-ended rod	Packing quantity	Order No.	Price from	
					1 pack	3 packs
<b>Lapping and polishing tools</b>						
<b>triangle</b>						
	brass	3.5 x 3.5 x 3.5 mm	0 411 141	50 pieces	<b>0 411 117-50</b>	
		6 x 6 x 6 mm	0 411 142	50 pieces	<b>0 411 118-50</b>	
		8 x 8 x 8 mm	0 411 144	50 pieces	<b>0 411 119-50</b>	
	plastic	3.5 x 3.5 x 3.5 mm	0 411 141	100 pieces	<b>0 411 137</b>	
		6 x 6 x 6 mm	0 411 142	100 pieces	<b>0 411 138</b>	
		8 x 8 x 8 mm	0 411 144	100 pieces	<b>0 411 139</b>	
<b>square</b>						
	brass	2 x 2 x 1.5 mm	0 411 141	50 pieces	<b>0 411 111-50</b>	
		2.5 x 2.5 x 1.5 mm	0 411 142	50 pieces	<b>0 411 112-50</b>	
		3 x 3 x 2 mm	0 411 143	50 pieces	<b>0 411 113-50</b>	
		4 x 4 x 3 mm	0 411 144	50 pieces	<b>0 411 114-50</b>	
		5 x 5 x 3 mm	0 411 145	50 pieces	<b>0 411 115-50</b>	
	plastic	2 x 2 x 1.5 mm	0 411 141	100 pieces	<b>0 411 131</b>	
		3 x 3 x 2 mm	0 411 143	100 pieces	<b>0 411 133</b>	
		4 x 4 x 3 mm	0 411 144	100 pieces	<b>0 411 134</b>	
		5 x 5 x 3 mm	0 411 145	100 pieces	<b>0 411 135</b>	
		6 x 6 x 4 mm	0 411 146	100 pieces	<b>0 411 136</b>	
<b>ring</b>						
	brass	Ø 2 x 1.5 mm	0 411 141	50 pieces	<b>0 411 101-50</b>	
		Ø 2.5 x 1.5 mm	0 411 142	50 pieces	<b>0 411 102-50</b>	
		Ø 3 x 2 mm	0 411 143	50 pieces	<b>0 411 103-50</b>	
		Ø 4 x 3 mm	0 411 144	50 pieces	<b>0 411 104-50</b>	
		Ø 5 x 3 mm	0 411 145	50 pieces	<b>0 411 105-50</b>	
	plastic	Ø 2 x 1.5 mm	0 411 141	100 pieces	<b>0 411 121</b>	
		Ø 2.5 x 1.5 mm	0 411 142	100 pieces	<b>0 411 122</b>	
		Ø 3 x 2 mm	0 411 143	100 pieces	<b>0 411 123</b>	
		Ø 4 x 3 mm	0 411 144	100 pieces	<b>0 411 124</b>	
		Ø 5 x 3 mm	0 411 145	100 pieces	<b>0 411 125</b>	
	Ø 6 x 4 mm	0 411 146	100 pieces	<b>0 411 126</b>		


# Lapping and polishing tools for linear processing

Accessories / spare parts

	Dimensions	Shank dimensions	Order No.	Price from 1 piece
<b>Ball-ended rods, straight</b>				
	Ø 1.8 x 140 mm	Ø 3.5 mm	<b>0 411 141</b>	
	Ø 2.2 x 140 mm	Ø 3.5 mm	<b>0 411 142</b>	
	Ø 2.7 x 140 mm	Ø 3.5 mm	<b>0 411 143</b>	
	Ø 3.5 x 140 mm	Ø 3.5 mm	<b>0 411 144</b>	
	Ø 4.5 x 140 mm	Ø 3.5 mm	<b>0 411 145</b>	
	Ø 5.5 x 140 mm	Ø 3.5 mm	<b>0 411 146</b>	



matching set

	Order No.	Price from 1 set	5 set
<b>Lapping and polishing tool set, triangles</b>			
 50 pcs of each dimension in brass and plastic	<b>0 411 120</b>		
<b>Lapping and polishing tool set, rings and squares</b>			
Approx. 25 pcs. per dimension and shape in brass and plastic	<b>0 411 100</b>		



# 2 Lapping tools and sticks

## SPEED LAP

The SPEED LAP lapping tools and lapping sticks work quickly and reliably during stock removal and offer many advantages:

- every other grit can be omitted
- even, gentle work
- prevents scratches
- the properties of the metallic component prevent the formation of orange peel through combined lapping and polishing work
- good stock removal rates with low surface roughness
- the dimensional stability of the lapping tools encourages maintenance of the given geometry
- The lapping sticks can be sharpened to a point and retain their shape, so that even sharp inner edges are easy to process

SPEED LAP means a reduction in working stages, time saving and enhancement of surface quality

Preparation of the lapping tools:






- dress before use with fine diamond grits on a ground surface

Preparation of the lapping sticks:

- adapt the lapping sticks to approximate the geometry to be processed (new steel file, diamond film)











**Grit sizes:**

- lapping can be performed down to 1 µm
- every other grit size can be omitted (e.g. instead of 6 µm - 3 µm - 1 µm now 6 µm - 1 µm)
- after the preparatory work with joke Magic Stone grit size 600, lapping with 6 µm can be performed on readily polishable steels, otherwise with 9 µm.
- the diamond compound should be sufficiently diluted with fluid.
- work with light pressure for about 2/3 of the working stage and without pressure for the last third (finishing).
- use full speed in linear motion with a rather short stroke and max. 3000 rpm for rotary processing



	Dimensions	Packing quantity	Order No.	Price from		
				1 pack	3 packs	5 packs
<b>Lapping sticks SPEED LAP</b>						
	Ø 3 x 50 mm	15 pieces	<b>0 570 005</b>			
	Ø 4 x 140 mm	5 pieces	<b>0 570 006</b>			
	Ø 5 x 140 mm	5 pieces	<b>0 570 007</b>			
	Ø 6 x 140 mm	5 pieces	<b>0 570 008</b>			
	Ø 8 x 140 mm	5 pieces	<b>0 570 009</b>			
	4 x 4 x 140 mm	5 pieces	<b>0 570 011</b>			
	5 x 5 x 140 mm	5 pieces	<b>0 570 012</b>			
	6 x 6 x 140 mm	5 pieces	<b>0 570 013</b>			
	8 x 8 x 140 mm	5 pieces	<b>0 570 014</b>			
	4 x 6 x 140 mm	5 pieces	<b>0 570 015</b>			
	6 x 10 x 140 mm	5 pieces	<b>0 570 016</b>			
	8 x 15 x 140 mm	5 pieces	<b>0 570 017</b>			

# Lapping tools and sticks

## SPEED LAP

	Dimensions	Suitable ball-ended rod	Packing quantity	Order No.	Price from				
					1 pack	3 packs	5 packs	50 packs	100 packs
<b>Lapping tools SPEED LAP</b>									
<b>triangle</b>									
	6 x 6 x 6 x 3 mm	0 570 035	25 pieces	<b>0 570 028</b>					
	8 x 8 x 8 x 4 mm	0 570 036	25 pieces	<b>0 570 029</b>					
<b>square</b>									
	4 x 4 x 2,5 mm	0 570 035	25 pieces	<b>0 570 024</b>					
	5 x 5 x 3,0 mm	0 570 035	25 pieces	<b>0 570 025</b>					
	6 x 6 x 3,5 mm	0 570 036	25 pieces	<b>0 570 026</b>					
	8 x 8 x 4 mm	0 570 036	25 pieces	<b>0 570 027</b>					
<b>ring</b>									
	Ø 4 x 2,5 mm	0 570 035	25 pieces	<b>0 570 020</b>					
	Ø 5 x 3,0 mm	0 570 035	25 pieces	<b>0 570 021</b>					
	Ø 6 x 3,5 mm	0 570 036	25 pieces	<b>0 570 022</b>					
	Ø 8 x 4,0 mm	0 570 036	25 pieces	<b>0 570 023</b>					

### Accessories / spare parts

	Order No.	Price from	
		1 piece	5 pieces
<b>Ball-ended rod SPEED LAP 2.5 mm</b>			
	<b>0 570 035</b>		
<b>Ball-ended rod SPEED LAP 3.3 mm</b>			
	<b>0 570 036</b>		



# 2 Internal lapping tools HELICAL LAP

## The ideal solution for perfect bores

### HELICAL LAP internal and external lapping tools

are made of close-grained grey cast iron. A homogenous smooth structure is achieved by a special annealing process making HELILAP the ideal carrier for any lapping media, especially for joke Magic and/or Hyprez® diamond compounds.

### HELICAL LAP internal lapping tools

have a spiral cut and taper bore, which fits precisely to the corresponding shaft. These two features guarantee a uniform and cylindrical expansion of the lapping tools. Roundness and parallelism of bores can be achieved quickly and economically within extremely fine limits. All internal lapping tools are ground. The retraction tool is used for the expanded lapping tool. It is available with several inserts; for applications refer to the table.

### HELICAL LAP outside lapping tools

also have a spiral cut and must be used with the corresponding holder. First, the lapping tool is fixed in the holder to prevent the tool from rotating simultaneously. The inside diameter of the lapping tool can be adjusted to a precisely round shape by contracting the holder. – All external lapping tools are ground and supplied at least 0.02 mm bigger than the indicated nominal diameter.

### Basic principles

- Internal lapping tools should be longer than the bore to be lapped
- External lapping tools should be shorter than the shaft to be lapped
- Lapping tools should be stored separately according to the grit size.



#### Looking for the right compound?

Flip through to page 106. A large selection of the widest variety of compounds is to be found on 24 pages.

Markus Abstoß will be pleased to help you with any enquiries:  
+49 2204 839-0 | m.abstoss@joke.de



### The HELICAL LAP system works

#### Work instructions

Drilling and reaming, then finishing with HELICAL LAP, Tolerance  $+0,002$   
 $-0$

All finished bores must be cylindrical and round, max. deviation 0.2 µm.  
The  $R_a$  value must not exceed 0.05 µm.

#### Measuring results

##### 1. INITIAL SITUATION

Steel bush, hardened Ø 16 x 35 mm  
Measuring instrument: Taylor Hobson  
Talyrond Roundness error: 0.04 mm  
Measured  $R_a$  value: 0.6 µm

##### 2. ROUGH LAPPING

Time: 5 min  
Tool: HELICAL LAP  
Lapping compound: joke HYPREZ®  
diamond compound 14 µm  
Correction of roundness to 0.0004 mm



##### 3. FINISHING

Time: 5 min  
Tool: HELICAL LAP  
Lapping compound: joke HYPREZ®  
diamond compound 3 µm  
Correction of roundness to 0.0002 mm  
Measured  $R_a$  value: 0.04 µm



# Internal lapping tools HELICAL LAP

## Standard dimensions

Design	End Ø E	Total length D	Suitable push-fit shaft	Suitable driver	Suitable retraction tool	Order No.	Price from 1 piece
<b>Internal lapping tool HELICAL LAP</b>							
 without radial groove	1.674 - 1.930 mm	16 mm	0 586 102	0 586 152	0 586 201	<b>0 586 302</b>	
	1.956 - 2.311 mm	16 mm	0 586 102	0 586 152	0 586 201	<b>0 586 303</b>	
	2.362 - 2.743 mm	19 mm	0 586 103	0 586 153	0 586 201	<b>0 586 304</b>	
	2.743 - 3.099 mm	19 mm	0 586 103	0 586 154	0 586 201	<b>0 586 305</b>	
	3.149 - 3.479 mm	22 mm	0 586 104	0 586 154	0 586 201	<b>0 586 306</b>	
	3.530 - 3.886 mm	22 mm	0 586 104	0 586 154	0 586 201	<b>0 586 307</b>	
	3.937 - 4.318 mm	22 mm	0 586 104	0 586 154	0 586 201	<b>0 586 308</b>	
	4.318 - 4.673 mm	22 mm	0 586 104	0 586 154	0 586 201	<b>0 586 309</b>	
 with radial groove	4.724 - 5.105 mm	35 mm	0 586 105	0 586 155	0 586 211	<b>0 586 310</b>	
	5.130 - 5.461 mm	35 mm	0 586 105	0 586 155	0 586 211	<b>0 586 311</b>	
	5.537 - 5.918 mm	45 mm	0 586 106	0 586 156	0 586 211	<b>0 586 312</b>	
	5.918 - 6.248 mm	45 mm	0 586 106	0 586 156	0 586 211	<b>0 586 313</b>	
	6.324 - 6.705 mm	50 mm	0 586 107	0 586 157	0 586 211	<b>0 586 314</b>	
	6.731 - 7.010 mm	50 mm	0 586 107	0 586 157	0 586 211	<b>0 586 315</b>	
	7.112 - 7.340 mm	50 mm	0 586 107	0 586 157	0 586 211	<b>0 586 316</b>	
	7.518 - 7.670 mm	50 mm	0 586 107	0 586 157	0 586 211	<b>0 586 317</b>	
	7.924 - 8.305 mm	50 mm	0 586 108	0 586 158	0 586 211	<b>0 586 318</b>	
	8.305 - 8.610 mm	50 mm	0 586 108	0 586 158	0 586 211	<b>0 586 319</b>	
	8.712 - 8.915 mm	50 mm	0 586 108	0 586 158	0 586 211	<b>0 586 320</b>	
	9.093 - 9.245 mm	50 mm	0 586 108	0 586 158	0 586 211	<b>0 586 321</b>	
	9.499 - 9.855 mm	63 mm	0 586 109	0 586 159	0 586 211	<b>0 586 322</b>	
	9.906 - 10.185 mm	63 mm	0 586 109	0 586 159	0 586 211	<b>0 586 323</b>	
	10.287 - 10.515 mm	63 mm	0 586 109	0 586 159	0 586 211	<b>0 586 324</b>	
	10.693 - 10.845 mm	63 mm	0 586 109	0 586 159	0 586 211	<b>0 586 325</b>	
	11.074 - 11.430 mm	63 mm	0 586 110	0 586 160	0 586 211	<b>0 586 326</b>	
	11.480 - 11.785 mm	63 mm	0 586 110	0 586 160	0 586 211	<b>0 586 327</b>	
	11.861 - 12.090 mm	63 mm	0 586 110	0 586 160	0 586 211	<b>0 586 328</b>	
	12.268 - 12.420 mm	63 mm	0 586 110	0 586 160	0 586 211	<b>0 586 329</b>	
12.674 - 13.081 mm	83 mm	0 586 111	0 586 161	0 586 211	<b>0 586 330</b>		
13.081 - 13.487 mm	83 mm	0 586 111	0 586 161	0 586 211	<b>0 586 331</b>		
13.462 - 13.868 mm	83 mm	0 586 111	0 586 161	0 586 211	<b>0 586 332</b>		

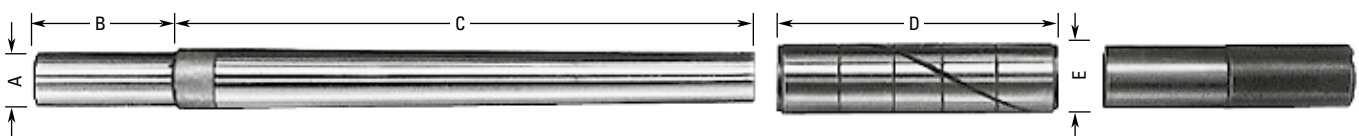


### Practical tips

If the desired diameter cannot be found in the table, rework the next largest lapping tool to the suitable diameter, e.g. on a lathe. The recesses must be retained, since they serve as a compound reservoir. The diameter to be adjusted is always the actual bore diameter minus 2 x stated grit size of the compound used. Process, clean and measure the bore and subsequently fit the tool to the mandrel accordingly by expansion.

**Special sizes available on request!** Please enquire about our special sizes, indicating the actual diameter of the workpiece to be processed.

**Speed: 100 – 200 1/min**



## 2 Internal lapping tools HELICAL LAP

### Standard dimensions

#### Accessories / spare parts

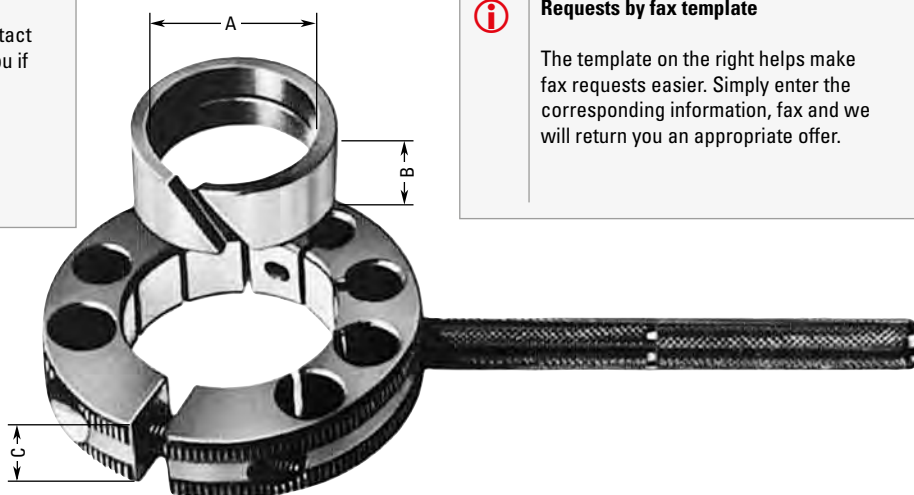
	Type	Shank dimensions A x B	Cone length C	Order No.	Price from 1 piece
<b>Push-fit shafts HELICAL LAP</b>					
	3/0	Ø 3.2 x 19 mm	38 mm	<b>0 586 102</b>	
	2/0	Ø 3.2 x 19 mm	41 mm	<b>0 586 103</b>	
	0	Ø 3.2 x 19 mm	44 mm	<b>0 586 104</b>	
	1	Ø 4.8 x 25 mm	70 mm	<b>0 586 105</b>	
	2	Ø 4.8 x 25 mm	76 mm	<b>0 586 106</b>	
	3	Ø 4.8 x 25 mm	102 mm	<b>0 586 107</b>	
	4	Ø 5.6 x 25 mm	102 mm	<b>0 586 108</b>	
	5	Ø 7.2 x 38 mm	127 mm	<b>0 586 109</b>	
	6	Ø 8.0 x 38 mm	127 mm	<b>0 586 110</b>	
	7	Ø 9.5 x 38 mm	152 mm	<b>0 586 111</b>	
<b>Driver HELICAL LAP</b>					
	3/0			<b>0 586 152</b>	
	2/0			<b>0 586 153</b>	
	0			<b>0 586 154</b>	
	1			<b>0 586 155</b>	
	2			<b>0 586 156</b>	
	3			<b>0 586 157</b>	
	4			<b>0 586 158</b>	
	5			<b>0 586 159</b>	
	6			<b>0 586 160</b>	
	7			<b>0 586 161</b>	
<b>Retraction tool HELICAL LAP</b>					
	Size 0			<b>0 586 201</b>	
	Size 1			<b>0 586 211</b>	



#### Your choice made easy

Refer to the relevant column in the "internal lapping tools" table to find the matching accessories. Enquiries pleased, your contact **Markus Abstoß** will be pleased to help you if you still have any further questions:

Tel. +49 2204 839-0 | [m.abstoss@joke.de](mailto:m.abstoss@joke.de)



#### Requests by fax template

The template on the right helps make fax requests easier. Simply enter the corresponding information, fax and we will return you an appropriate offer.

# Technical support **2** HELICAL LAP

## Request HELICAL LAP

Mail [sales@joke.de](mailto:sales@joke.de)

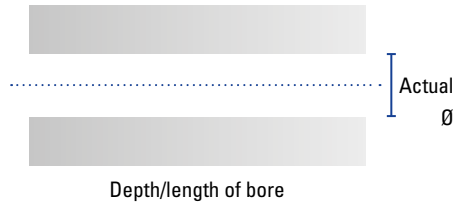
### Internal lapping tool

Actual Ø of bore .....

Depth/length of bore .....

Blind hole bore  yes  no

Number of internal lapping tools required .....



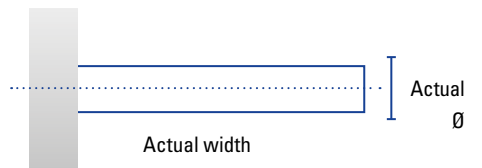
### External lapping tool

Actual Ø of shaft .....

Required width of lapping tool .....

Actual shaft width .....

Number of external lapping tools required .....



### Sender

Company .....

Name .....

First name .....

Department .....

Street .....

Postcode / town / city .....

Phone no. ....

Mail .....

Date, signature .....

# Polishing brushes and buff wheels

<b>170</b>	<b>Fleece polishing wheels with shank</b>	<b>190</b>	<b>Convolute compact grinding discs</b>	<b>194</b>	<b>Jet brushes</b>
<b>176</b>	<b>Polishing brushes and buff wheels with shaft</b>	<b>191</b>	<b>Polishing buffing discs</b>	<b>196</b>	<b>Pipe brushes</b>
<b>184</b>	<b>Polishing grinding discs joke HABRAS</b>	<b>192</b>	<b>Round brushes</b>	<b>198</b>	<b>Nylon honing brushes</b>



## Characteristics and fields of application of the brush trimmings

Trimming material	Characteristics	Field of application
<b>Fine cotton</b>	<ul style="list-style-type: none"> <li>Natural product, soft</li> <li>Picked</li> <li>Highly adaptable</li> </ul>	<ul style="list-style-type: none"> <li>Shining, polishing, dust removal</li> <li>Use with compounds</li> </ul>
<b>Felt buff</b>	<ul style="list-style-type: none"> <li>Natural product</li> <li>Highly adaptable</li> </ul>	<ul style="list-style-type: none"> <li>Shining, polishing, dust removal</li> <li>Use with compounds</li> </ul>
<b>Muslin/fleece</b>	<ul style="list-style-type: none"> <li>Highly adaptable</li> <li>High strength</li> <li>High stock removal until completely worn</li> </ul>	<ul style="list-style-type: none"> <li>Shining, polishing, dust removal</li> <li>Use with compounds</li> <li>Deburring</li> </ul>
<b>Goat hair</b>	<ul style="list-style-type: none"> <li>Very flexible, very soft</li> <li>Absorbent</li> <li>Natural product</li> </ul>	<ul style="list-style-type: none"> <li>Shining, polishing, dust removal</li> <li>Use with compounds (&lt; 6 µm)</li> </ul>
<b>Horsehair</b>	<ul style="list-style-type: none"> <li>Flexible yet hard</li> <li>Absorbent</li> <li>Natural product</li> </ul>	<ul style="list-style-type: none"> <li>Shining, polishing, dust removal</li> <li>Use with compounds (&lt; 6 µm)</li> </ul>
<b>Bristles (black or white)</b>	<ul style="list-style-type: none"> <li>Flexible, yet hard</li> <li>Elastic</li> <li>Strongest of all natural products</li> <li>Good compound absorbance in the individual bristles (hollow!)</li> </ul>	<ul style="list-style-type: none"> <li>Shining, polishing, dust removal</li> <li>Use with compounds (&lt; 6 µm)</li> </ul>





### Characteristics and fields of application of the brush trimmings


Trimming material	Characteristics	Field of application
<b>Nylon/synthetic</b>	<ul style="list-style-type: none"> <li>Better than chemical fibres with regard to friction resistance, elasticity, flexibility and durability</li> <li>Resistant to solvents, but readily soluble in acids</li> <li>Preferably used in the food and chemical industry (in contrast to natural products --&gt; bristles)</li> </ul>	<ul style="list-style-type: none"> <li>Shining, polishing, dust removal</li> <li>Use with compounds (&lt; 6 µm)</li> </ul>
<b>Deerskin</b>	<ul style="list-style-type: none"> <li>Highly adaptable</li> <li>Natural product</li> <li>Resistant</li> <li>High stock removal</li> </ul>	<ul style="list-style-type: none"> <li>Shining, polishing, dust removal</li> <li>Use with compounds</li> </ul>
<b>Brass wire</b>	<ul style="list-style-type: none"> <li>More supple and softer in the polished section than steel wires</li> <li>Discoloration on the workpiece possible</li> </ul>	<ul style="list-style-type: none"> <li>Polishing, descaling, deburring</li> <li>Use with and without compounds</li> </ul>
<b>BAE steel, Bessemer wire, steel wire</b>	<ul style="list-style-type: none"> <li>Flexible and elastic</li> <li>Leave a distinctly visible polished section</li> </ul>	<ul style="list-style-type: none"> <li>Preliminary polishing, descaling, deburring</li> <li>Use with and without compounds</li> </ul>
<b>V2A wire</b>	<ul style="list-style-type: none"> <li>Comparable to steel wire</li> <li>Resistant to acids and alkalis</li> <li>More unbreakable than steel</li> <li>Does not leave any rust residues and may also be used with water</li> </ul>	<ul style="list-style-type: none"> <li>Preliminary polishing, polishing, deburring of stainless steel and aluminium</li> <li>Polishing with water and at high temperatures</li> <li>Use with and without compounds</li> </ul>
<b>HABRAS discs</b>	<ul style="list-style-type: none"> <li>Work without additional abrasive</li> <li>Very flexible, soft plastic</li> <li>Excellent service life</li> <li>High, uniform stock removal until completely worn</li> </ul>	<ul style="list-style-type: none"> <li>Soft metals, aluminium, non-ferrous metals to a shine</li> <li>Deburring of hard plastic</li> <li>Deburring, matting and working to a finish</li> </ul>
<b>HABRAS brushes</b>	<ul style="list-style-type: none"> <li>High elasticity and resistance to buckling</li> <li>High, uniform stock removal until completely worn</li> <li>Long service life</li> <li>Low dust generation</li> <li>Work without additional abrasive</li> </ul>	<ul style="list-style-type: none"> <li>General deburring</li> <li>Preparation for polishing</li> </ul>
<b>Nylon bristles</b>	<ul style="list-style-type: none"> <li>Work without additional abrasive</li> <li>High elasticity and resistance to buckling</li> <li>High, uniform stock removal until completely worn</li> <li>Little contact pressure required</li> </ul>	<ul style="list-style-type: none"> <li>Deburring</li> <li>Matting</li> <li>Surface smoothing</li> </ul>
<b>Grinding fleece</b>	<ul style="list-style-type: none"> <li>Work without additional abrasive</li> <li>High, uniform stock removal until completely worn</li> <li>Cool, soft cut</li> <li>Usable on all materials</li> <li>Adapts to contours</li> </ul>	<ul style="list-style-type: none"> <li>Deburring</li> <li>Matting</li> <li>Surface smoothing</li> </ul>









## 2 Polishing wheels, foamed shank Ø 2.35 x 40 mm

### Polishing wheels and abrasive fleece

Foamed polishing wheels are highly dimensionally stable and are used in grooves and for edge processing. Abrasive fleece may be used wet and dry for deburring, matting and improving surfaces. They are characterised by a cool, soft cut. Owing to their elasticity, they adapt well to the surface contours. Use on all steels, non-ferrous metals, aluminium and plastics.

	Head dimensions	Hardness	Grit size	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from	
								1 piece	50 pieces
<b>Polishing wheel, foamed, shank Ø 2.35 mm</b>									
	Ø 25 x 6 mm	medium	coarse	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 950</b>		

## Polishing wheels, foamed shank Ø 3 x 40 mm

	Head dimensions	Hardness	Grit size	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from	
								1 piece	50 pieces
<b>Polishing wheel, foamed, shank Ø 3 mm</b>									
	Ø 25 x 6 mm	soft	fine	Ø 3 x 40 mm	15000 rpm	10 pieces	<b>0 570 926</b>		
		hard	medium	Ø 3 x 40 mm	15000 rpm	10 pieces	<b>0 570 923</b>		
		hard	coarse	Ø 3 x 40 mm	15000 rpm	10 pieces	<b>0 570 922</b>		
	Ø 25 x 12 mm	hard	medium	Ø 3 x 40 mm	15000 rpm	10 pieces	<b>0 570 924</b>		
		hard	coarse	Ø 3 x 40 mm	15000 rpm	10 pieces	<b>0 570 925</b>		
	Ø 30 x 3 mm	medium	medium	Ø 3 x 40 mm	15000 rpm	10 pieces	<b>0 570 933</b>		
	Ø 30 x 6 mm	soft	fine	Ø 3 x 40 mm	15000 rpm	10 pieces	<b>0 570 932</b>		
		medium	medium	Ø 3 x 40 mm	15000 rpm	10 pieces	<b>0 570 931</b>		
		hard	coarse	Ø 3 x 40 mm	15000 rpm	10 pieces	<b>0 570 930</b>		
	Ø 40 x 3 mm	medium	medium	Ø 3 x 40 mm	12000 rpm	10 pieces	<b>0 570 937</b>		
	Ø 40 x 6 mm	soft	fine	Ø 3 x 40 mm	12000 rpm	10 pieces	<b>0 570 936</b>		
		medium	medium	Ø 3 x 40 mm	12000 rpm	10 pieces	<b>0 570 935</b>		
		hard	coarse	Ø 3 x 40 mm	12000 rpm	10 pieces	<b>0 570 934</b>		



### Grit fleece

coarse (blue) = K 80  
medium (red) = K 120  
fine (black) = K 240

## Polishing wheels, foamed shank Ø 3 x 40 mm

**NEW!**

Soft and flexible, ideal for use in tight slots, grooves, etc.

	Head dimensions	Grit size	Colour	Shank dimensions	Order No.	Price from	
						1 piece	10 pieces
<b>Fleece polishing wheels</b>							
	20 x 1.5 mm	120	brown	Ø 3 x 40 mm	<b>0 573 020</b>		
		240	red	Ø 3 x 40 mm	<b>0 573 021</b>		
		400	green	Ø 3 x 40 mm	<b>0 573 022</b>		
	23 x 1.5 mm	120	brown	Ø 3 x 40 mm	<b>0 573 023</b>		
		240	red	Ø 3 x 40 mm	<b>0 573 024</b>		
		400	green	Ø 3 x 40 mm	<b>0 573 025</b>		
	25 x 1.5 mm	120	brown	Ø 3 x 40 mm	<b>0 573 026</b>		
		240	red	Ø 3 x 40 mm	<b>0 573 027</b>		
		400	green	Ø 3 x 40 mm	<b>0 573 028</b>		



## Grinding rolls corundum

**NEW!**

The solution for processing workpieces with complicated three-dimensional contours (e.g. aluminium injection moulds). A speciality: Process different diameters efficiently with one grinding point, as the tool perfectly adapts to every geometry. Another time-saving advantage: If the material is used up, a "new" tool is obtained by simply tearing off the worn material.

	Head dimensions	Shank dimensions	Grit size	Colour	Packing quantity	Order No.	Price from
							1 pack
<b>Grinding rolls, corundum</b>							
⬇	Ø 13 x 28 mm	Ø 2,34 mm	240	yellow	6 pieces	<b>0 547 970</b>	
⬇	Ø 13 x 28 mm	Ø 2,34 mm	320	red	6 pieces	<b>0 547 971</b>	
⬇	Ø 13 x 28 mm	Ø 2,34 mm	400	white	6 pieces	<b>0 547 972</b>	
⬇	Ø 13 x 28 mm	Ø 2,34 mm	600	blue	6 pieces	<b>0 547 973</b>	
⬇	Ø 13 x 28 mm	Ø 2,34 mm	800	black	6 pieces	<b>0 547 974</b>	
⬇	Ø 13 x 28 mm	Ø 2,34 mm	1000	green	6 pieces	<b>0 547 975</b>	



matching set

	Order No.	Price from
		1 pack
<b>Set grinding rolls, corundum, 6 pcs.</b>		
The set contains one grinding roller each with the grit size: 240, 320, 400, 600, 800, 1000	<b>0 547 976</b>	



## 2 Polishing balls on reusable shaft Ø 6 x 40 mm

**NEW!**

Grinding and polishing ball, abrasive fleece, multi-coated. Ideal for large surfaces and contours, as well as in large holes, pipes, etc.

	Design	Head dimensions	Grit size	Shank dimensions	Order No.	Price from		
						1 piece	10 pieces	50 pieces
<b>Grinding and polishing ball, abrasive fleece, multi-coated</b>								
	hard	50 mm	100	Ø 6 x 40 mm	<b>0 572 350</b>			
	medium hard	50 mm	320	Ø 6 x 40 mm	<b>0 572 353</b>			
	SiC	50 mm	600	Ø 6 x 40 mm	<b>0 572 356</b>			
	soft	50 mm	1000	Ø 6 x 40 mm	<b>0 572 358</b>			
	hard	75 mm	180	Ø 6 x 40 mm	<b>0 572 361</b>			
	medium hard	75 mm	320	Ø 6 x 40 mm	<b>0 572 360</b>			
	medium hard	75 mm	400	Ø 6 x 40 mm	<b>0 572 362</b>			

### Accessories / spare parts



	Order No.	Price from
		1 set
<b>Clamping shaft</b>		
Ø 6 mm with left-hand thread, 2 pieces, washers and locknut	<b>0 572 352</b>	

**Also ideal in combination with a polishing block!**




## Polishing balls Refill pack

Fit simply on the existing shaft. Unless otherwise described, corundum is used as an abrasive.

	Design	Head dimensions	Grit size	Packing quantity	Order No.	Price from		
						1 pack	10 packs	50 packs
<b>Refill pack for polishing balls</b>								
	hard	50 mm	100	20 pieces	<b>0 572 351</b>			
	medium hard	50 mm	320	20 pieces	<b>0 572 354</b>			
	SiC	50 mm	600	20 pieces	<b>0 572 357</b>			
	soft	50 mm	1000	20 pieces	<b>0 572 359</b>			
	hard	75 mm	180	20 pieces	<b>0 572 364</b>			
	medium hard	75 mm	320	20 pieces	<b>0 572 363</b>			
	medium hard	75 mm	400	20 pieces	<b>0 572 365</b>			



## Fleece polishing wheels shank Ø 2.35 x 40 mm

Material	Head dimensions	Hardness	Grit size	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from	
								1 piece	50 pieces
<b>Abrasive fleece, shank Ø 2.35 mm, dual-layer</b>									
	Ø 25 x 6 mm	medium	medium	Ø 2.35 x 40 mm	5000 rpm	10 pieces	<b>0 570 951</b>		
	Ø 25 x 6 mm	medium	fine	Ø 2.35 x 40 mm	5000 rpm	10 pieces	<b>0 570 952</b>		
	Ø 25 x 6 mm	medium	very fine	Ø 2.35 x 40 mm	5000 rpm	10 pieces	<b>0 570 956</b>		
<b>Abrasive fleece, shank Ø 2.35 mm, triple-layer</b>									
	Ø 25 x 8 mm	medium	medium	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 953</b>		
<b>Polishing brush, shank Ø 2.35 mm</b>									
	Scotch-Brite, fine and Chung-King	Ø 22 x 8 mm	-	-	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 888</b>	



**Grit fleece**

very coarse = K 60  
 coarse = K 80  
 medium = K 180  
 fine = K 240  
 very fine = K 400  
 ultra fine = K 1000

## 2 Fleece polishing wheels

### shank Ø 3 x 40 mm

	Head dimensions	Hardness	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from	
							1 piece	50 pieces
<b>Abrasive fleece, shank Ø 3 mm, triple-layer</b>								
<b>very coarse, colour: red</b> for deburring, derusting, etc. • firm grade	☒ Ø 22 x 13 mm	hard	Ø 3 x 40 mm	10000 1/min	10 pieces	<b>0 572 309</b>		
	Ø 25 x 17 mm	hard	Ø 3 x 40 mm	10000 1/min	10 pieces	<b>0 572 310</b>		
	Ø 30 x 17 mm	hard	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 572 311</b>		
<b>very coarse, colour: red</b> Ideally suited for all metals. High stock removal on aluminium, gold and silver. • very coarse grade	☒ Ø 22 x 13 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	<b>0 570 966</b>		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 570 940</b>		
	Ø 40 x 22 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 570 945</b>		
<b>coarse, colour: red</b> for processing all materials, ideal for removing small scratches, for deburring etc.	☒ Ø 22 x 13 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	<b>0 570 967</b>		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 570 941</b>		
	Ø 40 x 22 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 570 946</b>		
<b>medium, colour: green-brown</b> very well suited for processing aluminium and stainless steel • very firm grade	☒ Ø 22 x 13 mm	very hard	Ø 3 x 40 mm	10000 1/min	10 pieces	<b>0 572 315</b>		
	Ø 25 x 17 mm	very hard	Ø 3 x 40 mm	10000 1/min	10 pieces	<b>0 572 316</b>		
	Ø 30 x 17 mm	very hard	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 572 317</b>		
<b>medium, colour: red</b> very well suited for processing aluminium and stainless steel • very firm grade For processing all materials, ideal for removing small scratches, for deburring etc.	Ø 22 x 13 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	<b>0 570 968</b>		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 570 942</b>		
	Ø 40 x 22 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 570 947</b>		
<b>fine, colour: red</b> for processing all metals, highly versatile.	☒ Ø 22 x 13 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	<b>0 570 969</b>		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 570 943</b>		
	Ø 40 x 22 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 570 948</b>		
<b>very fine (SIC), colour: grey</b> Using this grinding fleece results in a slight shine. Ideal for aluminium, stainless steels, etc..	☒ Ø 22 x 13 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	<b>0 572 301</b>		
	Ø 25 x 17 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	<b>0 572 302</b>		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 572 303</b>		
<b>ultra fine, colour: gold</b> Very fine grinding nylon and grit. Ideal for processing gold, silver, brass, copper and aluminium.	☒ Ø 22 x 13 mm	soft	Ø 3 x 40 mm	10000 1/min	10 pieces	<b>0 572 305</b>		
	Ø 25 x 17 mm	soft	Ø 3 x 40 mm	10000 1/min	10 pieces	<b>0 572 304</b>		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 570 958</b>		
<b>without grit, colour: white</b> Grinding nylon without grit, ideal in combination with diamond compounds or also other polishing compounds.	☒ Ø 22 x 13 mm	medium	Ø 3 x 40 mm	10000 1/min	10 pieces	<b>0 570 970</b>		
	Ø 30 x 17 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 570 944</b>		
	Ø 30 x 17 mm	hard	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 572 306</b>		
	Ø 40 x 22 mm	medium	Ø 3 x 40 mm	8000 1/min	10 pieces	<b>0 570 949</b>		



# Fleece polishing wheels

shank Ø 3 x 40 mm

**2**

	Order No.	Price from	
		1 set	5 set

**SET Polishing wheels Abrasive fleeces, 3-layer, Ø 22 x 13 mm, shaft Ø 3 mm, 9 pieces**



Contains one piece each: **0 572 320**

- 0 572 309
- 0 570 966
- 0 570 967
- 0 572 315
- 0 570 968
- 0 570 969
- 0 572 301
- 0 572 305
- 0 570 970

## Overview

particularly well suited

Design	Colour	Plastics	Noble metal	Brass	Aluminium	Steel in general	Stainless steel	Difficult-to-cut materials	Deburring	Polishing
extra coarse	red									
very coarse	red									
coarse	red									
medium	green-brown									
medium	red									
fine	red									
very fine	grey									
ultra fine	gold									
without grain	white									



















## 2 Polishing brushes shank Ø 2.35 mm




	Material	Head dimensions	Trimming Ø	Trimming	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from		
									1 piece	50 pieces	
<b>Polishing brushes, shank Ø 2.35 mm</b>											
<b>cup</b>											
	BAE steel, corrugated	Ø 12 x 6 mm	0.08 mm	straight	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 570</b>			
		Ø 12 x 8 mm	0.08 mm	straight, steep	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 160</b>			
		Ø 12 x 6 mm	0.10 mm	bevelled	Ø 2.35 x 35 mm	10000 rpm	10 pieces	<b>0 570 571</b>			
	V2A wire, corrugated	Ø 12 x 6 mm	0.08 mm	straight	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 520</b>			
		Ø 12 x 6 mm	0.10 mm	bevelled	Ø 2.35 x 35 mm	10000 1/min	10 pieces	<b>0 570 503</b>			
	brass, corrugated	Ø 12 x 6 mm	0.08 mm	straight	Ø 2.35 x 35 mm	10000 rpm	10 pieces	<b>0 570 610</b>			
		Ø 12 x 6 mm	0.10 mm	bevelled	Ø 2.35 x 35 mm	10000 rpm	10 pieces	<b>0 570 501</b>			
		Ø 12 x 8 mm	0.08 mm	straight, steep	Ø 2.35 x 35 mm	10000 rpm	10 pieces	<b>0 570 133</b>			
	bristles, white	Ø 8 x 4 mm		bevelled	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 663</b>			
		Ø 12 x 8 mm		straight	Ø 2.35 x 35 mm	10000 rpm	10 pieces	<b>0 570 660</b>			
		Ø 12 x 8 mm		straight, steep	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 130</b>			
	bristles, black	Ø 12 x 8 mm		bevelled	Ø 2.35 x 35 mm	10000 rpm	10 pieces	<b>0 570 661</b>			
		Ø 8 x 4 mm		bevelled	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 714</b>			
		Ø 12 x 8 mm		straight	Ø 2.35 x 35 mm	10000 rpm	10 pieces	<b>0 570 710</b>			
	nylon	Ø 12 x 8 mm		straight, steep	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 128</b>			
		Ø 12 x 8 mm		bevelled	Ø 2.35 x 35 mm	10000 rpm	10 pieces	<b>0 570 711</b>			
		Ø 8 x 4 mm		bevelled	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 754</b>			
	goat hair, white	Ø 12 x 6 mm	0.30 mm	straight, steep	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 751-0</b>			
		Ø 8 x 4 mm		bevelled	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 872</b>			
		Ø 12 x 6 mm		straight, steep	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 871-0</b>			
	goat hair, white	Ø 12 x 8 mm		bevelled	Ø 2.35 x 35 mm	10000 rpm	10 pieces	<b>0 570 870</b>			
		<b>small brushes</b>									
			V2A wire, corrugated	Ø 3 x 8 mm	0.10 mm		Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 513</b>	
Ø 4 x 8 mm	0.10 mm				Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 510</b>			
Ø 5.5 x 11 mm	0.10 mm				Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 511</b>			
	BAE steel, corrugated	Ø 6 x 13 mm	0.10 mm		Ø 2.35 x 35 mm	10000 rpm	10 pieces	<b>0 570 502</b>			
		Ø 4 x 8 mm	0.10 mm		Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 560</b>			
		Ø 5.5 x 11 mm	0.10 mm		Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 561</b>			
	brass, corrugated	Ø 4 x 8 mm	0.10 mm		Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 620</b>			
		Ø 5.5 x 11 mm	0.10 mm		Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 621</b>			
		Ø 3 x 8 mm			Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 669</b>			
	bristles, white	Ø 4 x 8 mm			Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 670</b>			
		Ø 5.5 x 11 mm			Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 671</b>			
		Ø 4 x 8 mm			Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 720</b>			
	bristles, black	Ø 5.5 x 11 mm			Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 721</b>			
		Ø 7 x 13 mm			Ø 2.35 x 35 mm	10000 rpm	10 pieces	<b>0 570 723</b>			
		Ø 4 x 8 mm			Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 673</b>			
	goat hair, white	Ø 5.5 x 11 mm			Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 674</b>			

## Polishing brushes shank Ø 2.35 mm

	Material	Head dimensions	Trimming Ø	Trimming	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from	
									1 piece	50 pieces
<b>small brushes with elastic protection</b>										
	V2A wire, corrugated	Ø 4 x 8 mm	0.10 mm		Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 512</b>		
	BAE steel, corrugated	Ø 4 x 8 mm	0.10 mm		Ø 2.35 x 35 mm	10000 rpm	10 pieces	<b>0 570 562</b>		
	brass, corrugated	Ø 4 x 8 mm	0.10 mm		Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 622</b>		
	bristles, white	Ø 4 x 8 mm			Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 672</b>		
	bristles, black	Ø 4 x 8 mm			Ø 2.35 x 25 mm	10000 rpm	10 pieces	<b>0 570 722</b>		
<b>wheel</b>										
	VA wire, corrugated	Ø 12 mm	0.06 mm		Ø 2.35 x 30 mm	10000 rpm	10 pieces	<b>0 570 583</b>		
		Ø 14 mm	0.06 mm		Ø 2.35 x 30 mm	10000 rpm	10 pieces	<b>0 570 585</b>		
	V2A wire, corrugated	Ø 16 x 2 mm	0.08 mm		Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 505</b>		
		Ø 19 x 2 mm	0.08 mm		Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 500</b>		
		Ø 22 x 2 mm	0.08 mm		Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 504</b>		
	BAE steel, corrugated	Ø 16 x 2 mm	0.08 mm		Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 553</b>		
		Ø 19 x 2 mm	0.08 mm		Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 551</b>		
		Ø 22 x 2 mm	0.10 mm		Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 550</b>		
	brass, corrugated	Ø 16 x 2 mm	0.10 mm		Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 605</b>		
		Ø 19 x 2 mm	0.10 mm		Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 600</b>		
		Ø 22 x 2 mm	0.08 mm		Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 601</b>		
	goat hair, grey	Ø 10 mm			Ø 2.35 x 30 mm	10000 rpm	10 pieces	<b>0 570 575</b>		
	horsehair, grey	Ø 10 mm			Ø 2.35 x 30 mm	10000 rpm	10 pieces	<b>0 570 576</b>		
	horsehair, silver-grey	Ø 10 mm			Ø 2.35 x 30 mm	10000 rpm	10 pieces	<b>0 570 577</b>		
	Chungking bristles, white	Ø 10 mm			Ø 2.35 x 30 mm	10000 rpm	10 pieces	<b>0 570 578</b>		
	cotton	Ø 10 mm			Ø 2.35 x 30 mm	10000 rpm	10 pieces	<b>0 570 579</b>		
	Scotch Brite, rough	Ø 10 mm			Ø 2.35 x 30 mm	10000 rpm	10 pieces	<b>0 570 582</b>		
	bristles, white	Ø 16 x 1 mm			Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 653</b>		
		Ø 19 x 1 mm			Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 652</b>		
		Ø 22 x 1 mm			Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 651</b>		

## 2 Polishing brushes

### shank Ø 2,35 mm

	Material	Head dimensions	Trimming Ø	Trimming	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from	
									1 piece	50 pieces
	bristles, black	Ø 16 x 1 mm			Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 703</b>		
		Ø 19 x 1 mm			Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 702</b>		
		Ø 22 x 1 mm			Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 701</b>		
	nylon	Ø 16 x 1.5 mm	0.15 mm		Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 752</b>		
		Ø 19 x 1.5 mm	0.15 mm		Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 753</b>		
		Ø 22 x 1.5 mm	0.15 mm		Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 750</b>		
	goat hair, white	Ø 16 x 1 mm			Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 851</b>		
		Ø 22 x 1 mm			Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 850</b>		

### ↓ matching set

	Order No.	Price from	
		1 set	3 set
<b>Set polishing brushes</b>			
The set contains 12 brushes in the shape of a wheel, Ø 10 mm, shaft Ø 2.35 x 40 mm with the following fill material:	<b>0 570 887</b>		
<ul style="list-style-type: none"> <li>• Order No. 0 570 574 goat hair, white</li> <li>• Order No. 0 570 577 horse hair</li> <li>• Order No. 0 570 575 goat hair, grey</li> <li>• Order No. 0 570 580 stainless steel</li> <li>• Order No. 0 570 581 steel wire</li> <li>• Order No. 0 570 606 brass wire</li> <li>• Order No. 0 570 705 Chung King bristle, black</li> <li>• Order No. 0 570 578 Chung King bristle, white</li> <li>• Order No. 0 570 240 Muslin</li> <li>• Order No. 0 570 579 cotton</li> <li>• Order No. 0 570 582 cotch-Brite, coarse</li> <li>• Order No. 0 570 541 Nylon, smooth, white, 0.2 mm</li> </ul>			



## Polishing brushes shank Ø 3 mm

2

	Material	Head dimensions	Trimming Ø	Trimming	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from	
									1 piece	50 pieces
<b>Polishing brushes, shank Ø 3 mm</b>										
<b>cup</b>										
	BAE steel, corrugated	Ø 8 x 5 mm	0.08 mm	straight	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 587</b>		
		Ø 10 x 6 mm	0.08 mm	straight	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 588</b>		
	BAE steel, corrugated	Ø 12 x 6 mm	0.08 mm	straight	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 568</b>		
		Ø 12 x 6 mm	0.10 mm	bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 573</b>		
	bristles, black	Ø 8 x 4 mm		bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 775</b>		
		Ø 12 x 8 mm		straight	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 776</b>		
		Ø 12 x 8 mm		bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 734</b>		
	bristles, white	Ø 8 x 4 mm		bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 777</b>		
		Ø 12 x 8 mm		straight	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 664</b>		
		Ø 12 x 8 mm		bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 735</b>		
	brass, corrugated	Ø 6.5 x 4 mm	0.08 mm	bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 785</b>		
		Ø 6.5 x 4 mm/ 0.10 mm	0.10 mm	bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 786</b>		
		Ø 12 x 6 mm	0.08 mm	straight	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 614</b>		
		Ø 12 x 6 mm	0.10 mm	bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 779</b>		
	nylon	Ø 8 x 4 mm	0.15 mm	bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 774</b>		
	horse hair, black	Ø 25 x 15 mm		bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 873</b>		
	Steel wire, corrugated	Ø 6.5 x 4 mm	0.08 mm	bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 787</b>		
	V2A wire, corrugated	Ø 12 x 6 mm	0.08 mm	straight	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 521</b>		
	V2A wire, corrugated	Ø 12 x 6 mm	0.10 mm	bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 736</b>		
	goat hair, grey	Ø 25 x 15 mm		bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 874</b>		
	goat hair, white	Ø 8 x 4 mm		bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 773</b>		
		Ø 12 x 8 mm		bevelled	Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 733</b>		
<b>small brushes</b>										
	BAE steel, corrugated	Ø 5.5 x 11 mm	0.10 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 564</b>		
	bristles, black	Ø 4 x 8 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 727</b>		
		Ø 5.5 x 11 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 737</b>		
		Ø 7 x 13 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 728</b>		
	bristles, white	Ø 3 x 8 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 668</b>		
		Ø 4 x 8 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 676</b>		
		Ø 5.5 x 11 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 677</b>		
	brass, corrugated	Ø 4 x 8 mm	0.10 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 625</b>		
		Ø 5.5 x 11 mm	0.10 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 626</b>		
	V2A wire, corrugated	Ø 3 x 8 mm	0.10 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 761</b>		
		Ø 4 x 8 mm	0.10 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 762</b>		
		Ø 5.5 x 11 mm	0.10 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 763</b>		
		Ø 6 x 13 mm	0.10 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 729</b>		
	goat hair, white	Ø 4 x 8 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 679</b>		
		Ø 5.5 x 11 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 760</b>		

3




















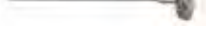
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## 2 Polishing brushes shank Ø 3 mm

	Material	Head dimensions	Trimming Ø	Trimming	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from	
									1 piece	50 pieces
<b>small brushes with elastic protection</b>										
	BAE steel, corrugated	Ø 4 x 8 mm	0.10 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 567</b>		
	bristles, black	Ø 4 x 8 mm			Ø 3 x 25 mm	10000 rpm	10 pieces	<b>0 570 719</b>		
	bristles, white	Ø 4 x 8 mm			Ø 3 x 25 mm	10000 rpm	10 pieces	<b>0 570 678</b>		
	brass, corrugated	Ø 4 x 8 mm	0.10 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 764</b>		
	V2A wire, corrugated	Ø 4 x 8 mm	0.10 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 765</b>		
<b>wheel</b>										
	BAE steel, corrugated	Ø 16 x 2 mm	0.08 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 770</b>		
		Ø 19 x 2 mm	0.08 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 771</b>		
		Ø 22 x 2 mm	0.08 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 554</b>		
	cotton	Ø 10 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 794</b>		
	bristles, black	Ø 16 x 1 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 709</b>		
		Ø 19 x 1 mm			Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 708</b>		
		Ø 22 x 1 mm			Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 731</b>		
	bristles, white	Ø 16 x 1 mm			Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 657</b>		
		Ø 19 x 1 mm			Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 656</b>		
		Ø 22 x 1 mm			Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 732</b>		
	Chungking bristles, black	Ø 10 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 793</b>		
	Chungking bristles, white	Ø 10 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 792</b>		
	brass, corrugated	Ø 10 mm	0.08 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 795</b>		
		Ø 16 x 2 mm	0.10 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 769</b>		
		Ø 19 x 2 mm	0.10 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 607</b>		
		Ø 22 x 2 mm	0.08 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 603</b>		
	nylon	Ø 32 x 2 mm	0.10 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 602</b>		
		Ø 16 x 1.5 mm	0.15 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 767</b>		
		Ø 19 x 1.5 mm	0.15 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 768</b>		
		Ø 22 x 1.5 mm	0.15 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 755</b>		
	horsehair, grey	Ø 10 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 790</b>		
	horsehair, silver-grey	Ø 10 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 791</b>		
	Scotch Bri- te, rough	Ø 10 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 798</b>		
	Steel wire, corrugated	Ø 10 mm	0.08 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 797</b>		
	V2A wire, corrugated	Ø 10 mm	0.08 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 797</b>		
		Ø 16 x 2 mm	0.08 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 772</b>		
		Ø 19 x 2 mm	0.08 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 508</b>		
	VA wire, corrugated	Ø 22 x 2 mm	0.08 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 506</b>		
		Ø 10 mm	0.08 mm		Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 796</b>		
		Ø 12 mm	0.06 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 584</b>		
	VA wire, corrugated	Ø 14 mm	0.06 mm		Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 586</b>		

## Polishing brushes shank Ø 3 mm



	Material	Head dimensions	Trimming		Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from	
			Ø	Trimming					1 piece	50 pieces
	goat hair, grey	Ø 10 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 789</b>		
	goat hair, white	Ø 10 mm			Ø 3 x 30 mm	10000 rpm	10 pieces	<b>0 570 788</b>		
		Ø 16 x 1 mm			Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 766</b>		
		Ø 22 x 1 mm			Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 730</b>		

## Polishing brushes shank Ø 6 mm

	Material	Head dimensions	Trimming Ø	Shank dimensions	Rotation speed max.	Order No.	Price from	
							1 piece	25 pieces
<b>Polishing brushes, shank Ø 6 mm</b>								
<b>wheel</b>								
	goat hair	Ø 45 / 25 x 4 mm	0.10 mm	Ø 6 x 40 mm	10000 rpm	<b>0 570 243</b>		
	cotton	Ø 45 / 25 x 4 mm	-	Ø 6 x 40 mm	10000 rpm	<b>0 570 246</b>		
	fleece, 8 layers	Ø 80 / 40 x 8 mm	-	Ø 6 x 40 mm	10000 rpm	<b>0 570 144</b>		
	perlon	Ø 45 / 25 x 4 mm	0.30 mm	Ø 6 x 40 mm	10000 rpm	<b>0 570 244</b>		
	bristles, black	Ø 45 / 25 x 4 mm	-	Ø 6 x 40 mm	10000 rpm	<b>0 570 245</b>		
	brass wire	Ø 30 / 18 x 6 mm	0.10 mm	Ø 6 x 40 mm	10000 rpm	<b>0 570 223</b>		
		Ø 50 / 25 x 6 mm	0.10 mm	Ø 6 x 40 mm	10000 rpm	<b>0 570 229</b>		
	Bessemer wire	Ø 45 / 25 x 4 mm	0.10 mm	Ø 6 x 40 mm	10000 rpm	<b>0 570 241</b>		




## 2 Diamond polishing brushes shank Ø 3 mm


	Material	Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from		
							1 piece	5 pieces	10 pieces
<b>Polishing brushes, shank Ø 3 mm</b>									
<b>cup</b>									
 <b>NEW!</b>	Nylon-Diamond	Ø 14 x 7 mm	# 400	Ø 3 x 30 mm	10000 rpm	<b>0 572 373</b>			
		Ø 14 x 7 mm	# 600	Ø 3 x 30 mm	10000 rpm	<b>0 572 374</b>			
		Ø 14 x 7 mm	# 800	Ø 3 x 30 mm	10000 rpm	<b>0 572 375</b>			
	Nylon-Diamond	Ø 15 x 4 mm	# 400	Ø 3 x 30 mm	10000 rpm	<b>0 572 456</b>			
		Ø 15 x 4 mm	# 600	Ø 3 x 30 mm	10000 rpm	<b>0 572 457</b>			
		Ø 15 x 4 mm	# 800	Ø 3 x 30 mm	10000 rpm	<b>0 572 458</b>			
	Nylon-SiC	Ø 25 x 8 mm	# 120	Ø 3 x 30 mm	10000 rpm	<b>0 572 385</b>			
		Ø 25 x 8 mm	# 320	Ø 3 x 30 mm	10000 rpm	<b>0 572 386</b>			
		Ø 25 x 8 mm	# 500	Ø 3 x 30 mm	10000 rpm	<b>0 572 387</b>			
	Nylon-Diamond	Ø 25 x 8 mm	# 400	Ø 3 x 30 mm	10000 rpm	<b>0 572 370</b>			
		Ø 25 x 8 mm	# 600	Ø 3 x 30 mm	10000 rpm	<b>0 572 371</b>			
		Ø 25 x 8 mm	# 800	Ø 3 x 30 mm	10000 rpm	<b>0 572 372</b>			
	Nylon-SiC	Ø 30 x 8 mm	# 120	Ø 3 x 30 mm	10000 rpm	<b>0 572 388</b>			
		Ø 30 x 8 mm	# 320	Ø 3 x 30 mm	10000 rpm	<b>0 572 389</b>			
		Ø 30 x 8 mm	# 500	Ø 3 x 30 mm	10000 rpm	<b>0 572 390</b>			
<b>small brushes</b>									
 <b>NEW!</b>	Nylon-Diamant	Ø 3 x 5 mm	# 400	Ø 3 x 30 mm	10000 rpm	<b>0 572 450</b>			
		Ø 3 x 5 mm	# 600	Ø 3 x 30 mm	10000 rpm	<b>0 572 451</b>			
	Ø 3 x 5 mm	# 800	Ø 3 x 30 mm	10000 rpm	<b>0 572 452</b>				
	Ø 6 x 8 mm	# 400	Ø 3 x 30 mm	10000 rpm	<b>0 572 453</b>				
	Ø 6 x 8 mm	# 600	Ø 3 x 30 mm	10000 rpm	<b>0 572 454</b>				
	Ø 6 x 8 mm	# 800	Ø 3 x 30 mm	10000 rpm	<b>0 572 455</b>				
<b>wheel</b>									
Nylon-Diamond	Ø 20 x 2 mm	# 400	Ø 3 x 30 mm	10000 rpm	<b>0 572 376</b>				
	Ø 20 x 2 mm	# 600	Ø 3 x 30 mm	10000 rpm	<b>0 572 377</b>				
	Ø 20 x 2 mm	# 800	Ø 3 x 30 mm	10000 rpm	<b>0 572 378</b>				
	Ø 25 x 2 mm	# 400	Ø 3 x 30 mm	10000 rpm	<b>0 572 379</b>				
	Ø 25 x 2 mm	# 600	Ø 3 x 30 mm	10000 rpm	<b>0 572 380</b>				
	Ø 25 x 2 mm	# 800	Ø 3 x 30 mm	10000 rpm	<b>0 572 381</b>				

**i** Optimum processing with the  
Poli Base polishing machine!  
...more information on page 90...


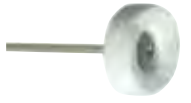



## Diamond polishing brushes shank Ø 6 mm

	Material	Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from		
							1 piece	5 pieces	10 pieces
<b>Polishing brushes, shank Ø 6 mm</b>									
<b>cup</b>									
	Nylon-SiC	Ø 40 x 24 mm	# 80	Ø 6 x 40 mm	10000 rpm	<b>0 572 400</b>			
		Ø 40 x 24 mm	# 120	Ø 6 x 40 mm	10000 rpm	<b>0 572 401</b>			
		Ø 40 x 24 mm	# 240	Ø 6 x 40 mm	10000 rpm	<b>0 572 402</b>			
		Ø 50 x 24 mm	# 80	Ø 6 x 40 mm	10000 rpm	<b>0 572 403</b>			
		Ø 50 x 24 mm	# 120	Ø 6 x 40 mm	10000 rpm	<b>0 572 404</b>			
		Ø 50 x 24 mm	# 240	Ø 6 x 40 mm	10000 rpm	<b>0 572 405</b>			




## Diamond polishing brushes shank Ø 6 mm

Material	Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from		
						1 piece	5 pieces	10 pieces
<b>wheel</b>								
	Nylon-SiC	Ø 40 x 10 mm	# 80	Ø 6 x 40 mm	10000 rpm	<b>0 572 391</b>		
		Ø 40 x 10 mm	# 120	Ø 6 x 40 mm	10000 rpm	<b>0 572 392</b>		
		Ø 40 x 10 mm	# 240	Ø 6 x 40 mm	10000 rpm	<b>0 572 393</b>		
		Ø 50 x 10 mm	# 80	Ø 6 x 40 mm	10000 rpm	<b>0 572 394</b>		
		Ø 50 x 10 mm	# 120	Ø 6 x 40 mm	10000 rpm	<b>0 572 395</b>		
		Ø 50 x 10 mm	# 240	Ø 6 x 40 mm	10000 rpm	<b>0 572 396</b>		
		Ø 65 x 10 mm	# 80	Ø 6 x 40 mm	10000 rpm	<b>0 572 397</b>		
		Ø 65 x 10 mm	# 120	Ø 6 x 40 mm	10000 rpm	<b>0 572 398</b>		
		Ø 65 x 10 mm	# 240	Ø 6 x 40 mm	10000 rpm	<b>0 572 399</b>		

## Polishing buff wheels shank Ø 2.35 mm

Material	Layers	Head dimensions	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from	
							1 piece	50 pieces
<b>Polishing buff wheels, shank Ø 2.35 mm</b>								
	fine cotton	-	Ø 22 x 6 mm	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 900</b>	
	felt	3 layers	Ø 22 x 6 mm	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 980</b>	
	deerskin	5 layers	Ø 22 x 8 mm	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 800</b>	
	muslin	16 layers	Ø 22 x 3 mm	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 990</b>	
	fleece	16 layers	Ø 21 x 3 mm	Ø 2.35 x 40 mm	10000 rpm	10 pieces	<b>0 570 143</b>	

## Polishing buff wheels shank Ø 3 mm

Material	Layers	Head dimensions	Shank dimensions	Rotation speed max.	Packing quantity	Order No.	Price from	
							1 piece	50 pieces
<b>Polishing buff wheels, shank Ø 3 mm</b>								
	fine cotton		Ø 22 x 6 mm	Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 900-0</b>	
	felt	3 layers	Ø 22 x 6 mm	Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 984</b>	
	deerskin	5 layers	Ø 22 x 8 mm	Ø 3 x 37 mm	10000 rpm	10 pieces	<b>0 570 801</b>	

# 2 Polishing grinding discs joke HABRAS Discs

**Recommended motor devices**

**Disc Ø 19 and 25 mm**  
ENESKAmicro, motor system  
jokeFlex Premium

**Disc Ø 51 and 76 mm**  
ENESKAmicro, motor systems  
jokeFlex Premium and Power

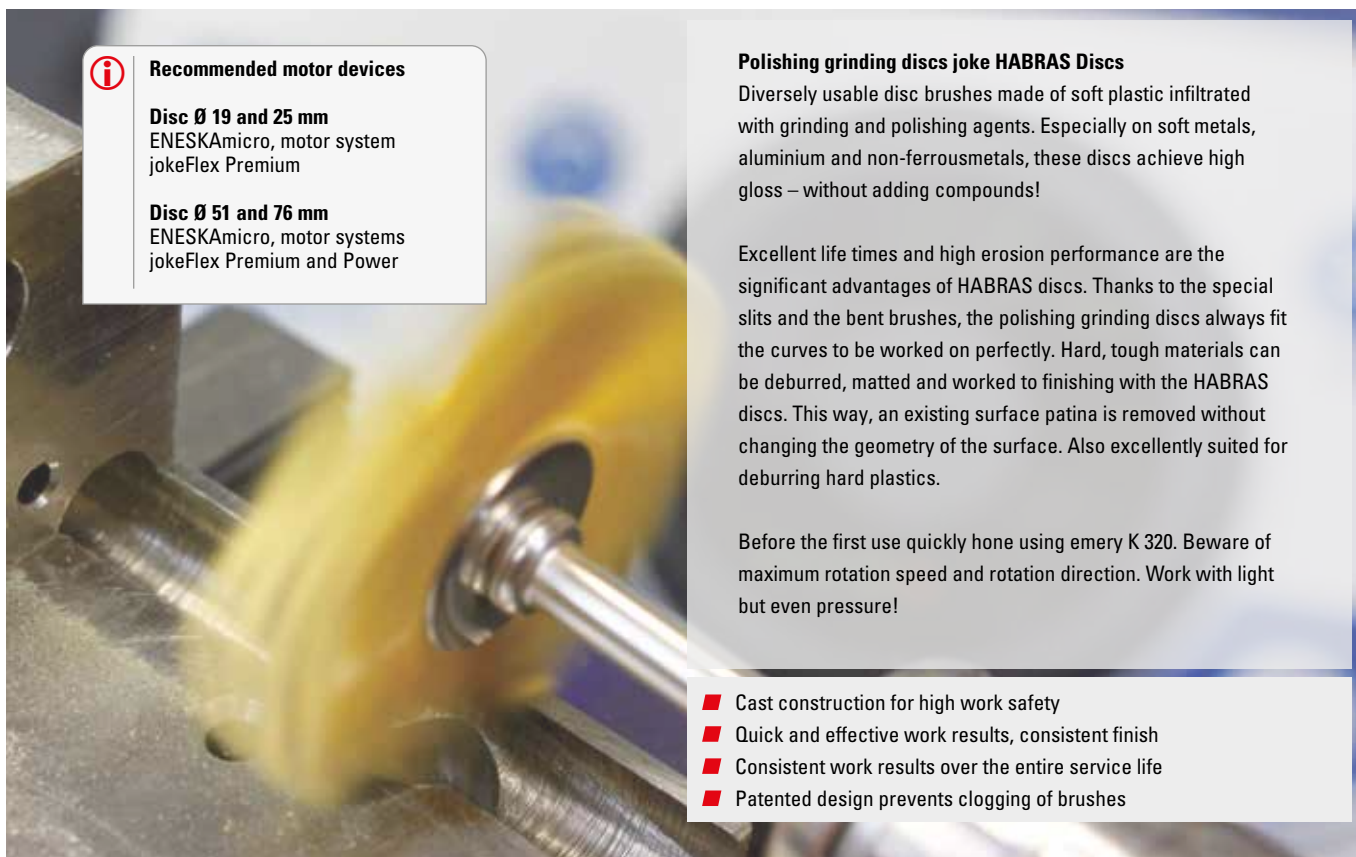
**Polishing grinding discs joke HABRAS Discs**

Diversely usable disc brushes made of soft plastic infiltrated with grinding and polishing agents. Especially on soft metals, aluminium and non-ferrous metals, these discs achieve high gloss – without adding compounds!

Excellent life times and high erosion performance are the significant advantages of HABRAS discs. Thanks to the special slits and the bent brushes, the polishing grinding discs always fit the curves to be worked on perfectly. Hard, tough materials can be deburred, matted and worked to finishing with the HABRAS discs. This way, an existing surface patina is removed without changing the geometry of the surface. Also excellently suited for deburring hard plastics.

Before the first use quickly hone using emery K 320. Beware of maximum rotation speed and rotation direction. Work with light but even pressure!

- Cast construction for high work safety
- Quick and effective work results, consistent finish
- Consistent work results over the entire service life
- Patented design prevents clogging of brushes



joke HABRAS discs are characterised by excellent service life and uniform stock removal. Work is performed directly without addition of compounds. Especially for mirror-polishing soft metals, aluminium and non-ferrous metals. Hard, tough metals such as titanium and stainless steels can be matted and mirror-polished. Any existing surface patina is removed without changing the surface geometry. Well suited for deburring hard plastics. Owing to their slotted design, joke HABRAS discs adapt to the surface shape.

**TIP:** briefly dress joke HABRAS discs before first time use and observe the maximum speed and direction of rotation. Work with light but even working pressure.

### Overview HABRAS Discs

\* **HABRAS PRO:** The particularly robust version!

Use	Abrasive	Grit size	Colour	Ø 14 mm PRO*	
				with shank Ø 3 x 38 mm	with shank Ø 3 x 41 mm
Deburring, Matting	Corundum	extra coarse, P 36	<span style="color: brown;">●</span> brown	x	x
		very coarse, P 50	<span style="color: green;">●</span> green	x	x
		coarse, P 80	<span style="color: yellow;">●</span> yellow	x	x
Deburring, Matting, Cross fading		medium, P 120	<span style="color: white;">○</span> white	0 571 606	0 571 549
		standard, P 220	<span style="color: red;">●</span> red	0 571 607	0 571 601
Matting, Cleaning		fine, P 400	<span style="color: blue;">●</span> blue	0 571 608	0 571 602
Cleaning, Finishing		Pumic stone	very fine –	<span style="color: pink;">●</span> pink	0 571 609
Finishing	High-grade corundum (EKR)	extra fine, 6 µm	<span style="color: orange;">●</span> orange	x	x
		ultra fine, 1 µm	<span style="color: lightgreen;">●</span> light green	x	0 571 605

## Polishing grinding discs joke HABRAS Discs shank Ø 3 x 40 mm **NEW!**






Polish	Head dimensions	Grit size	Co-lour	Shank dimensions	Recommended speed	Order No.	Price from		
							1 piece	5 pieces	10 pieces
<b>Polishing grinding discs joke HABRAS Discs with shank Ø 3 mm</b>									
<b>corundum</b>									
	medium	Ø 14 mm	P 120	white	Ø 3 x 40 mm	5,000 rpm	<b>0 571 549</b>		
	standard	Ø 14 mm	P 220	red	Ø 3 x 40 mm	5,000 rpm	<b>0 571 601</b>		
	fine	Ø 14 mm	P 400	blue	Ø 3 x 40 mm	5,000 rpm	<b>0 571 602</b>		
<b>Pumice</b>									
	very fine	Ø 14 mm	-	pink	Ø 3 x 40 mm	5,000 rpm	<b>0 571 603</b>		
<b>extra fine high-grade corundum</b>									
	high gloss	Ø 14 mm	1 µm	light green	Ø 3 x 40 mm	5,000 rpm	<b>0 571 605</b>		

## Polishing grinding discs joke HABRAS Discs PRO shank Ø 3 x 40 mm







Polish	Head dimensions	Grit size	Co-lour	Shank dimensions	Recommended speed	Order No.	Price from		
							1 piece	5 pieces	10 pieces
<b>Polishing grinding discs joke HABRAS Discs PRO with shank Ø 3 mm</b>									
<b>corundum</b>									
	medium	Ø 14 mm	P 120	white	Ø 3 x 40 mm	5,000 rpm	<b>0 571 606</b>		
	standard	Ø 14 mm	P 220	red	Ø 3 x 40 mm	5,000 rpm	<b>0 571 607</b>		
	fine	Ø 14 mm	P 400	blue	Ø 3 x 40 mm	5,000 rpm	<b>0 571 608</b>		
<b>Pumice</b>									
	very fine	Ø 14 mm	-	pink	Ø 3 x 40 mm	5,000 rpm	<b>0 571 609</b>		

Ø 14 mm		Ø 19 mm			Ø 25 mm PRO*	Ø 51 mm		Ø 76 mm	
without shank 4 Stück	without shank 48 Stück	with shank Ø 3 x 41 mm	without shank 4 Stück	without shank 48 Stück	with shank Ø 3 x 37 mm	with shank Ø 6 x 40 mm	without shank	with shank Ø 6 x 40 mm	without shank
×	×	×	×	×	0 571 067	×	×	×	×
×	×	×	×	×	0 571 068	×	×	×	×
×	×	0 571 031	0 571 037	0 571 043	0 571 061	0 571 501	0 571 521	0 571 511	0 571 531
0 571 559	0 571 561	×	0 571 075	0 571 076	0 571 069	0 571 509	0 571 529	0 571 519	0 571 539
0 571 552	0 571 562	0 571 032	0 571 038	0 571 044	0 571 062	0 571 502	0 571 522	0 571 512	0 571 532
0 571 553	0 571 563	0 571 033	0 571 039	0 571 045	0 571 063	0 571 503	0 571 523	0 571 513	0 571 533
0 571 554	0 571 564	0 571 034	0 571 040	0 571 046	×	0 571 504	0 571 524	×	×
×	×	0 571 035	0 571 041	0 571 047	×	0 571 505	0 571 525	0 571 515	0 571 535
0 571 556	0 571 566	0 571 036	0 571 042	0 571 048	×	0 571 506	0 571 526	0 571 516	0 571 536

## 2 Polishing grinding discs joke HABRAS Discs shank Ø 3 x 40 mm

	Polish	Head dimensions	Grit size	Colour	Shank dimensions	Recommended speed	Order No.	Price from		
								1 piece	5 pieces	10 pieces
<b>Polishing grinding discs joke HABRAS Discs with shank Ø 3 mm</b>										
<b>corundum</b>										
	coarse	Ø 19 mm	P 80	yellow	Ø 3 x 40 mm	5,000 rpm	<b>0 571 031</b>			
	standard	Ø 19 mm	P 220	red	Ø 3 x 40 mm	5,000 rpm	<b>0 571 032</b>			
	fine	Ø 19 mm	P 400	blue	Ø 3 x 40 mm	5,000 rpm	<b>0 571 033</b>			
<b>Pumice</b>										
	very fine	Ø 19 mm		pink	Ø 3 x 40 mm	5,000 1/min	<b>0 571 034</b>			
<b>extra fine high-grade corundum</b>										
	high gloss	Ø 19 mm	1 µm	light green	Ø 3 x 40 mm	5,000 rpm	<b>0 571 036</b>			
	shine	Ø 19 mm	6 µm	orange	Ø 3 x 40 mm	5,000 rpm	<b>0 571 035</b>			

## Polishing grinding discs joke HABRAS Discs PRO shank Ø 3 x 40 mm

	Polish	Head dimensions	Grit size	Colour	Shank dimensions	Recommended speed	Order No.	Price from		
								1 piece	5 pieces	10 pieces
<b>Polishing grinding discs joke HABRAS Discs PRO with shank Ø 3 mm</b>										
<b>corundum</b>										
	extra coarse	Ø 25 x 4 mm	P 36	brown	Ø 3 x 37 mm	5,000 rpm	<b>0 571 067</b>			
	very coarse	Ø 25 x 4 mm	P 50	green	Ø 3 x 37 mm	5,000 rpm	<b>0 571 068</b>			
	coarse	Ø 25 x 4 mm	P 80	yellow	Ø 3 x 37 mm	5,000 rpm	<b>0 571 061</b>			
	medium	Ø 25 x 4 mm	P 120	white	Ø 3 x 37 mm	5,000 rpm	<b>0 571 069</b>			
	standard	Ø 25 x 4 mm	P 220	red	Ø 3 x 37 mm	5,000 rpm	<b>0 571 062</b>			
	fine	Ø 25 x 4 mm	P 400	blue	Ø 3 x 37 mm	5,000 rpm	<b>0 571 063</b>			



**TIP:** The worn grinding discs can be replaced! In doing so, you can reuse the shanks!








Replacement discs for shank on page 188!

## Extension for shank tools

Extension for shank tools	Order No.	Price from	
		1 piece	5 pieces
Shank Ø 3 mm, receptacle Ø 3 mm, 75 mm long	0 571 650		
Shank Ø 6 mm, receptacle Ø 3 mm, 105 mm long	0 571 651		
Shank Ø 8 mm, receptacle Ø 6 mm, 340 mm long	0 571 652		-



## Polishing grinding discs joke HABRAS Discs shank Ø 6 x 40 mm

Polish	Head dimensions	Grit size	Colour	Shank dimensions	Recommended speed	Order No.	Price from		
							1 piece	5 pieces	10 pieces
<b>Polishing grinding discs joke HABRAS Discs, 4 layers, shank Ø 6 x 40 mm</b>									
<b>corundum</b>									
	coarse	Ø 51 x 5 mm	P 80	yellow	Ø 6 x 40 mm	1,400 rpm	0 571 501		
		Ø 76 x 5 mm	P 80	yellow	Ø 6 x 40 mm	1,400 rpm	0 571 511		
	medium	Ø 51 x 5 mm	P 120	white	Ø 6 x 40 mm	1,400 rpm	0 571 509		
		Ø 76 x 5 mm	P 120	white	Ø 6 x 40 mm	1,400 rpm	0 571 519		
	standard	Ø 51 x 5 mm	P 220	red	Ø 6 x 40 mm	1,400 rpm	0 571 502		
		Ø 76 x 5 mm	P 220	red	Ø 6 x 40 mm	1,400 rpm	0 571 512		
	fine	Ø 51 x 5 mm	P 400	blue	Ø 6 x 40 mm	1,400 rpm	0 571 503		
		Ø 76 x 5 mm	P 400	blue	Ø 6 x 40 mm	1,400 rpm	0 571 513		
<b>Pumice</b>									
	very fine	Ø 51 x 5 mm		pink	Ø 6 x 40 mm	1,400 rpm	0 571 504		
<b>extra fine high-grade corundum</b>									
	shine	Ø 51 x 5 mm	6 µm	orange	Ø 6 x 40 mm	1,400 rpm	0 571 505		
		Ø 76 x 5 mm	6 µm	orange	Ø 6 x 40 mm	1,400 rpm	0 571 515		
	high gloss	Ø 51 x 5 mm	1 µm	light green	Ø 6 x 40 mm	1,400 rpm	0 571 506		
		Ø 76 x 5 mm	1 µm	light green	Ø 6 x 40 mm	1,400 rpm	0 571 516		



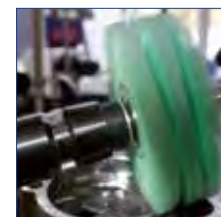
## 2 Polishing grinding discs joke HABRAS Discs without shank for self-assembly

**NEW!**

### HABRAS Discs without shank

Simply go and make yourself your own HABRAS disc tool! The individual solution tailored to your application.

The individually available HABRAS discs are supplied in the same versions, grit sizes and diameters as the shank-mounted discs.



Dimensions	Drilling dimension	Polish	Grit size	Colour	Recommended speed	Packing quantity	Order No.	Price from		
								1 pack	5 packs	10 packs
<b>Polishing grinding discs joke HABRAS without shank</b>										
Ø 14 mm	1.8 mm	medium	P 120	white	5,000 rpm	4 pieces	<b>0 571 559</b>			
	1.8 mm	medium	P 120	white	5,000 rpm	48 pieces	<b>0 571 561</b>			
	1.8 mm	standard	P 220	red	5,000 rpm	4 pieces	<b>0 571 552</b>			
	1.8 mm	standard	P 220	red	5,000 rpm	48 pieces	<b>0 571 562</b>			
	1.8 mm	fine	P 400	blue	5,000 rpm	4 pieces	<b>0 571 553</b>			
	1.8 mm	fine	P 400	blue	5,000 rpm	48 pieces	<b>0 571 563</b>			
	1.8 mm	very fine		pink	5,000 rpm	4 pieces	<b>0 571 554</b>			
	1.8 mm	very fine		pink	5,000 rpm	48 pieces	<b>0 571 564</b>			
	1.8 mm	high gloss	1 µm	light green	5,000 rpm	4 pieces	<b>0 571 556</b>			
	1.8 mm	high gloss	1 µm	light green	5,000 rpm	48 pieces	<b>0 571 566</b>			
Ø 19 mm	1.8 mm	coarse	P 80	yellow	5,000 rpm	4 pieces	<b>0 571 037</b>			
	1.8 mm	coarse	P 80	yellow	5,000 rpm	48 pieces	<b>0 571 043</b>			
	1.8 mm	medium	P 120	white	5,000 rpm	4 pieces	<b>0 571 075</b>			
	1.8 mm	medium	P 120	white	5,000 rpm	48 pieces	<b>0 571 076</b>			
	1.8 mm	standard	P 220	red	5,000 rpm	4 pieces	<b>0 571 038</b>			
	1.8 mm	standard	P 220	red	5,000 rpm	48 pieces	<b>0 571 044</b>			
	1.8 mm	fine	P 400	blue	5,000 rpm	4 pieces	<b>0 571 039</b>			
	1.8 mm	fine	P 400	blue	5,000 rpm	48 pieces	<b>0 571 045</b>			
	1.8 mm	very fine		pink	5,000 rpm	4 pieces	<b>0 571 040</b>			
	1.8 mm	very fine		pink	5,000 rpm	48 pieces	<b>0 571 046</b>			
	1.8 mm	shine	6 µm	orange	5,000 rpm	4 pieces	<b>0 571 041</b>			
	1.8 mm	shine	6 µm	orange	5,000 rpm	48 pieces	<b>0 571 047</b>			
	1.8 mm	high gloss	1 µm	light green	5,000 rpm	4 pieces	<b>0 571 042</b>			
	1.8 mm	high gloss	1 µm	light green	5,000 rpm	48 pieces	<b>0 571 048</b>			



Dimensions	Drilling dimension	Polish	Grit size	Colour	Recommended speed	Order No.	Price from		
							1 piece	5 pieces	10 pieces
<b>Polishing grinding discs joke HABRAS without shank</b>									
Ø 51 x 5 mm	5 mm	coarse	P 80	yellow	1,400 rpm	<b>0 571 521</b>			
	5 mm	medium	P 120	white	1,400 rpm	<b>0 571 529</b>			
	5 mm	standard	P 220	red	1,400 rpm	<b>0 571 522</b>			
Ø 51 x 5 mm	5 mm	fine	P 400	blue	1,400 rpm	<b>0 571 523</b>			
Ø 51 x 5 mm	5 mm	very fine		pink	1,400 rpm	<b>0 571 524</b>			
	5 mm	shine	6 µm	orange	1,400 rpm	<b>0 571 525</b>			
	5 mm	high gloss	1 µm	light green	1,400 rpm	<b>0 571 526</b>			
Ø 76 x 5 mm	5 mm	coarse	P 80	yellow	1,400 rpm	<b>0 571 531</b>			
	5 mm	medium	P 120	white	1,400 rpm	<b>0 571 539</b>			
	5 mm	standard	P 220	red	1,400 rpm	<b>0 571 532</b>			
	5 mm	fine	P 400	blue	1,400 rpm	<b>0 571 533</b>			
	5 mm	shine	6 µm	orange	1,400 rpm	<b>0 571 535</b>			
	5 mm	high gloss	1 µm	light green	1,400 rpm	<b>0 571 536</b>			





# Polishing grinding brushes joke HABRAS

## shank Ø 3 x 40 mm

### Polishing grinding brushes joke HABRAS

The carrier material of these polishing grinding brushes consists of nylon fibre, the characteristics of which, such as elasticity and bend-resistance are of advantage for all applications. The silicon carbide and corundum abrasives are applied with even distribution in the individual fibres.

Owing to the different grit sizes, the brushes in the HABRAS series are highly versatile in use. During processing, the HABRAS brushes are characterised above all by high stability with simultaneously low dust production.

Use for example for deburring cutting edges in carbide metal. Simply condition on K 320 emery before using for the first time!



#### HABRAS brushes and HABRAS

discs – what is the difference?

In both versions, the grit is embedded in the carrier material and is not released during work. Consequently, the result is consistent until completely worn out.

The discs are manufactured in their entirety using the injection moulding method and are only available as wheels. In the case of the brushes, the nylon fibres are grouped together as a pencil, wheel or cup. In contrast to the discs, it is not necessary to observe the direction of rotation in this case!

									Price from	
	Abrasive	Fibre	Head dimensions	Grit size	Colour	Shank dimensions	Rotation speed max.	Order No.	1 piece	10 pieces
<b>Polishing grinding brushes joke HABRAS</b>										
<b>cup</b>										
	corundum	coarse	Ø 12 / 6 mm	P 320	blue/red	Ø 3 x 40 mm	2,800 rpm	<b>0 571 013</b>		
		medium	Ø 12 / 6 mm	P 500	blue/green	Ø 3 x 40 mm	2,800 rpm	<b>0 571 012</b>		
		fine	Ø 12 / 6 mm	P 600	blue	Ø 3 x 40 mm	2,800 rpm	<b>0 571 011</b>		
	SiC	coarse	Ø 12 / 6 mm	P 320	green	Ø 3 x 40 mm	2,800 rpm	<b>0 571 016</b>		
		medium	Ø 12 / 6 mm	P 500	red	Ø 3 x 40 mm	2,800 rpm	<b>0 571 015</b>		
		extra fine	Ø 12 / 6 mm	P 800	white	Ø 3 x 40 mm	2,800 rpm	<b>0 571 014</b>		
<b>small brushes</b>										
	corundum	coarse	Ø 5 / 8 mm	P 320	blue/red	Ø 3 x 40 mm	6,000 rpm	<b>0 571 023</b>		
		medium	Ø 5 / 8 mm	P 500	blue/green	Ø 3 x 40 mm	6,000 rpm	<b>0 571 022</b>		
		fine	Ø 5 / 8 mm	P 600	blue	Ø 3 x 40 mm	6,000 rpm	<b>0 571 021</b>		
	SiC	coarse	Ø 5 / 8 mm	P 320	green	Ø 3 x 40 mm	6,000 rpm	<b>0 571 026</b>		
		medium	Ø 5 / 8 mm	P 500	red	Ø 3 x 40 mm	6,000 rpm	<b>0 571 025</b>		
		extra fine	Ø 5 / 8 mm	P 800	white	Ø 3 x 40 mm	6,000 rpm	<b>0 571 024</b>		
<b>wheel</b>										
	corundum	coarse	Ø 22 mm	P 320	blue/red	Ø 3 x 37 mm	6,000 rpm	<b>0 571 003</b>		
		medium	Ø 22 mm	P 500	blue/green	Ø 3 x 37 mm	6,000 rpm	<b>0 571 002</b>		
		fine	Ø 22 mm	P 600	blue	Ø 3 x 37 mm	6,000 rpm	<b>0 571 001</b>		
	SiC	coarse	Ø 22 mm	P 320	green	Ø 3 x 37 mm	6,000 rpm	<b>0 571 006</b>		
		medium	Ø 22 mm	P 500	red	Ø 3 x 37 mm	6,000 rpm	<b>0 571 005</b>		
		extra fine	Ø 22 mm	P 800	white	Ø 3 x 37 mm	6,000 rpm	<b>0 571 004</b>		



#### Matching mounting shanks on page 220:

- for discs Ø 19 mm: type 21, 22, 23, 24, 25, 26, 27
- for discs Ø 51 and 76 mm: type 41, 42

Note: 4 layers are bound together here to form a disc

## 2 Convolute compact grinding discs

### Convolute compact grinding discs

Wound, not pressed. These special grinding discs have been developed for the demanding preliminary and final processing of surfaces of the widest array of materials. They result from winding nylon fleece fabric around a hard core. Beforehand, the fabric is wetted with a special abrasive resin system. The winding results in a very uniform structure with which the direction of rotation must nevertheless be observed.

The discs are available in two abrasive finishes grit sizes in addition to three hardnesses.



#### The advantages:

- long service life
- consistent stock removal, dust-free
- highly resistant with only minor edge wear
- little contact heating
- no smearing of the surface
- rapid and easy profiling
- simple to use = efficient work
- optimally adapts to the workpiece
- no workpiece damage



#### Hardness grades

- 9 = extra hard
- 8 = hard
- 7 = medium/hard

		Dimensions	Drilling dimension	Hardness	Grit size	Rotation speed max.	Order No.	Price from 1 piece
<b>Convolute compact grinding discs</b>								
<b>Corundum</b>								
	The best choice for working on steel, aluminium, zinc, die-cast metal and brass.	Ø 150 x 12.5 mm	25.4 mm	8	A-Medium	5,500 rpm	<b>0 430 021</b>	
<b>Silicon carbide</b>								
	For final finishing on stainless steel, titanium, cobalt chrome and nickel alloys.	Ø 150 x 12.5 mm	25.4 mm	7	S-Fine	5,500 rpm	<b>0 430 031</b>	
		Ø 150 x 25.4 mm	25.4 mm	7	S-Fine	5,500 rpm	<b>0 430 033</b>	
		Ø 200 x 25.4 mm	76.2 mm	7	S-medium	4,500 rpm	<b>0 430 036</b>	
		Ø 200 x 25.4 mm	76.2 mm	7	S-Fine	4,500 rpm	<b>0 430 037</b>	
		Ø 200 x 25.4 mm	76.2 mm	9	S-medium	4,500 rpm	<b>0 430 040</b>	
		Ø 200 x 25.4 mm	76.2 mm	9	S-Fine	4,500 rpm	<b>0 430 041</b>	



#### Applications for the convolute compact grinding discs

Application	Specification	Recommended working speed
<b>Cleaning:</b> general cleaning, removal of rust, oxidation and slight scale, cleaning of pipe threads and slight casting burrs	6 S-Fine 7 S-Fine 8 S-Fine	11 – 32 m/sec.
<b>Deburring:</b> mouldings and milled parts, rounding of edges on metal parts, slight deburring of piston rings and other metal parts	7 S-Medium 8 S-Medium 9 S-Medium 9 S-Fine	28 – 41 m/sec.
<b>Overlaying:</b> turbine blades, preparation of surfaces before galvanising, forging flashes on turbine blades, overlaying sanding marks of grit size 60/80/120	7 S-Fine 8 A-Medium	28 – 41 m/sec.
<b>Final finishing:</b> satin finishing, finishing of aluminium parts, final surface finishing before coating, final finishing of cutlery, final finishing of hand-held tools before coating	S-Med finishing S-Fine finishing 8 S-Fine 9 S-Fine	2 – 15 m/sec.

## Polishing buffing discs OPTI for use on polishing machines

### Polishing buffing discs OPTI

These discs are used on stationary polishing machines in conjunction with solid polishing compounds (Dialux).

Available in two versions:


#### Cotton, soft:

- highly adaptable
- use for final polishing

#### Cotton, hard (quilted):

- very firm
- high stock removal rates
- highly dimensionally stable



	Head dimensions	Material	Drilling dimension	Rotation speed max.	Order No.	Price from 1 piece
<b>Polishing buffing discs OPTI</b>						
	Ø 200 x 20 mm	cotton, soft	15.9 mm	3,000 rpm	<b>0 041 622</b>	
		cotton, hard (quilted)	15.9 mm	3,000 rpm	<b>0 041 623</b>	
	Ø 250 x 25 mm	cotton, soft	20 mm	3,000 rpm	<b>0 041 632</b>	
		cotton, hard (quilted)	20 mm	3,000 rpm	<b>0 041 633</b>	

### The perfect complement

#### OPTI polish

The ideal polishing machine for fine machining

Order No.	Price
<b>0 041 620-0</b>	



### The perfect complement

#### Dialux polishing compound

- polishing compounds in "bar form"
- use up to finishing stage
- perfect for use with felts, brushes and buffers



Order No.	Price
<b>0 580 560</b>	

### The perfect complement

#### Protective goggles

- Clear, optically correct, scratchproof PC glasses
- Comfort cushions on the sidepiece ends
- Soft nose pad



Order No.	Price
<b>0 203 083-1</b>	

### The perfect complement

#### Universal-Spray joke X 73020

- Five products rolled into one: corrosion protection, cleaning, water repellence, lubrication and preservation
- Cleans surfaces and cares for tools



Order No.	Price
<b>0 580 526</b>	

## 2 Round brushes with nylon grinding bristles

### Round brushes with nylon grinding bristles





The nylon fibres of these brushes are interspersed with silicon carbide. The latter is constantly released during work and a highly even grinding effect with a highly uniform ground section is produced.

The nylon polishing bristles are extremely elastic and flexible and consequently absolutely unbreakable. The trimming area does not clog with work residues during deployment and the polishing effect remains constantly high throughout the entire working period. Suitable for wet and dry use.


#### Further advantages:

- long service life
- only very light contact pressure required
- low heat generation
- usable for clockwise and anticlockwise running
- suitable for machine and manual use



	Dimensions	Grit size	Drilling dimension	Rotation speed max.	Order No.	Price from	
						1 piece	3 pieces
<b>Round brushes with nylon grinding bristles (silicon-carbide-embedded)</b>							
	Ø 75 x 12 mm	K 80	15.9 mm	20,000 rpm	<b>0 571 370</b>		
		K 120	15.9 mm	20,000 rpm	<b>0 571 371</b>		
		K 180	15.9 mm	20,000 rpm	<b>0 571 372</b>		
		K 320	15.9 mm	20,000 rpm	<b>0 571 373</b>		
	Ø 100 x 13 mm	K 80	15.9 mm	12,000 rpm	<b>0 571 374</b>		
		K 120	15.9 mm	12,000 rpm	<b>0 571 375</b>		
		K 180	15.9 mm	12,000 rpm	<b>0 571 376</b>		
		K 320	15.9 mm	12,000 rpm	<b>0 571 377</b>		
	Ø 125 x 16 mm	K 80	15.9 mm	12,000 rpm	<b>0 571 378</b>		
		K 120	15.9 mm	12,000 rpm	<b>0 571 379</b>		
		K 180	15.9 mm	12,000 rpm	<b>0 571 380</b>		
		K 320	15.9 mm	12,000 rpm	<b>0 571 381</b>		
	Ø 150 x 18 mm	K 80	20 mm	6,000 rpm	<b>0 571 382</b>		
		K 120	20 mm	6,000 rpm	<b>0 571 383</b>		
		K 180	20 mm	6,000 rpm	<b>0 571 384</b>		
		K 320	20 mm	6,000 rpm	<b>0 571 385</b>		

### Accessories / spare parts

		for bore dimensions	Shank dimensions	Order No.	Price from 1 piece
<b>Clamping mandrel</b>					
	using this clamping mandrel, the round brushes Ø 75, 100 and 125 mm can be operated manually on the jokeFlex Power motor unit.	Ø 15.9 mm	Ø 6 x 40 mm	<b>0 571 400</b>	

# Drilling brushes **2**

## Drilling brushes

Do you often struggle with heavy burrs on tough materials? From now on, the odds will be in your favour, for we are providing you with the appropriate "weapon" in the form of these new brushes.

The special feature: triangular piano wire is used as the trimming, which is additionally twisted around its own axis.

The drilling brushes are available with three different head versions:

1. **Wire, oval:** for readily accessible transverse holes.
2. **Wire, crossed:** for transverse holes and end face processing in addition to non-concentric holes.
3. **Wire, knotted:** for transverse holes at the bottom of the blind hole. For removing very heavy burrs.

	Head dimensions	Trimming Ø	Shank dimensions	Total length	Rotation speed max.	Order No.	Price from		
							1 piece	3 pieces	5 pieces
<b>Drilling brushes</b>									
<b>Wire, crossed</b>									
	Ø 3 x 30 mm	Ø 0.7 mm	Ø 3 x 70 mm	100 mm	700 rpm	<b>0 571 721</b>			
	Ø 4 x 30 mm	Ø 0.7 mm	Ø 3 x 70 mm	100 mm	700 rpm	<b>0 571 722</b>			
	Ø 5 x 30 mm	Ø 0.7 mm	Ø 4 x 50 mm	100 mm	700 rpm	<b>0 571 723</b>			
	Ø 6 x 30 mm	Ø 0.7 mm	Ø 4 x 50 mm	100 mm	700 rpm	<b>0 571 724</b>			
	Ø 7 x 30 mm	Ø 0.7 mm	Ø 5 x 50 mm	100 mm	700 rpm	<b>0 571 725</b>			
	Ø 8 x 35 mm	Ø 0.7 mm	Ø 5 x 45 mm	100 mm	700 rpm	<b>0 571 726</b>			
<b>Wire, oval</b>									
	Ø 3 x 30 mm	Ø 0.7 mm	Ø 3 x 70 mm	100 mm	700 rpm	<b>0 571 701</b>			
	Ø 4 x 30 mm	Ø 0.7 mm	Ø 3 x 70 mm	100 mm	700 rpm	<b>0 571 702</b>			
	Ø 5 x 30 mm	Ø 0.7 mm	Ø 4 x 50 mm	100 mm	700 rpm	<b>0 571 703</b>			
	Ø 6 x 30 mm	Ø 0.7 mm	Ø 5 x 50 mm	100 mm	700 rpm	<b>0 571 704</b>			
	Ø 7 x 40 mm	Ø 0.7 mm	Ø 5 x 40 mm	100 mm	700 rpm	<b>0 571 705</b>			
	Ø 8 x 40 mm	Ø 0.7 mm	Ø 5 x 40 mm	100 mm	700 rpm	<b>0 571 706</b>			
	Ø 9 x 45 mm	Ø 0.7 mm	Ø 6 x 35 mm	100 mm	700 rpm	<b>0 571 707</b>			
<b>Wire, knotted</b>									
	Ø 5 x 30 mm	Ø 0.7 mm	Ø 4 x 50 mm	100 mm	700 rpm	<b>0 571 711</b>			
	Ø 6 x 30 mm	Ø 0.7 mm	Ø 4 x 50 mm	100 mm	700 rpm	<b>0 571 712</b>			
	Ø 7 x 30 mm	Ø 0.7 mm	Ø 5 x 50 mm	100 mm	700 rpm	<b>0 571 713</b>			
	Ø 8 x 30 mm	Ø 0.7 mm	Ø 5 x 50 mm	100 mm	700 rpm	<b>0 571 714</b>			
	Ø 9 x 30 mm	Ø 0.7 mm	Ø 6 x 50 mm	100 mm	700 rpm	<b>0 571 715</b>			
	Ø 10 x 30 mm	Ø 0.7 mm	Ø 6 x 50 mm	100 mm	700 rpm	<b>0 571 716</b>			
	Ø 11 x 30 mm	Ø 0.7 mm	Ø 6 x 50 mm	100 mm	700 rpm	<b>0 571 717</b>			

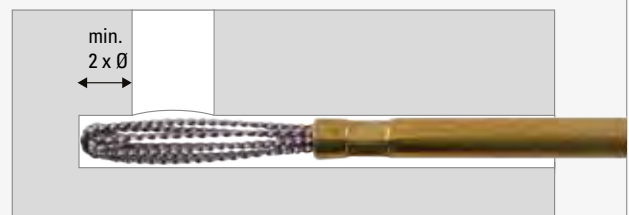


The drilling brushes are available with three different head versions:

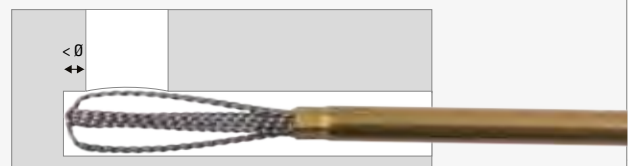
1. **Wire, oval:** for readily accessible transverse holes.



2. **Wire, crossed:** for transverse holes and end face processing in addition to non-concentric holes.



3. **Wire, knotted:** for transverse holes at the bottom of the blind hole. For removing very heavy burrs.





## 2 Jet brushes shaft with eyelets

### Jet brushes

The solution for inner cleaning, dust removal and varnish removal for jets, pipes, hoses, threaded holes, crossed holes, cylinders and much more.

Created for real men capable of driving the brushes with sheer muscle power. For those with less brute force, the brushes can also be inserted using a cordless screw driver. To do this, simply cut off the eyelets. The jet brushes are wound clockwise.

Available with nylon trimming and corrugated wire made of brass, steel or **stainless steel**.



- Processing of (cross) drill holes, jets, cylinders etc.
- Optimum for deburring, dust removal and varnish removal
- Drive by muscle power or machine (cordless screw driver)
- Available in four trimming versions





### A little thicker please!

For optimum results, select the following excess brush dimensions according to the drilling hole diameter:


- Drilling hole > 4 mm: approx. 10 – 15 %
- Drilling hole > 15 mm: approx. 20 – 25 %

							Price from						
							1 piece	10 pieces					
							Head dimensions	Trimming Ø	Shank dimensions	Total length	Order No.		
<b>Jet brushes, cylinders, shaft with eyelets</b>													
<b>nylon</b>													
	Excellent elasticity and durability. Resistant to solvents, but easily dissolved in acid. To shine, polish and clean. Possible to use with compounds.		Ø 2 x 100 mm	0.06 mm	Ø 1.4 x 200 mm	300 mm	<b>0 571 240</b>						
			Ø 3 x 100 mm	0.10 mm	Ø 1.6 x 200 mm	300 mm	<b>0 571 241</b>						
			Ø 4 x 100 mm	0.15 mm	Ø 1.4 x 200 mm	300 mm	<b>0 571 200</b>						
			Ø 5 x 100 mm	0.15 mm	Ø 1.8 x 200 mm	300 mm	<b>0 571 201</b>						
			Ø 6 x 100 mm	0.15 mm	Ø 1.8 x 200 mm	300 mm	<b>0 571 202</b>						
			Ø 8 x 100 mm	0.25 mm	Ø 2.6 x 200 mm	300 mm	<b>0 571 203</b>						
			Ø 10 x 100 mm	0.25 mm	Ø 2.6 x 200 mm	300 mm	<b>0 571 204</b>						
			Ø 12 x 100 mm	0.25 mm	Ø 2.6 x 200 mm	300 mm	<b>0 571 205</b>						
			Ø 15 x 100 mm	0.25 mm	Ø 2.6 x 200 mm	300 mm	<b>0 571 206</b>						
			Ø 18 x 100 mm	0.25 mm	Ø 2.6 x 200 mm	300 mm	<b>0 571 207</b>						
		Ø 20 x 100 mm	0.25 mm	Ø 2.6 x 200 mm	300 mm	<b>0 571 208</b>							
		Ø 25 x 100 mm	0.35 mm	Ø 3.2 x 200 mm	300 mm	<b>0 571 209</b>							
<b>Corrugated brass wire</b>													
	Silkier and softer grinding pattern than steel wires. Possible discolouration on workpiece. For polishing, descaling, deburring. Possible to use with and without compounds.		Ø 4 x 100 mm	0.08 mm	Ø 1.8 x 200 mm	300 mm	<b>0 571 210</b>						
			Ø 5 x 100 mm	0.08 mm	Ø 1.8 x 200 mm	300 mm	<b>0 571 211</b>						
			Ø 6 x 100 mm	0.15 mm	Ø 1.8 x 200 mm	300 mm	<b>0 571 212</b>						
			Ø 8 x 100 mm	0.15 mm	Ø 2.8 x 200 mm	300 mm	<b>0 571 213</b>						
			Ø 10 x 100 mm	0.15 mm	Ø 2.8 x 200 mm	300 mm	<b>0 571 214</b>						
			Ø 12 x 100 mm	0.15 mm	Ø 2.8 x 200 mm	300 mm	<b>0 571 215</b>						
			Ø 15 x 100 mm	0.15 mm	Ø 4.6 x 200 mm	300 mm	<b>0 571 216</b>						
			Ø 18 x 100 mm	0.15 mm	Ø 4.6 x 200 mm	300 mm	<b>0 571 217</b>						
			Ø 20 x 100 mm	0.20 mm	Ø 4.6 x 200 mm	300 mm	<b>0 571 218</b>						
			Ø 25 x 100 mm	0.20 mm	Ø 4.6 x 200 mm	300 mm	<b>0 571 219</b>						

## Jet brushes shaft with eyelets **2**

		Head dimensions	Trimming Ø	Shank dimensions	Total length	Order No.	Price from	
							1 piece	10 pieces
<b>Steel wire, corrugated</b>								
	Bendable and elastic wire which leaves a significantly visible grinding pattern on the work piece. For pre-polishing, descaling, deburring. Possible to use with and without compounds.	Ø 4 x 100 mm	0.10 mm	Ø 1.8 x 200 mm	300 mm	<b>0 571 220</b>		
		Ø 5 x 100 mm	0.10 mm	Ø 1.8 x 200 mm	300 mm	<b>0 571 221</b>		
		Ø 6 x 100 mm	0.10 mm	Ø 1.8 x 200 mm	300 mm	<b>0 571 222</b>		
		Ø 8 x 100 mm	0.15 mm	Ø 3.7 x 200 mm	300 mm	<b>0 571 223</b>		
		Ø 10 x 100 mm	0.15 mm	Ø 3.7 x 200 mm	300 mm	<b>0 571 224</b>		
		Ø 12 x 100 mm	0.15 mm	Ø 3.7 x 200 mm	300 mm	<b>0 571 225</b>		
		Ø 15 x 100 mm	0.15 mm	Ø 4.6 x 200 mm	300 mm	<b>0 571 226</b>		
		Ø 18 x 100 mm	0.15 mm	Ø 4.6 x 200 mm	300 mm	<b>0 571 227</b>		
		Ø 20 x 100 mm	0.20 mm	Ø 4.6 x 200 mm	300 mm	<b>0 571 228</b>		
		Ø 25 x 100 mm	0.20 mm	Ø 4.6 x 200 mm	300 mm	<b>0 571 229</b>		
<b>Stainless steel wire, corrugated</b>								
	Comparable with steel wire but resistant to acids and alkalis. More break resistant than steel. Can also be used with water and leaves no rust residues on the material. For pre-polishing, descaling, deburring especially for stainless steels and aluminium. With and without compounds.	Ø 4 x 100 mm	0.10 mm	Ø 1.8 x 200 mm	300 mm	<b>0 571 230</b>		
		Ø 5 x 100 mm	0.10 mm	Ø 1.8 x 200 mm	300 mm	<b>0 571 231</b>		
		Ø 6 x 100 mm	0.10 mm	Ø 1.8 x 200 mm	300 mm	<b>0 571 232</b>		
		Ø 8 x 100 mm	0.15 mm	Ø 1.8 x 200 mm	300 mm	<b>0 571 233</b>		
		Ø 10 x 100 mm	0.15 mm	Ø 3.7 x 200 mm	300 mm	<b>0 571 234</b>		
		Ø 12 x 100 mm	0.15 mm	Ø 3.7 x 200 mm	300 mm	<b>0 571 235</b>		
		Ø 15 x 100 mm	0.15 mm	Ø 4.6 x 200 mm	300 mm	<b>0 571 236</b>		
		Ø 18 x 100 mm	0.15 mm	Ø 4.6 x 200 mm	300 mm	<b>0 571 237</b>		
		Ø 20 x 100 mm	0.15 mm	Ø 4.6 x 200 mm	300 mm	<b>0 571 238</b>		

## Jet brushes stainless steel shank with eyelets

		Head dimensions	Trimming Ø	Shank dimensions	Total length	Order No.	Price from	
							1 piece	10 pieces
<b>Jet brush, cylinder, stainless steel shank with eyelets</b>								
<b>nylon</b>								
	Very good elasticity, durability and resistance to solvents. For shining, polishing and cleaning. Can be used with compounds. What is special about these jet brushes is the stainless steel shank. This ensures that no corrosion forms when used with water.	2 x 100 mm	0.08 mm	Ø 0.93 x 200 mm	300 mm	<b>0 571 801</b>		
		3 x 100 mm	0.10 mm	Ø 1.50 x 200 mm	300 mm	<b>0 571 802</b>		
		4 x 100 mm	0.10 mm	Ø 2.22 x 200 mm	300 mm	<b>0 571 803</b>		
		5 x 100 mm	0.10 mm	Ø 2.22 x 200 mm	300 mm	<b>0 571 804</b>		
		6 x 100 mm	0.10 mm	Ø 2.22 x 200 mm	300 mm	<b>0 571 805</b>		
		8 x 100 mm	0.15 mm	Ø 2.22 x 200 mm	300 mm	<b>0 571 806</b>		
		10 x 100 mm	0.15 mm	Ø 2.22 x 200 mm	300 mm	<b>0 571 807</b>		
		12 x 100 mm	0.15 mm	Ø 2.22 x 200 mm	300 mm	<b>0 571 808</b>		
		20 x 100 mm	0.15 mm	Ø 2.96 x 200 mm	300 mm	<b>0 571 809</b>		
		30 x 100 mm	0.30 mm	Ø 3.33 x 200 mm	300 mm	<b>0 571 810</b>		
		40 x 100 mm	0.30 mm	Ø 3.70 x 200 mm	300 mm	<b>0 571 811</b>		
		60 x 100 mm	0.30 mm	Ø 3.70 x 200 mm	300 mm	<b>0 571 812</b>		
		100 x 100 mm	0.30 mm	Ø 4.62 x 200 mm	300 mm	<b>0 571 813</b>		




## 2 Pipe brushes nylon with silicon carbide

### Pipe brushes

Pipe brushes are ideally suited for deburring and cleaning work in crossways drillings and insertions. The flexible trimming made of nylon or steel prevents breakage of the material even with the highest stress and deformation.

The pipe brushes are available in four different versions:

- nylon standard with silicon carbide
- nylon standard with corundum
- nylon-diamond
- steel without additional abrasive.

	Abrasive	Head dimensions	Grit size	Shank dimensions	Total length	Rotation speed max.	Order No.	Price from
								1 piece 10 pieces
<b>Nylon silicon carbide pipe brushes</b>								
<b>SiC</b>								
 <p>Using nylon pipe brushes smooths the surface and positively influences the latter for subsequent use. The twisted wire is zinc-coated. Linear use by hand and clockwise in machines.</p>	SiC	Ø 0.7 x 12 mm	K 1000	Ø 0.42 mm	100 mm	700 rpm	<b>0 571 101</b>	
	SiC	Ø 1.2 x 12 mm	K 1000	Ø 0.47 mm	100 mm	700 rpm	<b>0 571 102</b>	
	SiC	Ø 1.9 x 18 mm	K 1000	Ø 0.74 mm	100 mm	700 rpm	<b>0 571 103</b>	
	SiC	Ø 2.2 x 18 mm	K 1000	Ø 0.94 mm	100 mm	700 rpm	<b>0 571 104</b>	
	SiC	Ø 2.6 x 25 mm	K 1000	Ø 1.08 mm	100 mm	700 rpm	<b>0 571 105</b>	
	SiC	Ø 3.2 x 25 mm	K 1000	Ø 1.66 mm	100 mm	700 rpm	<b>0 571 106</b>	
	SiC	Ø 3.5 x 25 mm	K 1000	Ø 1.66 mm	100 mm	700 rpm	<b>0 571 107</b>	
<b>Nylon-corundum pipe brushes</b>								
<b>corundum</b>								
<p>Using nylon pipe brushes smooths the surface and positively influences the latter for subsequent use. The twisted wire is zinc-coated. Linear use by hand and clockwise in machines.</p>	Corundum	Ø 4.2 x 25 mm	K 600	Ø 2.2 mm	125 mm	700 rpm	<b>0 571 108</b>	
	Corundum	Ø 4.8 x 25 mm	K 600	Ø 2.2 mm	125 mm	700 rpm	<b>0 571 109</b>	
	Corundum	Ø 5.5 x 25 mm	K 600	Ø 2.2 mm	125 mm	700 rpm	<b>0 571 110</b>	
	Corundum	Ø 6.6 x 25 mm	K 600	Ø 3 mm	125 mm	700 rpm	<b>0 571 111</b>	
	Corundum	Ø 8.2 x 25 mm	K 600	Ø 3 mm	125 mm	700 rpm	<b>0 571 112</b>	
	Corundum	Ø 9.8 x 25 mm	K 600	Ø 3.4 mm	125 mm	700 rpm	<b>0 571 113</b>	
	Corundum	Ø 11.5 x 25 mm	K 600	Ø 3.4 mm	125 mm	700 rpm	<b>0 571 114</b>	
	Corundum	Ø 13.0 x 25 mm	K 600	Ø 4.2 mm	125 mm	700 rpm	<b>0 571 115</b>	
	Corundum	Ø 16.0 x 25 mm	K 600	Ø 4.2 mm	125 mm	700 rpm	<b>0 571 116</b>	
	Corundum	Ø 17.5 x 25 mm	K 600	Ø 4.2 mm	125 mm	700 rpm	<b>0 571 117</b>	
	Corundum	Ø 19.4 x 25 mm	K 600	Ø 5.6 mm	125 mm	700 rpm	<b>0 571 118</b>	
	Corundum	Ø 22.6 x 25 mm	K 600	Ø 5.6 mm	125 mm	700 rpm	<b>0 571 119</b>	
	Corundum	Ø 25.8 x 25 mm	K 600	Ø 6.2 mm	125 mm	700 rpm	<b>0 571 120</b>	



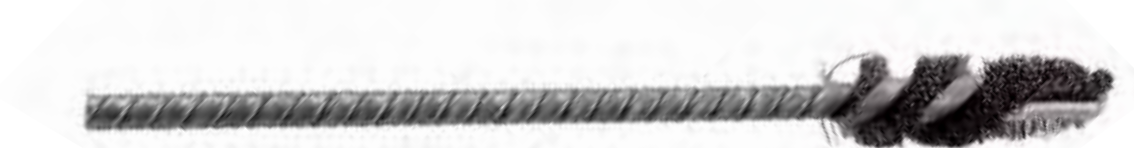
## Pipe brushes nylon with diamond

	Abrasive	Head dimensions	Grit size	Shank dimensions	Total length	Rotation speed max.	Order No.	Price from	
								1 piece	3 pieces
<b>Nylon-diamond pipe brushes</b>									
<b>Diamond</b>									
By the use of industrial diamonds, eminently suitable for processing tungsten carbide. The shank in zinccoated twisted wire is additionally stabilised with a brass bush for brushes of Ø 4 mm and more. Suitable for manual and machine use.	Diamond	Ø 2 x 20 mm	K 400	Ø 1 mm	100 mm	700 rpm	<b>0 571 121</b>		
		Ø 2,5 x 20 mm	K 400	Ø 1 mm	100 mm	700 rpm	<b>0 571 122</b>		
		Ø 3 x 20 mm	K 400	Ø 1.5 mm	100 mm	700 rpm	<b>0 571 123</b>		
		Ø 3,5 x 20 mm	K 400	Ø 1.5 mm	100 mm	700 rpm	<b>0 571 124</b>		
		Ø 4 x 20 mm	K 400	Ø 3 mm	115 mm	700 rpm	<b>0 571 125</b>		
		Ø 5 x 20 mm	K 400	Ø 3 mm	115 mm	700 rpm	<b>0 571 126</b>		
		Ø 6 x 20 mm	K 400	Ø 3 mm	115 mm	700 rpm	<b>0 571 127</b>		
		Ø 7 x 20 mm	K 400	Ø 3 mm	115 mm	700 rpm	<b>0 571 128</b>		
		Ø 8 x 20 mm	K 400	Ø 3 mm	115 mm	700 rpm	<b>0 571 129</b>		
		Ø 9 x 20 mm	K 400	Ø 3 mm	115 mm	700 rpm	<b>0 571 130</b>		
		Ø 10 x 20 mm	K 400	Ø 4 mm	115 mm	700 rpm	<b>0 571 131</b>		
		Ø 12 x 20 mm	K 400	Ø 6 mm	115 mm	700 rpm	<b>0 571 132</b>		



## Pipe brushes steel

	Trimming	Head dimensions	Trimming Ø	Shank dimensions	Total length	Rotation speed max.	Order No.	Price from	
								1 piece	10 pieces
<b>Steel pipe brushes</b>									
Brushes with steel trimming without additional abrasive. Ideal for simple deburring work.	Steel	Ø 6 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 rpm	<b>0 571 170</b>		
		Ø 8 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 rpm	<b>0 571 171</b>		
		Ø 10 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 rpm	<b>0 571 172</b>		
		Ø 11 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 rpm	<b>0 571 173</b>		
		Ø 13 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 rpm	<b>0 571 174</b>		
		Ø 14 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 rpm	<b>0 571 175</b>		
		Ø 16 x 25 mm	0.13 mm	Ø 3.18 mm	89 mm	700 rpm	<b>0 571 176</b>		



# 2 Nylon honing brushes Novoflex-B

### Nylon honing brushes Novoflex-B

An innovative tool for perfect results on surfaces or in bores. These silicon carbide abrasive balls have a flexible arrangement and therefore adapt to the processed surface – even in non-concentric bores.

These brushes are useful for example for removing burr on all common materials. The Novoflex-B honing brushes leave a cross-grinding on the surface, which is the perfect carrier for an possible oil film. The surface is free from cold-shaped or deformed material.

The only „hardware“ you need to work with these brushes is a conventional hand drill. Honing machines or cordless screwdrivers can be used for serial production.

#### Possible applications:

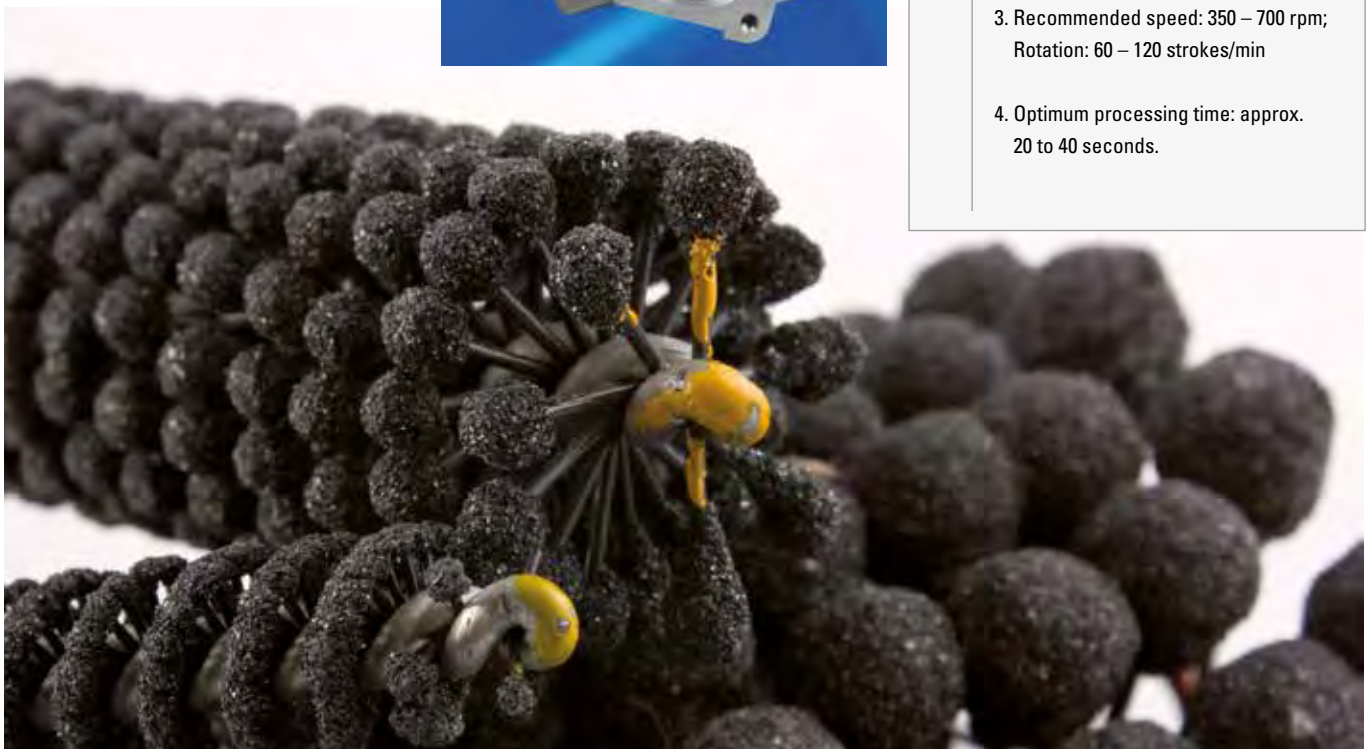
- Motor cylinders
- Drive rods
- Bores on shafts and crank levers
- Pneumatic and hydraulic cylinders
- Valve guides
- Compressed air units
- Wheel brake cylinders
- Brake control cylinders
- Pipes and hoses
- Many more applications in the automotive, aeronautics and aerospace construction and in the firearms industry.



**Tip:** jet and pipe brushes are best suited for bores < 8 mm (see pages 194 and 196)!




#### Important points for the use of Novoflex-B nylon honing brushes?

1. Always choose the brush diameter according to the bore. If the desired brush size is not available, use the next larger one.
2. Always use the brushes with oil with a viscosity between 10 and 30 or with special honing oil. We also recommend joke lubricant X 73012.
3. Recommended speed: 350 – 700 rpm;  
Rotation: 60 – 120 strokes/min
4. Optimum processing time: approx. 20 to 40 seconds.



# Nylon honing brushes Novoflex-B

2

	for bore dimensions	Head dimensions	Grit size	Shank dimensions	Total length	Order No.	Price from 1 piece
<b>Nylon honing brushes Novoflex-B</b>							
	Ø 8 mm	Ø 9 x 50 mm	120	Ø 3.7 mm	200 mm	<b>0 571 300</b>	
		Ø 9 x 50 mm	180	Ø 3.6 mm	200 mm	<b>0 571 330</b>	
	Ø 10 mm	Ø 11 x 60 mm	120	Ø 3.7 mm	200 mm	<b>0 571 301</b>	
		Ø 11 x 60 mm	180	Ø 3.6 mm	200 mm	<b>0 571 331</b>	
	Ø 11 mm	Ø 12 x 60 mm	120	Ø 3.7 mm	200 mm	<b>0 571 302</b>	
		Ø 12 x 60 mm	180	Ø 3.6 mm	200 mm	<b>0 571 332</b>	
	Ø 12 mm	Ø 13 x 60 mm	120	Ø 3.7 mm	200 mm	<b>0 571 303</b>	
		Ø 13 x 60 mm	180	Ø 3.6 mm	200 mm	<b>0 571 333</b>	
	Ø 14 mm	Ø 15.5 x 60 mm	120	Ø 3.7 mm	200 mm	<b>0 571 304</b>	
		Ø 15.5 x 60 mm	180	Ø 3.6 mm	200 mm	<b>0 571 334</b>	
	Ø 16 mm	Ø 18 x 60 mm	120	Ø 4.6 mm	200 mm	<b>0 571 305</b>	
		Ø 18 x 60 mm	180	Ø 4.6 mm	200 mm	<b>0 571 335</b>	
	Ø 18 mm	Ø 20 x 60 mm	120	Ø 4.6 mm	200 mm	<b>0 571 306</b>	
		Ø 20 x 60 mm	180	Ø 4.6 mm	200 mm	<b>0 571 336</b>	
	Ø 20 mm	Ø 22 x 70 mm	120	Ø 4.6 mm	200 mm	<b>0 571 307</b>	
		Ø 22 x 70 mm	180	Ø 4.6 mm	200 mm	<b>0 571 337</b>	
	Ø 22 mm	Ø 25 x 70 mm	120	Ø 4.6 mm	200 mm	<b>0 571 308</b>	
		Ø 25 x 70 mm	180	Ø 4.6 mm	200 mm	<b>0 571 338</b>	
	Ø 24 mm	Ø 27 x 70 mm	120	Ø 5.1 mm	200 mm	<b>0 571 309</b>	
		Ø 27 x 70 mm	180	Ø 5.1 mm	200 mm	<b>0 571 339</b>	
	Ø 25 mm	Ø 28 x 70 mm	120	Ø 5.1 mm	200 mm	<b>0 571 310</b>	
		Ø 28 x 70 mm	180	Ø 5.1 mm	200 mm	<b>0 571 340</b>	
	Ø 27 mm	Ø 30 x 70 mm	120	Ø 5.1 mm	200 mm	<b>0 571 311</b>	
		Ø 30 x 70 mm	180	Ø 5.1 mm	200 mm	<b>0 571 341</b>	
	Ø 29 mm	Ø 32 x 70 mm	120	Ø 5.1 mm	200 mm	<b>0 571 312</b>	
		Ø 32 x 70 mm	180	Ø 5.1 mm	200 mm	<b>0 571 342</b>	
	Ø 32 mm	Ø 35 x 70 mm	120	Ø 5.1 mm	200 mm	<b>0 571 313</b>	
		Ø 35 x 70 mm	180	Ø 5.7 mm	200 mm	<b>0 571 343</b>	
	Ø 35 mm	Ø 38 x 70 mm	120	Ø 5.7 mm	200 mm	<b>0 571 314</b>	
		Ø 38 x 70 mm	180	Ø 5.7 mm	200 mm	<b>0 571 344</b>	
	Ø 38 mm	Ø 41 x 70 mm	120	Ø 5.7 mm	200 mm	<b>0 571 315</b>	
		Ø 41 x 70 mm	180	Ø 5.7 mm	200 mm	<b>0 571 345</b>	
	Ø 42 mm	Ø 45 x 70 mm	120	Ø 5.7 mm	200 mm	<b>0 571 316</b>	
		Ø 45 x 70 mm	180	Ø 5.7 mm	200 mm	<b>0 571 346</b>	
	Ø 45 mm	Ø 48 x 70 mm	120	Ø 5.7 mm	200 mm	<b>0 571 317</b>	
		Ø 48 x 70 mm	180	Ø 5.7 mm	200 mm	<b>0 571 347</b>	


**In order to avoid blunders...**

...the honing brushes are colour-coded to distinguish between the grit sizes:

Grit 120 = yellow

Grit 180 = red



1

2

3

4

5

6

7



# Grinding points






























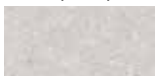






























The maximum permissible speeds depending on the cutting speed:

$\emptyset$	$V_c$ 35 m/s	$V_c$ 50 m/s
4 mm	170,000 rpm	240,000 rpm
6 mm	110,000 rpm	160,000 rpm
8 mm	80,000 rpm	120,000 rpm
10 mm	65,000 rpm	95,000 rpm
12 mm	55,000 rpm	80,000 rpm
20 mm	33,000 rpm	47,000 rpm

# Grinding points Overview **2**

-  very well suited
-  suitable

	Cast iron, malleable cast iron	Steel, cast steel	Alloyed/hardened and tempered steels	High and highest alloyed steels	Welding seams on alloyed and non-alloyed steels	Hardened tool steels	Hard chrome-plated steels	Titanium, cobalt and nickel alloys	Glass/ceramic/carbide metal	Aluminium/soft non-ferrous metals
<b>AWCO grinding points</b>  <b>202</b>										
<b>Aluminium oxide fibre grinding points</b>  <b>204</b>										
<b>Silicon carbide for aluminium (SiC-Alu)</b>  <b>206</b>										
<b>High-grade corundum pink (EKR)</b>  <b>207</b>										
<b>High-grade corundum white-brown (EKWbr)</b>  <b>212</b>										
<b>High-grade corundum white (EKW)</b>  <b>212</b>										
<b>High-grade corundum dark red (EKD)</b>  <b>213</b>										
<b>Blue Stones</b>  <b>214</b>										
<b>NORTON</b>  <b>215</b>										
<b>VORTEX</b>  <b>216</b>										
<b>Fibre-laminated grinding and polishing points</b>  <b>220</b>										



## 2 Grinding points AWCO















### shank Ø 3 x 30 mm, hardness J

#### Grinding points AWCO

The ideal points for regrinding repair weldings, Produced from ceramic bond with a mixture of white high-grade corundum and blue ceramic sintered corundum, This material combination results in extraordinarily high chip removal rates with an excellent service life,

#### The advantages:

- cool cutting owing to friability of the grit mixture
- high stock removal rates with a very good service life
- self-sharpening effect of the sintered corundum for consistent stock removal rates

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max,	Order No,	Price from		
							1 piece	20 pieces	50 pieces
<b>AWCO grinding points, shank Ø 3 x 30 mm</b>									
<b>cylinder</b>									
	Ø 1 x 5 mm	J	320	Ø 3 x 30 mm	50 m/s	<b>0 542 421</b>			
	Ø 1,5 x 8 mm	J	320	Ø 3 x 30 mm	50 m/s	<b>0 542 422</b>			
	Ø 1,7 x 8 mm	J	320	Ø 3 x 30 mm	50 m/s	<b>0 542 423</b>			
	Ø 2 x 5 mm	J	80	Ø 3 x 30 mm	50 m/s	<b>0 542 424</b>			
	Ø 3 x 6 mm	J	80	Ø 3 x 30 mm	50 m/s	<b>0 542 427</b>			
	Ø 3 x 6 mm	J	120	Ø 3 x 30 mm	50 m/s	<b>0 542 428</b>			
	Ø 4 x 8 mm	J	60	Ø 3 x 30 mm	50 m/s	<b>0 542 429</b>			
	Ø 4 x 8 mm	J	80	Ø 3 x 30 mm	50 m/s	<b>0 542 430</b>			
	Ø 4 x 8 mm	J	100	Ø 3 x 30 mm	50 m/s	<b>0 542 431</b>			
	Ø 5 x 10 mm	J	60	Ø 3 x 30 mm	50 m/s	<b>0 542 432</b>			
	Ø 5 x 10 mm	J	80	Ø 3 x 30 mm	50 m/s	<b>0 542 433</b>			
	Ø 5 x 10 mm	J	100	Ø 3 x 30 mm	50 m/s	<b>0 542 434</b>			
	Ø 6 x 13 mm	J	60	Ø 3 x 30 mm	50 m/s	<b>0 542 436</b>			
	Ø 8 x 16 mm	J	46	Ø 3 x 30 mm	50 m/s	<b>0 542 439</b>			
	Ø 8 x 16 mm	J	60	Ø 3 x 30 mm	50 m/s	<b>0 542 440</b>			
	Ø 8 x 16 mm	J	80	Ø 3 x 30 mm	50 m/s	<b>0 542 441</b>			
<b>sphere</b>									
	Ø 3 mm	J	80	Ø 3 x 30 mm	50 m/s	<b>0 542 447</b>			
	Ø 6 mm	J	80	Ø 3 x 30 mm	50 m/s	<b>0 542 449</b>			
	Ø 8 mm	J	80	Ø 3 x 30 mm	50 m/s	<b>0 542 452</b>			
<b>wheel</b>									
	Ø 13 x 3 mm	J	60	Ø 3 x 30 mm	50 m/s	<b>0 542 443</b>			
	Ø 20 x 6 mm	J	46	Ø 3 x 30 mm	50 m/s	<b>0 542 444</b>			
	Ø 20 x 6 mm	J	60	Ø 3 x 30 mm	50 m/s	<b>0 542 445</b>			
<b>tree with pointed end</b>									
	Ø 3 x 6 mm	J	80	Ø 3 x 30 mm	50 m/s	<b>0 542 455</b>			
	Ø 4 x 8 mm	J	80	Ø 3 x 30 mm	50 m/s	<b>0 542 458</b>			

 *matching set*

	Order No,	Price from 1 set
<b>Set of grinding points AWCO</b>		

The set consists of the twelve grinding points with a shank Ø 3 x 40 mm

**0 542 420**



# Grinding points AWCO




## Ø 6 x 40 mm, hardness J

### Grinding points AWCO


The ideal points for regrinding repair weldings, Produced from ceramic bond with a mixture of white high-grade corundum and blue ceramic sintered corundum, This material combination results in extraordinarily high chip removal rates with an excellent service life,

#### The advantages:

- cool cutting owing to friability of the grit mixture
- high stock removal rates with a very good service life
- self-sharpening effect of the sintered corundum for consistent stock removal rates

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max,	Order No,	Price from		
							1 piece	20 pieces	50 pieces
<b>AWCO grinding points, shank Ø 6 x 40 mm</b>									
<b>cylinder</b>									
	↓ Ø 8 x 16 mm	J	46	Ø 6 x 40 mm	50 m/s	<b>0 542 471</b>			
	↓ Ø 10 x 13 mm	J	46	Ø 6 x 40 mm	50 m/s	<b>0 542 473</b>			
	↓ Ø 10 x 20 mm	J	46	Ø 6 x 40 mm	50 m/s	<b>0 542 475</b>			
	↓ Ø 13 x 25 mm	J	46	Ø 6 x 40 mm	50 m/s	<b>0 542 477</b>			
	↓ Ø 16 x 20 mm	J	46	Ø 6 x 40 mm	50 m/s	<b>0 542 479</b>			
	↓ Ø 16 x 32 mm	J	46	Ø 6 x 40 mm	50 m/s	<b>0 542 481</b>			
	↓ Ø 20 x 25 mm	J	46	Ø 6 x 40 mm	50 m/s	<b>0 542 483</b>			
	↓ Ø 20 x 40 mm	J	46	Ø 6 x 40 mm	50 m/s	<b>0 542 485</b>			
<b>sphere</b>									
	↓ Ø 13 mm	J	46	Ø 6 x 40 mm	50 m/s	<b>0 542 491</b>			
<b>tree with pointed end</b>									
	↓ Ø 13 x 20 mm	J	46	Ø 6 x 40 mm	50 m/s	<b>0 542 494</b>			

### ↓ matching set

	Order No,	Price from
		1 set
<b>Set of grinding points AWCO</b>		
	The set consists of ten grinding points with a grit size of 46 and a shank Ø 6 x 40 mm	<b>0 542 470</b>



- optimally suited to reworking repair weldings
- finishing of turbine blades or similar components
- special grit mixture for high stock removal and long service life

**i Right diameter but wrong grit size?**  
 Many other grit sizes on request,  
 Please consult **Markus Abstoß:**  
 +49 22 04 839-0 • [m.abstoss@joke.de](mailto:m.abstoss@joke.de)

## 2 Aluminium oxide fibre grinding points shank $\varnothing$ 3 x 30 mm



### Aluminium oxide fibre grinding points

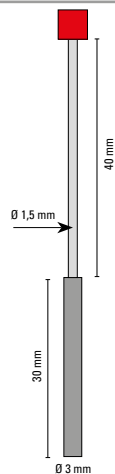
- Deburring and chamfering of cross holes
- Removing burr at the bottom of blind holes
- Precision removal of fine burr
- Self-sharpening without grinding dust
- High edge stability and dimensional stability for extended service life
- Elastic shank with high bending radius (2 mm)
- Range of different grit sizes
- Versatile application areas
- Use by hand and machine (processing centres, special machines, drilling machines, with robots, etc.)



Head dimensions	Collar dimensions	Grit size	Colour	Shank dimensions	Rotation speed max,	Order No.	Price from
							1 piece 3 pieces 5 pieces

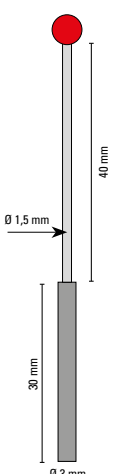
### Aluminium oxide fibre grinding points, shank $\varnothing$ 3 mm, 70 mm

#### cylinder



$\varnothing$ 3 x 3 mm	$\varnothing$ 1,5 x 40 mm	# 220	grey	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 181</b>
	$\varnothing$ 1,5 x 40 mm	# 400	orange	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 182</b>
	$\varnothing$ 1,5 x 40 mm	# 800	blue	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 183</b>
$\varnothing$ 4 x 4 mm	$\varnothing$ 1,5 x 40 mm	# 220	grey	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 184</b>
	$\varnothing$ 1,5 x 40 mm	# 400	orange	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 185</b>
	$\varnothing$ 1,5 x 40 mm	# 800	blue	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 186</b>
$\varnothing$ 5 x 5 mm	$\varnothing$ 1,5 x 40 mm	# 220	grey	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 187</b>
	$\varnothing$ 1,5 x 40 mm	# 400	orange	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 188</b>
	$\varnothing$ 1,5 x 40 mm	# 800	blue	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 189</b>

#### sphere



$\varnothing$ 3 mm	$\varnothing$ 1,5 x 40 mm	# 220	grey	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 161</b>
	$\varnothing$ 1,5 x 40 mm	# 400	orange	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 162</b>
	$\varnothing$ 1,5 x 40 mm	# 800	blue	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 163</b>
$\varnothing$ 4 mm	$\varnothing$ 1,5 x 40 mm	# 220	grey	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 164</b>
	$\varnothing$ 1,5 x 40 mm	# 400	orange	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 165</b>
	$\varnothing$ 1,5 x 40 mm	# 800	blue	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 166</b>
$\varnothing$ 5 mm	$\varnothing$ 1,5 x 40 mm	# 220	grey	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 167</b>
	$\varnothing$ 1,5 x 40 mm	# 400	orange	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 168</b>
	$\varnothing$ 1,5 x 40 mm	# 800	blue	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 169</b>
$\varnothing$ 6 mm	$\varnothing$ 1,5 x 40 mm	# 220	grey	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 170</b>
	$\varnothing$ 1,5 x 40 mm	# 400	orange	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 171</b>
	$\varnothing$ 1,5 x 40 mm	# 800	blue	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 172</b>
$\varnothing$ 10 mm	$\varnothing$ 1,5 x 40 mm	# 220	grey	$\varnothing$ 3 x 30 mm	6,000 rpm	<b>0 425 173</b>

## Aluminium oxide fibre grinding points extra long version

**NEW!**


Extra long version, total length 150 mm

	Head dimensions	Grit size	Colour	Shank dimensions	Rotation speed max,	Order No,	Price from		
							1 piece	3 pieces	5 pieces
<b>Aluminium oxide fibre grinding points, 150 mm</b>									
<b>sphere</b>									
	Ø 3 mm	# 220	grey	Ø 3,0 mm	6,000 rpm	<b>0 425 161-1</b>			
	Ø 4 mm	# 220	grey	Ø 2,35 mm	6,000 rpm	<b>0 425 164-1</b>			
	Ø 5 mm	# 220	grey	Ø 2,35 mm	6,000 rpm	<b>0 425 167-1</b>			
	Ø 6 mm	# 220	grey	Ø 2,35 mm	6,000 rpm	<b>0 425 170-1</b>			
	Ø 10 mm	# 220	grey	Ø 2,35 mm	6,000 rpm	<b>0 425 173-1</b>			

## Aluminium oxide fibre grinding disc

	Head dimensions	Grit size	Colour	Rotation speed max,	Order No,	Price from		
						1 piece	3 pieces	5 pieces
<b>Aluminium oxide fibre grinding disc</b>								
<b>wheel</b>								
	Ø 14 mm	# 220	grey	6,000 rpm	<b>0 425 175</b>			



### Accessories / spare parts

	Order No,	Price from		
		1 piece	3 pieces	5 pieces
<b>Shank with screw</b>				
	<b>0 425 175-0</b>			



## 2 Grinding points SiC-Alu shank Ø 3 x 30 mm and 6 x 40 mm

### Grinding points SiC-Alu

These grinding points were especially developed for processing aluminium. The high plasticity of aluminium means that if the wrong grinding points are used, "smearing" and "clogging" of the tool occurs,

Owing to their special structural configuration, extremely long service lives are achieved, as the pores of the points do not become clogged during processing. The selfsharpening effect is enhanced by the special impregnation of these grinding points,


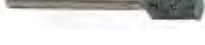





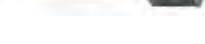
### Particularly suitable for:

- non-ferrous metals (especially aluminium)
- hard-chromium plated steels
- high and highest-alloyed steels


### Also suitable for:

- tempered and hardened steels
- soft non-ferrous metals







	Head dimensions	Grit size	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	Price from		
							1 piece	20 pieces	50 pieces
<b>SiC-Alu grinding points, shank Ø 3 x 30 mm</b>									
<b>cylinder</b>									
	Ø 4 x 8 mm	80	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 542 501</b>			
	Ø 5 x 10 mm	80	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 542 502</b>			
	Ø 6 x 10 mm	80	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 542 503</b>			
	Ø 8 x 10 mm	80	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 542 504</b>			
	Ø 10 x 10 mm	80	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 542 505</b>			
<b>SiC-Alu grinding points, shank Ø 6 x 40 mm</b>									
<b>cylinder</b>									
	Ø 10 x 13 mm	80	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 506</b>			
	Ø 16 x 32 mm	80	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 511</b>			
	Ø 20 x 25 mm	80	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 513</b>			









### matching set

	Grit size	Order No,	Price from
			1 set
<b>Set of grinding points SiC-Alu</b>			
	K 80	<b>0 542 530</b>	
The set consists of the following five cylindrical grinding points with a grit size of SiC 80, shank Ø 3 x 30 mm:			
<ul style="list-style-type: none"> <li>• Cylinder, Ø 4 x 8 mm (order no, 0 542 501)</li> <li>• Cylinder, Ø 5 x 10 mm (order no, 0 542 502)</li> <li>• Cylinder, Ø 6 x 10 mm (order no, 0 542 503)</li> <li>• Cylinder, Ø 8 x 10 mm (order no, 0 542 504)</li> <li>• Cylinder, Ø 10 x 10 mm (order no, 0 542 505)</li> </ul>			
The grinding points are particularly suitable for processing aluminium and hard chrome-plated steels as well as high-alloy and ultra high alloy steels, They are also suitable for annealed and hardened steels and for soft non-ferrous metals,			

## Grinding points EKR shank Ø 2,35 x 40 mm, hardness N

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	Price from		
								1 piece	20 pieces	50 pieces
<b>EKR grinding points, shank Ø 2,35 x 40 mm</b>										
<b>cylinder</b>										
	Ø 2 x 5 mm	N	120	Ø 2,35 x 40 mm	50 m/s	10 pieces	<b>0 542 101</b>			
	Ø 3 x 6 mm	N	100	Ø 2,35 x 40 mm	50 m/s	10 pieces	<b>0 542 102</b>			
<b>wheel</b>										
	Ø 10 x 3 mm	N	100	Ø 2,35 x 40 mm	50 m/s	10 pieces	<b>0 542 107</b>			
<b>sphere</b>										
	Ø 5 mm	N	100	Ø 2,35 x 40 mm	50 m/s	10 pieces	<b>0 542 114</b>			















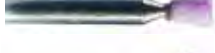








## Grinding points EKR shank Ø 3 x 30 mm, hardness N

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	Price from		
								1 piece	20 pieces	50 pieces
<b>EKR grinding points, shank Ø 3 x 30 mm</b>										
<b>cylinder</b>										
	Ø 2 x 5 mm	N	120	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 542 131</b>			
	Ø 2,5 x 6 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 540 922</b>			
	Ø 3 x 6 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 542 132</b>			
	Ø 4 x 8 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 542 133</b>			
	Ø 5 x 6 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 540 923</b>			
	Ø 5 x 10 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 542 134</b>			
	Ø 6 x 6 mm	N	60	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 540 924</b>			
	Ø 6 x 10 mm	N	60	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 542 135</b>			













## 2 Grinding points EKR

shank  $\varnothing 3 \times 30$  mm, hardness N

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	1 piece	Price from 20 pieces	50 pieces
<b>pointed cylinder</b>										
	$\varnothing 5 \times 7$ mm	N	100	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 932</b>			
	$\varnothing 8 \times 10$ mm	N	100	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 542 140</b>			
<b>wheel</b>										
	$\varnothing 4 \times 1$ mm	N	100	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 904</b>			
	$\varnothing 5 \times 3$ mm	N	80	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 905</b>			
	$\varnothing 8 \times 2$ mm	N	100	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 903</b>			
	$\varnothing 9 \times 2$ mm	N	100	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 901</b>			
	$\varnothing 9 \times 3$ mm	N	80	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 902</b>			
	$\varnothing 10 \times 5$ mm	N	100	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 542 139</b>			
<b>conical</b>										
	$\varnothing 3,3 / 2,2 \times 6,4$ mm	N	100	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 929</b>			
	$\varnothing 4,4 / 3 \times 10$ mm	N	100	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 930</b>			
	$\varnothing 7 / 3,5 \times 6$ mm	N	80	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 906</b>			
<b>cone</b>										
	$\varnothing 6 \times 11$ mm	N	80	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 936</b>			
	$\varnothing 8 \times 8$ mm	N	100	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 542 149</b>			
	$\varnothing 10 \times 10$ mm	N	100	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 542 150</b>			
<b>trapeze</b>										
	$\varnothing 3,2 / 2 \times 4$ mm	N	100	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 910</b>			
	$\varnothing 5 / 2 \times 2,5$ mm	N	100	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 907</b>			
	$\varnothing 5 / 3 \times 5$ mm	N	80	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 911</b>			
	$\varnothing 7 / 5 \times 6$ mm	N	80	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 912</b>			
	$\varnothing 8 / 3,5 \times 4$ mm	N	80	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 909</b>			
<b>tree with pointed end</b>										
	$\varnothing 4,3 \times 7$ mm	N	100	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 934</b>			
	$\varnothing 5 \times 10$ mm	N	80	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 542 147</b>			
	$\varnothing 6 \times 8$ mm	N	80	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 933</b>			
	$\varnothing 6 \times 10$ mm	N	80	$\varnothing 3 \times 30$ mm	50 m/s	10 pieces	<b>0 540 935</b>			

## Grinding points EKR shank Ø 3 x 30 mm, hardness N

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	Price from		
								1 piece	20 pieces	50 pieces
<b>barrel</b>										
	Ø 4 x 5 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 540 917</b>			
	Ø 6 x 8 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 540 918</b>			
<b>rhombus</b>										
	Ø 7 x 5 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 540 920</b>			
<b>mushroom</b>										
	Ø 8 x 1,6 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 540 921</b>			
<b>sphere</b>										
	Ø 3 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 540 913</b>			
	Ø 4 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 540 914</b>			
	Ø 5 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 540 915</b>			
	Ø 8 mm	N	80	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 542 145</b>			
	Ø 10 mm	N	60	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 542 146</b>			
<b>wheel</b>										
	Ø 5 x 1,5 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 540 925</b>			
	Ø 6 x 2,5 mm	N	100	Ø 3 x 30 mm	50 m/s	10 pieces	<b>0 540 926</b>			





 *matching set*

	Order No,	Price from
<b>Set of grinding points EKR</b>		1 set
Content: 36 pieces	<b>0 540 900</b>	







## 2 Grinding points EKR

### shank Ø 6 x 40 mm, hardness N

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	Price from		
								1 piece	20 pieces	50 pieces
<b>EKR grinding points, shank Ø 6 x 40 mm</b>										
<b>cylinder</b>										
	Ø 4 x 8 mm	N	80	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 702</b>			
	Ø 5 x 10 mm	N	80	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 703</b>			
	Ø 6 x 10 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 704</b>			
	Ø 8 x 10 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 705</b>			
	Ø 8 x 16 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 706</b>			
	Ø 10 x 10 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 707</b>			
	Ø 10 x 20 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 708</b>			
	Ø 13 x 13 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 710</b>			
	Ø 13 x 20 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 711</b>			
	Ø 16 x 16 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 712</b>			
	Ø 16 x 20 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 713</b>			
	Ø 16 x 32 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 714</b>			
	Ø 20 x 20 mm	N	36	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 715</b>			
	Ø 20 x 25 mm	N	36	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 716</b>			
Ø 20 x 40 mm	N	36	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 718</b>				
<b>sphere</b>										
	Ø 8 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 747</b>			
	Ø 10 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 736</b>			
	Ø 16 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 738</b>			
	Ø 20 mm	N	36	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 739</b>			
<b>cone</b>										
	Ø 16 x 32 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 742</b>			
	Ø 16 x 40 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 743</b>			
	Ø 20 x 32 mm	N	36	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 744</b>			
	Ø 20 x 40 mm	N	36	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 745</b>			
<b>wheel</b>										
	Ø 25 x 6 mm	N	60	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 728</b>			
	Ø 32 x 8 mm	N	46	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 730</b>			
	Ø 40 x 10 mm	N	30	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 731</b>			
	Ø 40 x 20 mm	N	30	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 724</b>			

## Grinding points EKR

shank Ø 3 x 40/60 mm, hardness N • Shanks made from rustproof steel

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	Price from		
								1 piece	20 pieces	50 pieces
<b>EKR grinding points, shank Ø 3 x 40 mm, rustproof steel</b>										
<b>cylinder</b>										
	Ø 2 x 5 mm	N	60	Ø 3 x 40 mm	35 m/s	10 pieces	<b>0 542 651</b>			
	Ø 3 x 5 mm	N	60	Ø 3 x 40 mm	35 m/s	10 pieces	<b>0 542 652</b>			
	Ø 4 x 8 mm	N	60	Ø 3 x 40 mm	35 m/s	10 pieces	<b>0 542 653</b>			
		N	60	Ø 3 x 60 mm	35 m/s	10 pieces	<b>0 542 663</b>			
	Ø 5 x 10 mm	N	60	Ø 3 x 40 mm	35 m/s	10 pieces	<b>0 542 654</b>			
		N	60	Ø 3 x 60 mm	35 m/s	10 pieces	<b>0 542 664</b>			
	Ø 6 x 10 mm	N	60	Ø 3 x 40 mm	35 m/s	10 pieces	<b>0 542 655</b>			
		N	60	Ø 3 x 60 mm	35 m/s	10 pieces	<b>0 542 665</b>			
	Ø 7 x 10 mm	N	60	Ø 3 x 40 mm	35 m/s	10 pieces	<b>0 542 656</b>			
Ø 7 x 70 mm	N	60	Ø 3 x 60 mm	35 m/s	10 pieces	<b>0 542 666</b>				
<b>sphere</b>										
	Ø 5 mm	N	60	Ø 3 x 60 mm	35 m/s	10 pieces	<b>0 542 677</b>			
	Ø 6 mm	N	60	Ø 3 x 60 mm	35 m/s	10 pieces	<b>0 542 678</b>			
<b>cone</b>										
	Ø 6 x 10 mm	N	60	Ø 3 x 60 mm	35 m/s	10 pieces	<b>0 542 680</b>			
<b>tree with pointed end</b>										
	Ø 3 x 6 mm	N	60	Ø 3 x 60 mm	35 m/s	10 pieces	<b>0 542 679</b>			




### Why rustproof shanks?

These points have shanks made of rustproof steel, They are mainly used in the food and chemical industry,

## Blowing pen






### A must for every workplace!

Possibly the smallest blowing pen in the world, It weighs a mere 20 g and regulates the compressed air perfectly, The small aperture of 3 mm ensures that the air really only goes where it should, A must for every workplace!

	Order No,	Price from
		1 piece
<b>Blowing pen</b>		
		<b>0 203 200</b>
For direct connection to a rapid coupling system, Dimensions: Ø 12,5 x 108 mm Weight: 20 g		


## 2 Grinding points EKWbr

shank Ø 3 x 30 mm, hardness O/P

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	Price from		
								1 piece	20 pieces	50 pieces
<b>EKWbr grinding points, shank Ø 3 x 30 mm</b>										
<b>cylinder</b>										
	Ø 3 x 6 mm	O/P	100	Ø 3 x 30 mm	35 m/s	10 pieces	<b>0 542 401</b>			
	Ø 4 x 8 mm	O/P	80	Ø 3 x 30 mm	35 m/s	10 pieces	<b>0 542 402</b>			
	Ø 5 x 10 mm	O/P	80	Ø 3 x 30 mm	35 m/s	10 pieces	<b>0 542 403</b>			
	Ø 6 x 10 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	<b>0 542 404</b>			
	Ø 8 x 10 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	<b>0 542 405</b>			
	Ø 10 x 10 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	<b>0 542 406</b>			
	Ø 10 x 13 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	<b>0 542 407</b>			
	Ø 10 x 15 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	<b>0 542 408</b>			
	Ø 13 x 13 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	<b>0 542 409</b>			
	Ø 13 x 16 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	<b>0 542 410</b>			
<b>wheel</b>										
	Ø 16 x 4 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	<b>0 542 413</b>			
	Ø 20 x 6 mm	O/P	60	Ø 3 x 30 mm	35 m/s	10 pieces	<b>0 542 414</b>			

## Grinding points EKW

shank Ø 3 x 40 mm, hardness N

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	Price from		
								1 piece	20 pieces	50 pieces
<b>EKW grinding points, shank Ø 3 x 40 mm</b>										
<b>cylinder</b>										
	Ø 2 x 5 mm	N	80	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 601</b>			
	Ø 3 x 5 mm	N	80	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 602</b>			
	Ø 4 x 8 mm	N	80	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 603</b>			
	Ø 5 x 10 mm	N	80	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 604</b>			
	Ø 6 x 10 mm	N	80	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 605</b>			
	Ø 7 x 10 mm	N	80	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 606</b>			

# Grinding points EKD

shank Ø 3 x 40 mm, hardness N

**2**

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	Price from		
								1 piece	20 pieces	50 pieces
<b>EKD grinding points, shank Ø 3 x 40 mm</b>										
<b>cylinder</b>										
	Ø 2 x 5 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 331</b>			
	Ø 4 x 8 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 332</b>			
	Ø 5 x 10 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 333</b>			
	Ø 8 x 10 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 334</b>			
<b>pointed cylinder</b>										
	Ø 7 x 12 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 340</b>			
<b>rounded cylinder</b>										
	Ø 3 x 6 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 347</b>			
	Ø 4 x 8 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 348</b>			
	Ø 6 x 10 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 341</b>			
	Ø 6 x 12 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 342</b>			
<b>wheel</b>										
	Ø 10 x 2 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 336</b>			
	Ø 10 x 5 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 337</b>			
<b>mushroom</b>										
	Ø 10 x 2 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 338</b>			
<b>cone</b>										
	Ø 5 x 10 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 339</b>			
<b>sphere</b>										
	Ø 5 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 344</b>			
	Ø 8 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 345</b>			
	Ø 10 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 346</b>			
<b>cone</b>										
	Ø 8 x 8 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 349</b>			
	Ø 10 x 10 mm	N	100	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 542 350</b>			

*matching set*












Set of grinding points EKD	Order No,	Price from
		1 set
Content: 18 pieces	<b>0 542 330</b>	





## 2 Grinding points Blue Stones

shank  $\varnothing$  3 x 40 mm, hardness QU

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	1 piece	Price from	20 pieces	50 pieces
<b>Blue Stones grinding points, shank <math>\varnothing</math> 3 x 40 mm</b>											
<b>cylinder</b>											
	$\varnothing$ 2 x 5 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 778</b>				
	$\varnothing$ 3 x 6 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 779</b>				
	$\varnothing$ 4 x 8 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 780</b>				
	$\varnothing$ 5 x 6 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 781</b>				
	$\varnothing$ 5 x 10 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 782</b>				
	$\varnothing$ 6 x 6 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 783</b>				
	$\varnothing$ 6 x 10 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 784</b>				
	$\varnothing$ 8 x 10 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 785</b>				
	$\varnothing$ 10 x 10 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 786</b>				
<b>wheel</b>											
	$\varnothing$ 8 x 1,6 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 788</b>				
	$\varnothing$ 13 x 3 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 789</b>				
	$\varnothing$ 13 x 6 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 790</b>				
<b>tree with pointed end</b>											
	$\varnothing$ 3 x 6 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 774</b>				
	$\varnothing$ 5 x 10 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 773</b>				
<b>sphere</b>											
	$\varnothing$ 3 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 775</b>				
	$\varnothing$ 5 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 776</b>				
	$\varnothing$ 6 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 777</b>				
<b>rounded arch</b>											
	$\varnothing$ 6 x 10 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 772</b>				
<b>pointed cone</b>											
	$\varnothing$ 6 x 10 mm	QU	120	$\varnothing$ 3 x 40 mm	50 m/s	10 pieces	<b>0 542 771</b>				





 *matching set*

	Grit size	Order No,	Price from
<b>Set of grinding points Blue Stones</b>			1 set
	Content: 19 pieces	K 120	<b>0 542 770</b>




## Grinding points Blue Stones

shank Ø 6 x 40 mm, hardness QU

	Head dimensions	Hardness	Grit size	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	Price from		
								1 piece	20 pieces	50 pieces
<b>Blue Stones grinding points, shank Ø 6 x 40 mm</b>										
<b>cylinder</b>										
	Ø 8 x 10 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 813</b>			
	Ø 10 x 20 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 816</b>			
<b>sphere</b>										
	Ø 8 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 818</b>			
	Ø 10 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 819</b>			
	Ø 13 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 820</b>			
<b>tree with pointed end</b>										
	Ø 6 x 13 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 822</b>			
<b>cone</b>										
	Ø 8 x 10 mm	QU	120	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 542 824</b>			


 *matching set*

		Grit size	Order No,	Price from
				1 set
<b>Set of grinding points Blue Stones</b>				
	Contents: 8 pieces:	K 120	<b>0 542 810</b>	
	0 542 813 cylinder, 0 542 816 cylinder 2x, 0 542 818 sphere, 0 542 819 sphere, 0 542 820 sphere, 0 542 822 ogive, 0 542 824 cone			

## Grinding points NORTON

shank Ø 3 / 6 x 40 mm, soft

Suitable for all metals, ideal for softer materials such as aluminium, Perfect in postprocessing for 3D printed aluminium parts

	Head dimensions	Hardness	Grit size	Colour	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	Price from		
									1 piece	20 pieces	50 pieces
<b>NORTON grinding points, shank Ø 3 mm</b>											
<b>cylinder</b>											
	Ø 6 x 12 mm	soft	fine	grey	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 571 911</b>			
	Ø 10 x 12 mm	soft	fine	grey	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 571 910</b>			
	Ø 20 x 25 mm	soft	fine	grey	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 571 912</b>			

## 2 Compact discs VORTEX Unitized for manual and machine use

### Compact discs VORTEX Unitized

A new dimension in deburring and uniform finishing – particularly on materials that are difficult to process,

The patented grit of these discs results in an up to twice as high, very aggressive stock removal in comparison to conventional discs, with improved results on the workpiece,

#### The advantages at a glance:

- more rapid stock removal, shortened throughput times, optimised quality
- cool cut
- maximum service lives: consistent stock removal performance from the beginning to the end of the disc
- usable for a wide range of shapes and contours



	Bonding	Dimensions	Drilling dimension	Order No,	Price from	
					1 piece	10 pieces
<b>Compact discs VORTEX Unitized</b>						
	soft	Ø 75 x 3 mm	6,3 mm	<b>0 545 681</b>		
	hard	Ø 50 x 6 mm	6,3 mm	<b>0 545 680</b>		
		Ø 75 x 3 mm	6,3 mm	<b>0 545 682</b>		
		Ø 75 x 12 mm	6,3 mm	<b>0 545 683</b>		
		Ø 150 x 6 mm	25,4 mm	<b>0 545 684</b>		

### ⚙️ Accessories / spare parts

	for bore dimensions	Shank dimensions	Type	Max, disc size	Order No,	Price from	
						1 piece	10 pieces
<b>CRATEX® grinding wheel holder</b>							
	Ø 1/4" / Ø 6,3 mm	Ø 6 x 40 mm	32	Ø 75 x 20 mm	<b>0 545 297</b>		

**NEW!**

## Sanding rod with bevelled edge for linear processing in combination with a hand file machine


	Order No,	Price from
		1 piece
<b>Sanding rod with bevelled edge</b>		
10 x 10 x 40 mm, shank- Ø 3 x 40 mm	<b>0 571 938</b>	




## Grinding wheels VORTEX Rapid with quick change system

Patented grain technology combined with improved synthetic resin system prevents rapid clogging, Up to 8 x longer lifetime than other surface finishing discs,

Suitable for the following materials:  
stainless steel, carbon steels, aluminium

Grinding wheels VORTEX Rapid	Dimensions	Grit size	Packing quantity	Order No,	Price from	
					1 pack	3 packs
	Ø 50 mm	medium	25 pieces	<b>0 545 697</b>		
	Ø 75 mm	medium	25 pieces	<b>0 545 698</b>		

### Accessories / spare parts

Grinding disc holder TR	Dimensions	Order No,	Price from	
			1 piece	3 pieces
	Ø 50 mm	<b>0 545 699</b>		
	Ø 75 mm	<b>0 545 700</b>		

**NEW!** 

## Grinding discs VORTEX blue on shaft

Grinding disc on VORTEX blue shaft	Order No,	Price from	
		1 piece	50 pieces
VORTEX® blue disc on rubber carrier, shaft Ø 3 x 26 mm	<b>0 571 935</b>		



## 2 Grinding points VORTEX® shank Ø 3 x 40 mm, hard

### VORTEX®-blue grinding points

The grinding points are ideally suited for processing hard materials that are difficult to machine, such as titanium, Inconel, etc. The patented high performance grit is ideal for rapid stock removal and reduces processing times,

The following versions are available:

• Wheel • Cylinder • Ball

Packaging unit: 10 pieces | Colour: blue

	Head dimensions	Hardness	Grit size	Colour	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	1 piece	Price from	20 pieces	50 pieces
<b>VORTEX®-blue grinding points, shank Ø 3 x 40 mm</b>												
<b>wheel</b>												
	Ø 25 x 3 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 571 904</b>				
	Ø 30 x 3 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 571 900</b>				
<b>cylinder</b>												
	Ø 5 x 12 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 571 901</b>				
	Ø 6 x 13 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 571 902</b>				
	Ø 10 x 12 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 571 903</b>				
<b>sphere</b>												
	Ø 6 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 571 926</b>				
	Ø 8 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 571 927</b>				
	Ø 10 mm	hard	coarse	blue	Ø 3 x 40 mm	50 m/s	10 pieces	<b>0 571 928</b>				

### ↓ matching set

	Order No,	Price from
<b>Set of grinding points VORTEX®-blue</b>		1 set
The set consists of the following five coarse-grit, hard grinding points with a shank Ø 3 x 40 mm:		<b>0 571 915</b>
• Wheel, Ø 25 x 3 mm (order no, 0 571 904)		
• Wheel, Ø 30 x 3 mm (order no, 0 571 900)		
• Cylinder, Ø 5 x 13 mm (order no, 0 571 901)		
• Cylinder, Ø 6 x 13 mm (order no, 0 571 902)		
• Cylinder, Ø 10 x 12 mm (order no, 0 571 903)		





# Grinding points VORTEX®

## Grinding points VORTEX® shank Ø 6 x 40 mm, hard




### VORTEX®-blue grinding points

The grinding points are ideally suited for processing hard materials that are difficult to machine, such as titanium, Inconel, etc. The patented high performance grit is ideal for rapid stock removal and reduces processing times,

The following versions are available:

- Wheel • Cylinder • Ball

Packaging unit: 10 pieces | Colour: blue

	Head dimensions	Hardness	Grit size	Colour	Shank dimensions	Cutting speed max,	Packing quantity	Order No,	1 piece	Price from 20 pieces	50 pieces
<b>VORTEX®-blue grinding points, shank Ø 6 x 40 mm</b>											
<b>cylinder</b>											
	Ø 10 x 20 mm	hard	coarse	blue	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 571 920</b>			
	Ø 13 x 20 mm	hard	coarse	blue	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 571 921</b>			
	Ø 20 x 25 mm	hard	coarse	blue	Ø 6 x 40 mm	50 m/s	10 pieces	<b>0 571 922</b>			

↓ *matching set*

	Order No,	Price from 1 set
<b>Set of grinding points VORTEX® blue</b>		
The set consists of the following three coarse-grit, hard grinding points with a shank Ø 6 x 40 mm: <ul style="list-style-type: none"> <li>• Cylinder, Ø 10 x 20 mm (order no, 0 571 920)</li> <li>• Cylinder, Ø 13 x 20 mm (order no, 0 571 921)</li> <li>• Cylinder, Ø 20 x 25 mm (order no, 0 571 922)</li> </ul>	<b>0 571 925</b>	





## 2 Fibre-laminated grinding and polishing points

### shank Ø 3 x 40 mm









#### Fibre-laminated grinding and polishing points

These fibre-laminated grinding points produce excellent surfaces with high stock removal, The tools do not clog, offer a very good service life, grind and polish simultaneously and are vibration-free, They are ideal for hard chromium plated steels and have proved their worth with all difficult steels in aeronautical, motor and plant construction, The points are available in two bonding strengths and different grit sizes:

**Hard:** Aggressive for high stock removal and fine surfaces,



**Soft:** Polishing with low stock removal and deburring,

Vmax 30 m/s

	Head dimensions	Bonding	Grit size	Shank dimensions	Order No,	Price from		
						1 piece	10 pieces	20 pieces
<b>Fibre-laminated grinding points, corundum, shank Ø 3 x 40 mm</b>								
<b>cylinder</b>								
	Ø 6 x 6 mm	hard	80	Ø 3 x 40 mm	<b>0 545 611</b>			
		soft	80	Ø 3 x 40 mm	<b>0 545 612</b>			
		soft	180	Ø 3 x 40 mm	<b>0 545 613</b>			
	Ø 6 x 13 mm	hard	80	Ø 3 x 40 mm	<b>0 545 614</b>			
		soft	80	Ø 3 x 40 mm	<b>0 545 615</b>			
		soft	180	Ø 3 x 40 mm	<b>0 545 616</b>			
	Ø 10 x 19 mm	hard	54	Ø 3 x 40 mm	<b>0 545 617</b>			
		hard	80	Ø 3 x 40 mm	<b>0 545 618</b>			
		soft	80	Ø 3 x 40 mm	<b>0 545 619</b>			
		soft	180	Ø 3 x 40 mm	<b>0 545 620</b>			
	Ø 13 x 13 mm	hard	80	Ø 3 x 40 mm	<b>0 545 621</b>			
		soft	80	Ø 3 x 40 mm	<b>0 545 622</b>			
		soft	180	Ø 3 x 40 mm	<b>0 545 623</b>			
<b>sphere</b>								
	Ø 6 mm	hard	80	Ø 3 x 40 mm	<b>0 545 658</b>			
	Ø 6,5 mm	soft	80	Ø 3 x 40 mm	<b>0 545 647</b>			
	Ø 8 mm	hard	80	Ø 3 x 40 mm	<b>0 545 659</b>			
	Ø 13 mm	soft	80	Ø 3 x 40 mm	<b>0 545 609</b>			
		hard	80	Ø 3 x 40 mm	<b>0 545 627</b>			
		soft	180	Ø 3 x 40 mm	<b>0 545 610</b>			
<b>pointed cone</b>								
	Ø 10 x 19 mm	hard	54	Ø 3 x 40 mm	<b>0 545 605</b>			
		soft	80	Ø 3 x 40 mm	<b>0 545 607</b>			
		hard	80	Ø 3 x 40 mm	<b>0 545 606</b>			
		soft	180	Ø 3 x 40 mm	<b>0 545 608</b>			
<b>cone</b>								
	Ø 13 x 19 mm	hard	54	Ø 3 x 40 mm	<b>0 545 601</b>			
		soft	80	Ø 3 x 40 mm	<b>0 545 603</b>			
		hard	80	Ø 3 x 40 mm	<b>0 545 602</b>			
		soft	180	Ø 3 x 40 mm	<b>0 545 604</b>			
<b>sphere</b>								
	Ø 13 mm	hard	54	Ø 3 x 40 mm	<b>0 545 626</b>			

## Fibre-laminated grinding and polishing points shank $\varnothing$ 3 x 40 mm

matching set

	Grit size	Order No,	Price from 1 set
<b>Set of grinding points, fibre-laminated</b>			
 <p>This range contains following seven hard bonded fibre-laminated polishing points in grit size 80, shank dimensions 3 x 40mm:</p> <ul style="list-style-type: none"> <li>• Cylinder, <math>\varnothing</math> 6 x 6 mm (order no, 0 545 611)</li> <li>• Cylinder, <math>\varnothing</math> 6 x 13 mm (order no, 0 545 614)</li> <li>• Cylinder, <math>\varnothing</math> 10 x 19 mm (order no, 0 545 618)</li> <li>• Cylinder, <math>\varnothing</math> 13 x 13 mm (order no, 0 545 621)</li> <li>• Sphere, <math>\varnothing</math> 13 mm (order no, 0 545 627)</li> <li>• Pointed Cone, <math>\varnothing</math> 10 x 19 mm (order no, 0 545 606)</li> <li>• Cone, <math>\varnothing</math> 13 x 19 mm (order no, 0 545 602)</li> </ul> <p>These polishing points are suitable for fine surfaces due to a high material removal,</p>	K 80	<b>0 545 695</b>	
 <p>This range contains following seven soft bonded fibre-laminated polishing points in grit size 80, shank dimensions 3 x 40 mm:</p> <ul style="list-style-type: none"> <li>• Cylinder, <math>\varnothing</math> 6 x 6 mm (order no, 0 545 612)</li> <li>• Cylinder, <math>\varnothing</math> 6 x 13 mm (order no, 0 545 615)</li> <li>• Cylinder, <math>\varnothing</math> 10 x 19 mm (order no, 0 545 619)</li> <li>• Cylinder, <math>\varnothing</math> 13 x 13 mm (order no, 0 545 622)</li> <li>• Sphere, <math>\varnothing</math> 13 mm (order no, 0 545 609)</li> <li>• Pointed Cone, <math>\varnothing</math> 10 x 19 mm (order no, 0 545 607)</li> <li>• Cone, <math>\varnothing</math> 13 x 19 mm (order no, 0 545 603)</li> </ul> <p>These polishing points are suitable for polishing aluminium and for deburring due to a low material removal,</p>	K 80	<b>0 545 690</b>	



# Rubber-bonded grinding tools

**223 Rubber-bonded polishing points**

**225 Elastic polishing points**

**228 Elastic grinding files**

**229 Rubber-bonded grinding tools  
CERA Sticks**

**230 Tool system CRATEX®**

Rubber-bonded tools are the right choice wherever the highest demands are placed on the polished section and the latter's dimensional stability. A wide selection of these can be found with us: polishing points on a shank (rubber-bonded, elastic and fibrelaminated), rubber-bonded grinding discs, in addition to compact discs and of course the CRATEX® tool system, which has been tried and trusted for decades.















# Rubber-bonded polishing points series 700

## hard rubber bonding • shank Ø 3 x 30 mm


### Rubber-bonded polishing points series 700

Thanks to their hard rubber bond and corundum grit combination, these fine grinding and polishing tools with hard rubber bonding are particularly suited for very fine grinding, equally for cast iron, hardened or unhardened, alloy or nonalloy steels as well as all other materials to be ground. These tools do not clog, do not smear and deliver high efficiency with medium grinding pressure.

Cutting speed Vmax: 50 m/s

	Head dimensions	Grit size	Shank dimensions	Order No.	Price from		
					1 piece	20 pieces	50 pieces
<b>Rubber-bonded polishing points series 700, shank Ø 3 x 30 mm</b>							
<b>hard rubber bonding</b>							
<b>cylinder</b>							
	Ø 4 x 8 mm	100	Ø 3 x 30 mm	<b>0 544 701</b>			
	Ø 5 x 10 mm	100	Ø 3 x 30 mm	<b>0 544 702</b>			
	Ø 6 x 10 mm	100	Ø 3 x 30 mm	<b>0 544 703</b>			
	Ø 7 x 10 mm	100	Ø 3 x 30 mm	<b>0 544 704</b>			
	Ø 8 x 10 mm	100	Ø 3 x 30 mm	<b>0 544 705</b>			
	Ø 10 x 10 mm	100	Ø 3 x 30 mm	<b>0 544 706</b>			
	Ø 10 x 13 mm	100	Ø 3 x 30 mm	<b>0 544 707</b>			
	Ø 10 x 16 mm	100	Ø 3 x 30 mm	<b>0 544 708</b>			
	Ø 13 x 3 mm	100	Ø 3 x 30 mm	<b>0 544 712</b>			
	Ø 13 x 13 mm	100	Ø 3 x 30 mm	<b>0 544 709</b>			
	Ø 13 x 16 mm	100	Ø 3 x 30 mm	<b>0 544 710</b>			
	Ø 16 x 4 mm	100	Ø 3 x 30 mm	<b>0 544 713</b>			
	Ø 16 x 16 mm	100	Ø 3 x 30 mm	<b>0 544 715</b>			
	Ø 20 x 6 mm	100	Ø 3 x 30 mm	<b>0 544 714</b>			

 *matching set*


	Grit size	Order No.	Price from
<b>Rubber-bonded polishing points series 700, shank Ø 3 mm, 14 pieces</b>			
	Set contains all head sizes 1x each	100	<b>0 544 700</b>

## 2 Rubber-bonded polishing points series 720

### soft rubber bonding, shank $\varnothing$ 3 x 30 mm


#### Rubber-bonded polishing points series 720

The special features of the soft rubber bond of the series 720 is an extremely soft cut, high surface quality and very low stock removal of the corundum grit. The outstanding elasticity of the soft rubber bond results in a relatively low cutting speed for the vibration-free operation. **Cutting speed Vmax: 15 m/s**


	Head dimensions	Grit size	Colour	Shank dimensions	Order No.	Price from		
						1 piece	20 pieces	50 pieces
<b>Rubber-bonded polishing points series 720, shank <math>\varnothing</math> 3 x 30 mm &amp; 3 x 60 mm</b>								
<b>soft rubber bonding</b>								
<b>sphere</b>								
	$\varnothing$ 5 mm	120	red	$\varnothing$ 3 x 30 mm	<b>0 544 760</b>			
			120	red	$\varnothing$ 3 x 60 mm	<b>0 544 727</b>		
	$\varnothing$ 8 mm	120	red	$\varnothing$ 3 x 30 mm	<b>0 544 767</b>			
		120	red	$\varnothing$ 3 x 60 mm	<b>0 544 726</b>			
	$\varnothing$ 10 mm	120	red	$\varnothing$ 3 x 30 mm	<b>0 544 768</b>			
	$\varnothing$ 10 mm	120	red	$\varnothing$ 3 x 60 mm	<b>0 544 725</b>			
$\varnothing$ 13 mm	120	red	$\varnothing$ 3 x 30 mm	<b>0 544 719</b>				
<b>cylinder</b>								
	$\varnothing$ 4 x 8 mm	80	grey	$\varnothing$ 3 x 30 mm	<b>0 544 731</b>			
		120	red	$\varnothing$ 3 x 30 mm	<b>0 544 751</b>			
		220	brown	$\varnothing$ 3 x 30 mm	<b>0 544 771</b>			
		280	green	$\varnothing$ 3 x 30 mm	<b>0 544 791</b>			
	$\varnothing$ 5 x 10 mm	400	white	$\varnothing$ 3 x 30 mm	<b>0 544 930</b>			
		600	light pink	$\varnothing$ 3 x 30 mm	<b>0 544 931</b>			
		80	grey	$\varnothing$ 3 x 30 mm	<b>0 544 732</b>			
		120	red	$\varnothing$ 3 x 30 mm	<b>0 544 752</b>			
		220	brown	$\varnothing$ 3 x 30 mm	<b>0 544 772</b>			
	$\varnothing$ 6 x 10 mm	280	green	$\varnothing$ 3 x 30 mm	<b>0 544 792</b>			
		80	grey	$\varnothing$ 3 x 30 mm	<b>0 544 733</b>			
		120	red	$\varnothing$ 3 x 30 mm	<b>0 544 753</b>			
		220	brown	$\varnothing$ 3 x 30 mm	<b>0 544 773</b>			
	$\varnothing$ 8 x 10 mm	280	green	$\varnothing$ 3 x 30 mm	<b>0 544 793</b>			
		400	white	$\varnothing$ 3 x 30 mm	<b>0 544 933</b>			
		600	light pink	$\varnothing$ 3 x 30 mm	<b>0 544 934</b>			
		80	grey	$\varnothing$ 3 x 30 mm	<b>0 544 734</b>			
		120	red	$\varnothing$ 3 x 30 mm	<b>0 544 754</b>			
	$\varnothing$ 8 x 10 mm	220	brown	$\varnothing$ 3 x 30 mm	<b>0 544 774</b>			
		280	green	$\varnothing$ 3 x 30 mm	<b>0 544 794</b>			
		400	white	$\varnothing$ 3 x 30 mm	<b>0 544 936</b>			
		600	light pink	$\varnothing$ 3 x 30 mm	<b>0 544 937</b>			
		80	grey	$\varnothing$ 3 x 30 mm	<b>0 544 735</b>			
	$\varnothing$ 10 x 10 mm	120	red	$\varnothing$ 3 x 30 mm	<b>0 544 755</b>			
		220	brown	$\varnothing$ 3 x 30 mm	<b>0 544 775</b>			
		280	green	$\varnothing$ 3 x 30 mm	<b>0 544 795</b>			
		80	grey	$\varnothing$ 3 x 30 mm	<b>0 544 736</b>			
	$\varnothing$ 13 x 13 mm	120	red	$\varnothing$ 3 x 30 mm	<b>0 544 756</b>			
		220	brown	$\varnothing$ 3 x 30 mm	<b>0 544 776</b>			
		280	green	$\varnothing$ 3 x 30 mm	<b>0 544 796</b>			
		80	grey	$\varnothing$ 3 x 30 mm	<b>0 544 737</b>			
	$\varnothing$ 13 x 16 mm	120	red	$\varnothing$ 3 x 30 mm	<b>0 544 757</b>			
		220	brown	$\varnothing$ 3 x 30 mm	<b>0 544 777</b>			
		280	green	$\varnothing$ 3 x 30 mm	<b>0 544 797</b>			
		80	grey	$\varnothing$ 3 x 30 mm	<b>0 544 738</b>			










## Rubber-bonded polishing points series 720 soft rubber bonding

	Head dimensions	Grit size	Colour	Shank dimensions	Order No.	Price from		
						1 piece	20 pieces	50 pieces
	Ø 16 x 16 mm	80	grey	Ø 3 x 30 mm	<b>0 544 738</b>			
		120	red	Ø 3 x 30 mm	<b>0 544 758</b>			
		220	brown	Ø 3 x 30 mm	<b>0 544 778</b>			
		280	green	Ø 3 x 30 mm	<b>0 544 798</b>			

↓ *matching set*

	Grit size	Order No.	Price from
			1 set
<b>Rubber-bonded polishing points series 720, 8 pieces, shank Ø 3 x 30 mm</b>			
	Set contains all head sizes 1x each	80	<b>0 544 730</b>
		120	<b>0 544 750</b>
		220	<b>0 544 770</b>
		280	<b>0 544 790</b>

## Rubber-bonded polishing points series 720 soft rubber bonding, shank Ø 6 x 30 mm

	Head dimensions	Grit size	Colour	Shank dimensions	Order No.	Price from		
						1 piece	20 pieces	50 pieces
<b>Rubber-bonded polishing points series 720, shank Ø 6 x 40 mm</b>								
<b>Soft rubber bonding</b>								
<b>cylinder</b>								
	Ø 8 x 16 mm	80	grey	Ø 6 x 40 mm	<b>0 544 741</b>			
		120	red	Ø 6 x 40 mm	<b>0 544 761</b>			
		220	brown	Ø 6 x 40 mm	<b>0 544 781</b>			
		280	green	Ø 6 x 40 mm	<b>0 544 801</b>			
	Ø 10 x 20 mm	80	grey	Ø 6 x 40 mm	<b>0 544 742</b>			
		120	red	Ø 6 x 40 mm	<b>0 544 762</b>			
		220	brown	Ø 6 x 40 mm	<b>0 544 782</b>			
		280	green	Ø 6 x 40 mm	<b>0 544 802</b>			
	Ø 13 x 20 mm	80	grey	Ø 6 x 40 mm	<b>0 544 743</b>			
		120	red	Ø 6 x 40 mm	<b>0 544 763</b>			
		220	brown	Ø 6 x 40 mm	<b>0 544 783</b>			
		280	green	Ø 6 x 40 mm	<b>0 544 803</b>			
	Ø 16 x 20 mm	80	grey	Ø 6 x 40 mm	<b>0 544 744</b>			
		120	red	Ø 6 x 40 mm	<b>0 544 764</b>			
		220	brown	Ø 6 x 40 mm	<b>0 544 784</b>			
		280	green	Ø 6 x 40 mm	<b>0 544 804</b>			
	Ø 16 x 32 mm	120	red	Ø 6 x 40 mm	<b>0 544 765</b>			
		80	grey	Ø 6 x 40 mm	<b>0 544 745</b>			
		220	brown	Ø 6 x 40 mm	<b>0 544 785</b>			
	Ø 20 x 20 mm	80	grey	Ø 6 x 40 mm	<b>0 544 746</b>			
		120	red	Ø 6 x 40 mm	<b>0 544 766</b>			
		220	brown	Ø 6 x 40 mm	<b>0 544 786</b>			
		280	green	Ø 6 x 40 mm	<b>0 544 806</b>			
<b>sphere</b>								
	Ø 13 mm	120	red	Ø 6 x 40 mm	<b>0 544 769</b>			








## 2 Elastic polishing points shank Ø 2.35 x 40 mm


### Elastic polishing points

These points are available with silicon carbide or diamond as abrasive. These points are highly suitable for working on hard and tough materials, such as titanium or ceramic. They leave a matt finish with excellent roughness values on materials. Regardless of the various bonds, these points can be easily shaped.

**Recommended Speed: 5,000 – 10,000 rpm**

	Head dimensions	Grit size	Colour	Shank dimensions	Rotation speed max.	Order No.	Price from	
							1 piece	10 pieces
<b>Elastic polishing points, shank Ø 2.35 x 40 mm</b>								
<b>Diamond polishing points, medium bond</b>								
<b>pointed</b>								
	Ø 4 x 13 mm	medium / K 150	pink	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 914</b>		
		fine / K 240	light grey	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 915</b>		
<b>silicone polishing points, soft bond</b>								
<b>cylinder</b>								
	Ø 6 x 11.5 mm	coarse / K 80	white	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 904</b>		
		medium / K 150	black	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 905</b>		
		fine / K 240	light blue	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 906</b>		
<b>pointed</b>								
	Ø 4.5 x 12 mm	coarse / K 80	white	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 901</b>		
		medium / K 150	black	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 902</b>		
		fine / K 240	light blue	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 903</b>		
<b>technical polishing points, hard bond</b>								
<b>cylinder</b>								
	Ø 10 x 12 mm	very coarse	blue	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 910</b>		
		coarse	grey	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 911</b>		
		medium	red brown	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 912</b>		
<b>pointed</b>								
	Ø 3.3 x 7.5 mm	very coarse	blue	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 907</b>		
		coarse	grey	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 908</b>		
		medium	red brown	Ø 2.35 x 40 mm	1,0000 rpm	<b>0 542 909</b>		


## Elastic polishing points shank Ø 3 x 30 mm

	Order No.	Price from		
		1 set	5 set	10 set
<b>SET – Elastic grinding- and polishing points, shank-Ø 3 x 30 mm, 10 pieces</b>				
	<b>0 544 800</b>			
Set includes: 2 x cyl., Ø 5 x 15 mm, grit 80 2 x cyl., Ø 5 x 15 mm, grit 120 2 x cyl., Ø 5 x 15 mm, grit 220 2 x cyl., Ø 5 x 15 mm, grit 320 1 x cyl., Ø 4 x 13 mm, diamond grit 1000 1 x cyl., Ø 4 x 13 mm, diamond grit 3000				

## Elastic polishing points joke FlexPol with holder shank $\varnothing$ 2.35 x 30 mm

These elastic polishers with silicon carbide in plastic rubber bond are ideal for processing hard and tough materials in hard to reach places. The points are available in five different diameters and six grit sizes each. Independently of the various bond strengths, these points can be profiled very well. The points are suitable for both rotating and linear applications. Handling the points is very easy with the right holder. By simply turning the holder, you can clamp the flexi-polishers and change them equally quickly.

**Recommended rotational speed: 15,000 rpm | max. rotational speed: 30,000 rpm**

	Dimensions	Grit size	Colour	Bonding	Packing quantity	Order No.	Price from 1 pack
<b>Elastic polishing points joke FlexPol</b>							
	$\varnothing$ 1 x 10 mm	medium	dark brown	x-hard	10 pieces	<b>0 542 941-1</b>	
		very coarse	blue	hard	10 pieces	<b>0 542 942-1</b>	
		coarse	anthracite	hard	10 pieces	<b>0 542 943-1</b>	
		fine	green	soft	10 pieces	<b>0 542 945-1</b>	
	$\varnothing$ 2 x 20 mm	coarse	blue	hard	10 pieces	<b>0 542 952-10</b>	
		medium	dark brown	x-hard	10 pieces	<b>0 542 951-10</b>	
		medium	dark grey	medium	10 pieces	<b>0 542 953-10</b>	
		fine	red brown	medium	10 pieces	<b>0 542 954-10</b>	
		x-fine	green	medium	10 pieces	<b>0 542 955-10</b>	
		xx-fine	yellow	medium	10 pieces	<b>0 542 956-10</b>	
	$\varnothing$ 3 x 23 mm	coarse	blue	hard	10 pieces	<b>0 542 962-10</b>	
		medium	dark brown	x-hard	10 pieces	<b>0 542 961-10</b>	
		medium	dark grey	medium	10 pieces	<b>0 542 963-10</b>	
		fine	red brown	medium	10 pieces	<b>0 542 964-10</b>	
		x-fine	green	medium	10 pieces	<b>0 542 965-10</b>	
		xx-fine	yellow	medium	10 pieces	<b>0 542 966-10</b>	
	$\varnothing$ 4 x 26 mm	coarse	blue	hard	10 pieces	<b>0 542 972-10</b>	
		medium	dark brown	x-hard	10 pieces	<b>0 542 971-10</b>	
		medium	dark grey	medium	10 pieces	<b>0 542 973-10</b>	
		fine	red brown	medium	10 pieces	<b>0 542 974-10</b>	
		x-fine	green	medium	10 pieces	<b>0 542 975-10</b>	
		xx-fine	yellow	medium	10 pieces	<b>0 542 976-10</b>	
	$\varnothing$ 5 x 28 mm	coarse	blue	hard	10 pieces	<b>0 542 982-10</b>	
		medium	dark brown	x-hard	10 pieces	<b>0 542 981-10</b>	
		medium	dark grey	medium	10 pieces	<b>0 542 983-10</b>	
		fine	red brown	medium	10 pieces	<b>0 542 984-10</b>	
		x-fine	green	medium	10 pieces	<b>0 542 985-10</b>	
		xx-fine	yellow	medium	10 pieces	<b>0 542 986-10</b>	




### Grite size compare with FEPA

coarse	K 100
medium	K 220
fine	K 400
x-fine	K 1000
xx-fine	K 1200

### Accessories / spare parts



	Dimensions	Order No.	1 piece	3 pieces	5 pieces
<b>Holder for joke FlexPol, shank <math>\varnothing</math> 2.35 x 30 mm</b>					
	$\varnothing$ 1 mm	<b>0 542 940-1</b>			
	$\varnothing$ 2 mm	<b>0 542 950</b>			
	$\varnothing$ 3 mm	<b>0 542 960</b>			
	$\varnothing$ 4 mm	<b>0 542 970</b>			
	$\varnothing$ 5 mm	<b>0 542 980</b>			

## 2 Elastic grinding files

### joke PU-DIA

#### Rubber-bonded grinding files joke PU-DIA

Synthetic diamond grits bonded in polyurethane (PU). Excellent stock removal performance on hardened surfaces and also the correct medium of choice for removing erosion structures. Owing to the elastic bond, these tools also adapt very well to the widest array of contours without any risk of breaking. Two dimensions in each of six grit sizes as standard (others on request!).

**Use:** wet/dry with water, fluid or oil

**Tip:** Make your own grinding files. The joke Pu-Dia's can be simply cut to size and adapted.



	Dimensions	Grit size	Colour	Order No.	Price from	
					1 piece	5 pieces
<b>Elastic grinding files joke PU-DIA</b>						
<b>rectangular</b>						
	10 x 10 x 100 mm	D 3	green	<b>0 545 801</b>		
		D 9	red	<b>0 545 802</b>		
		D 15	brown	<b>0 545 803</b>		
		D 30	mahagony	<b>0 545 804</b>		
		D 40	purple	<b>0 545 805</b>		
		D 60	orange	<b>0 545 806</b>		
	20 x 20 x 100 mm	D 3	green	<b>0 545 811</b>		
		D 9	red	<b>0 545 812</b>		
		D 15	brown	<b>0 545 813</b>		
		D 30	mahagony	<b>0 545 814</b>		
		D 40	purple	<b>0 545 815</b>		
		D 60	orange	<b>0 545 816</b>		

## Polishing point set, soft elastomer

### shank Ø 2.35 x 30 mm

	Grit size	Colour	Shank dimensions	Packing quantity	Order No.	Price from		
						1 set	20 set	50 set
<b>Polishing point set, soft elastomer</b>								
	Sic 240	green	Ø 2.35 - 30 mm	12 pieces	<b>0 544 855</b>			
	Set – silicone polishers consisting of 1 piece each: <b>Wheel:</b> head dim. 10 x 2 mm <b>Mushroom:</b> head dim. 10 x 2 mm <b>Cylinder:</b> head dim. 10 x 4 mm <b>Cylinder:</b> head dim. 6 x 10 mm <b>Trapezium (open):</b> head dim. 9 x 6 mm <b>Trapezium (closed):</b> head dim. 8 x 6 mm							
	Sic 400	grey	Ø 2.35 - 30 mm	12 pieces	<b>0 544 856</b>			
	<b>Barrel:</b> head dim. 6 x 6 mm <b>Sphere:</b> head dim. Ø 8 mm <b>Cone:</b> head dim. 6 x 6 mm <b>Tree:</b> head dim. 6 x 6 mm <b>Tree with pointed end:</b> head dim. 6 x 12 mm <b>Tree:</b> head dim. 6 x 15 mm							
Storage in a plastic box.								

## Lapping and polishing rubber for self-made tools

Dimensions	Grit size	Type	Order No.	Price from	
				1 piece	20 pieces
<b>Lapping and polishing rubber for self-made tools</b>					
<b>stick</b>					
∅ 6 x 200 mm	120	SG-6	<b>0 544 951</b>		
∅ 10 x 200 mm	120	SG-100	<b>0 544 956</b>		



## Rubber-bonded grinding tools CERA Sticks

### Rubber-bonded grinding tools CERA Sticks

A rubber tool on a handle - or modern: stick. Highly practical in any case, since firstly handy and secondly adapting optimally to the contours to be processed. This qualifies the sticks above all for uneven surfaces in addition to places which are difficult to reach. For deburring work, removal of annealing colours, for chamfering ...

available separately in different grit sizes or as a set in the practical plastic box.

	Coating dimensions	Grit size	Colour	Order No.	Price from
					1 piece
<b>Rubber-bonded grinding tool with handle CERA Stick</b>					
	50 x 12 x 6 mm	# 46	grey	<b>0 544 581</b>	
	50 x 12 x 6 mm	# 80	red	<b>0 544 582</b>	
	50 x 12 x 6 mm	# 120	blue	<b>0 544 583</b>	
	50 x 12 x 6 mm	# 220	yellow	<b>0 544 584</b>	
	50 x 12 x 6 mm	# 320	violet	<b>0 544 585</b>	

### matching set

	Order No.	Price from
		1 pack
<b>Set CERA Sticks in plastic box</b>		
	Content: 1 stick in each grit size	<b>0 544 580</b>

## 2 Tool system CRATEX® Sets

The assortment for tool and mould makers. The bond is made of chemical rubber. In contrast to hard grinding wheels, the CRATEX® bond has a unique cushioned action ensuring soft, smooth and free cutting. With harder materials, CRATEX® yields a clean, polishable cut, free from corrugation and discoloration. CRATEX® grinds and polishes soft materials and plastics without tearing. It resists clogging and smearing and does not result in any glassy points.

CRATEX® can be used for dry and wet grinding. The tools are insensitive to all common grinding cooling media and rust protectors and to oil. Even more gentle work can be achieved in conjunction with polishing pastes.

### Typical applications:

Smoothing and polishing of casting moulds, dies and other production tools, smoothing of edges on punched or sheared parts or glass, lapping of welded seams after rough grinding; sharpening of cutting dies, deburring and smoothing of plastic workpieces, reworking injection channels; polishing of moulds.

### The advantages at a glance:

- flexible and adaptable
- clean, discoloration-free polished section
- for all metals, non-ferrous metals and plastics
- grinding, polishing, deburring and smoothing
- four different grit sizes

CRATEX® tools are available in four standard grit sizes, which each have a different colour for ease of differentiation:

#### (C) Coarse – dark green – grit size 40

For coarse grinding and deburring. Cuts rapidly without clogging. CRATEX® C is used for soft materials such as brass, copper and aluminium and leaves a clean, smooth surface after rough casting

#### (M) Medium – dark brown – grit size 90

For light deburring and for general finishing, yielding a surface quality between preliminary grinding and polishing. CRATEX® M is recommended for the working states following rough grinding of brass, copper, aluminium and stainless steel, etc. It is eminently suitable for polishing of moulds and for performing general finishing work.

#### (F) Fine – light brown – grit size 120

A fine, needle-sharp grit size for polishing. A clean, polished surface is achieved very rapidly using this grit size. Particularly suitable for highalloyed steels, gold and other noble metals, for which a good surface is required.

#### (XF) Extra fine – light green – grit size 240

A microfine grit for achievement of a high gloss polish or final polishing on all metals.



### Maximum cutting speeds and best operating speeds

For most efficient results and good surface quality, operating speeds must not exceed the maximum safety speeds mentioned in the instruction sheets of the relevant CRATEX® tools. The maximum cutting speed must never be exceeded.

The rpm values for small CRATEX® wheels up to Ø 25 mm are based on a protruding shank length between 10 and 15 mm. If the protruding shank length exceeds 15 mm, the speed must be reduced by 20 % per 5 mm.

# Tool system CRATEX® Sets

	Order No.	Price from
		1 set

## CRATEX® Set 778, 68 pieces



Contents in plastic storage case:

- 8 CRATEX® points shape 4
- 8 CRATEX® points shape 6
- 8 CRATEX® points shape 8
- 8 CRATEX® points shape 10
- 8 CRATEX® points shape 11
- 8 CRATEX® points shape 12
- 8 CRATEX® points shape 14
- 8 CRATEX® points shape 15
- equally assorted in the four CRATEX® grit sizes
- 2 point mounting shanks shape 12 (Ø 3 mm)
- 2 point mounting shanks shape 13 (Ø 3 mm)

**0 545 291**

	Order No.	Price from
		1 set

## CRATEX® Set 777, 84 pieces





Contents in plastic storage case:

- 8 CRATEX® wheels shape 2
- 16 CRATEX® points shape 6
- 16 CRATEX® points shape 8
- 8 CRATEX® points shape 10
- 8 CRATEX® wheels shape 54
- 16 CRATEX® wheels shape 74
- 8 CRATEX® wheels shape 86
- equally assorted in the four CRATEX® grit sizes
- 2 point mounting shanks shape 22 (Ø 3 mm)
- 2 point mounting shanks shape 12 (Ø 3 mm)

**0 545 292**



## 2 Tool system CRATEX® rubber-bonded abrasives for shank-mounting

Shape	Dimensions	Grit size	Type	Matching receptacles	Order No.	Price from	
						1 piece	20 pieces
<b>CRATEX® rubber-bonded abrasive for shank mounting</b>							
	wheel, tapered	Ø 16 x 2.5 mm	C-coarse 40	2	21, 22, 23, 25	<b>0 545 005</b>	
		Ø 16 x 2.5 mm	M-medium 90	2	21, 22, 23, 25	<b>0 545 006</b>	
		Ø 16 x 2.5 mm	F-fine 120	2	21, 22, 23, 25	<b>0 545 007</b>	
		Ø 16 x 2.5 mm	XF-extra fine 240	2	21, 22, 23, 25	<b>0 545 008</b>	
		Ø 25 x 3 mm	C-coarse 40	5	21, 22, 23, 25	<b>0 545 009</b>	
		Ø 25 x 3 mm	M-medium 90	5	21, 22, 23, 25	<b>0 545 010</b>	
		Ø 25 x 3 mm	F-fine 120	5	21, 22, 23, 25	<b>0 545 011</b>	
		Ø 25 x 3 mm	XF-extra fine 240	5	21, 22, 23, 25	<b>0 545 012</b>	
	point, cylindrical shape	Ø 6 x 12.5 mm	C-coarse 40	4	11, 12	<b>0 545 017</b>	
		Ø 6 x 12.5 mm	M-medium 90	4	11, 12	<b>0 545 018</b>	
		Ø 6 x 12.5 mm	F-fine 120	4	11, 12	<b>0 545 019</b>	
		Ø 6 x 12.5 mm	XF-extra fine 240	4	11, 12	<b>0 545 020</b>	
		Ø 6 x 22 mm	C-coarse 40	6	11, 12	<b>0 545 021</b>	
		Ø 6 x 22 mm	M-medium 90	6	11, 12	<b>0 545 022</b>	
		Ø 6 x 22 mm	F-fine 120	6	11, 12	<b>0 545 023</b>	
		Ø 6 x 22 mm	XF-extra fine 240	6	11, 12	<b>0 545 024</b>	
	point, bullet-shape	Ø 7 x 25 mm	C-coarse	8	11, 12	<b>0 545 029</b>	
		Ø 7 x 25 mm	M-medium 90	8	11, 12	<b>0 545 030</b>	
		Ø 7 x 25 mm	F-fine 120	8	11, 12	<b>0 545 031</b>	
		Ø 7 x 25 mm	XF-extra fine 240	8	11, 12	<b>0 545 032</b>	
		Ø 9.5 x 16 mm	C-coarse 40	10	11, 12	<b>0 545 033</b>	
		Ø 9.5 x 16 mm	M-medium 90	10	11, 12	<b>0 545 034</b>	
		Ø 9.5 x 16 mm	F-fine 120	10	11, 12	<b>0 545 035</b>	
		Ø 9.5 x 16 mm	XF-extra fine 240	10	11, 12	<b>0 545 036</b>	
		Ø 9.5 x 25 mm	C-coarse 40	11	13, 14	<b>0 545 037</b>	
		Ø 9.5 x 25 mm	M-medium 90	11	13, 14	<b>0 545 038</b>	
		Ø 9.5 x 25 mm	F-fine 120	11	13, 14	<b>0 545 039</b>	
		Ø 9.5 x 25 mm	XF-extra fine 240	11	13, 14	<b>0 545 040</b>	
		Ø 12.5 x 22 mm	C-coarse 40	15	13, 14	<b>0 545 041</b>	
		Ø 12.5 x 22 mm	M-medium 90	15	13, 14	<b>0 545 042</b>	
		Ø 12.5 x 22 mm	F-fine 120	15	13, 14	<b>0 545 043</b>	
	Ø 12.5 x 22 mm	XF-extra fine 240	15	13, 14	<b>0 545 044</b>		





## Tool system CRATEX® rubber-bonded abrasives for shank-mounting

Shape	Dimensions	Grit size	Type	Matching receptacles	Order No.	Price from	
						1 piece	20 pieces
	wheel	Ø 16 x 2.3 mm	C-coarse 40	53	21, 22, 23, 25	<b>0 545 073</b>	
	Ø 16 x 2.3 mm	M-medium 90	53	21, 22, 23, 25	<b>0 545 074</b>		
	Ø 16 x 2.3 mm	F-fine 120	53	21, 22, 23, 25	<b>0 545 075</b>		
	Ø 16 x 2.3 mm	XF-extra fine 240	53	21, 22, 23, 25	<b>0 545 076</b>		
	Ø 16 x 3 mm	C-coarse 40	54	21, 22, 23, 25	<b>0 545 077</b>		
	Ø 16 x 3 mm	M-medium 90	54	21, 22, 23, 25	<b>0 545 078</b>		
	Ø 16 x 3 mm	F-fine 120	54	21, 22, 23, 25	<b>0 545 079</b>		
	Ø 16 x 3 mm	XF-extra fine 240	54	21, 22, 23, 25	<b>0 545 080</b>		
	Ø 22 x 3 mm	C-coarse 40	74	21, 22, 23, 25	<b>0 545 085</b>		
	Ø 22 x 3 mm	M-medium 90	74	21, 22, 23, 25	<b>0 545 086</b>		
	Ø 22 x 3 mm	F-fine 120	74	21, 22, 23, 25	<b>0 545 087</b>		
	Ø 22 x 3 mm	XF-extra fine 240	74	21, 22, 23, 25	<b>0 545 088</b>		
	Ø 22 x 4.5 mm	C-coarse 40	76	21, 22, 23, 25	<b>0 545 089</b>		
	Ø 22 x 4.5 mm	M-medium 90	76	21, 22, 23, 25	<b>0 545 090</b>		
	Ø 22 x 4.5 mm	F-fine 120	76	21, 22, 23, 25	<b>0 545 091</b>		
	Ø 22 x 4.5 mm	XF-extra fine 240	76	21, 22, 23, 25	<b>0 545 092</b>		
	Ø 25 x 3 mm	C-coarse 40	80	21, 22, 23, 25	<b>0 545 101</b>		
	Ø 25 x 3 mm	M-medium 90	80	21, 22, 23, 25	<b>0 545 102</b>		
	Ø 25 x 3 mm	F-fine 120	80	21, 22, 23, 25	<b>0 545 103</b>		
Ø 25 x 3 mm	XF-extra fine 240	80	21, 22, 23, 25	<b>0 545 104</b>			
	cone	Ø 16/6 x 25 mm	M-medium 90	1340	31	<b>0 545 118</b>	
	Ø 16/6 x 25 mm	F-fine 120	1340	31	<b>0 545 119</b>		





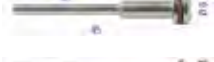




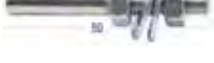



## Tool system CRATEX® rubber-bonded grinding wheels for elastic grinding

Dimensions	Drilling dimension	Grit size	Type	Rotation speed max.	Order No.	Price from
						1 piece
<b>CRATEX® Rubber-bonded grinding wheels</b>						
	Ø 38 x 3 mm	3 mm	M-medium 90	152	15,000 rpm	<b>0 545 302</b>
	Ø 38 x 9.5 mm	6 mm	M-medium 90	156	15,000 rpm	<b>0 545 314</b>
	Ø 50 x 3 mm	6 mm	C-coarse 40	202	10,500 rpm	<b>0 545 321</b>
		6 mm	F-fine 120	202	10,500 rpm	<b>0 545 323</b>
	Ø 50 x 4.5 mm	6 mm	M-medium 90	203	10,500 rpm	<b>0 545 326</b>
	Ø 50 x 6 mm	6 mm	C-coarse 40	204	10,500 rpm	<b>0 545 329</b>
		6 mm	F-fine 120	204	10,500 rpm	<b>0 545 331</b>
	Ø 75 x 6 mm	6 mm	M-medium 90	304	7,000 rpm	<b>0 545 358</b>
	Ø 125 x 6 mm	25 mm	XF-extra fine 240	504	4200 rpm	<b>0 545 408</b>

## 2 Tool system CRATEX® mounting shanks and grinding wheel holders

	for bore dimensions	Shank dimensions	Type	Order No.	Price from	
					1 piece	10 pieces
<b>CRATEX® mounting shanks</b>						
	Ø 2 mm	Ø 2.35 mm	11	<b>0 545 271</b>		
	Ø 2 mm	Ø 3 mm	12	<b>0 545 272</b>		
	Ø 3 mm	Ø 3 mm	13	<b>0 545 273</b>		
	Ø 3 mm	Ø 6 mm	14	<b>0 545 274</b>		

## Tool system CRATEX® mounting shanks and grinding wheel holders

	for bore dimensions	Shank dimensions	Type	Max. disc size	Order No.	Price from	
						1 piece	10 pieces
<b>CRATEX® grinding wheel holder</b>							
	Ø 1.5 – 1.8 mm	Ø 2.35 x 30/15 mm	25	Ø 38 x 4.5 mm	<b>0 545 279</b>		
	Ø 1.5 – 1.8 mm	Ø 2.35 x 40/28 mm	21	Ø 38 x 4.5 mm	<b>0 545 275</b>		
	Ø 1.5 – 1.8 mm	Ø 3 x 40/30 mm	24	Ø 38 x 3 mm	<b>0 545 278</b>		
	Ø 1.5 – 1.8 mm	Ø 3 x 42 mm	22	Ø 38 x 4.5 mm	<b>0 545 276</b>		
	Ø 1/8" / Ø 3.2 mm	Ø 3 x 40/30 mm	28	Ø 38 x 5.5 mm	<b>0 545 296</b>		
	Ø 1.5 – 1.8 mm	Ø 3 x 40 mm	26	Ø 25 x 8.5 mm	<b>0 545 280</b>		
	Ø 1.5 – 1.8 mm	Ø 6 x 42 mm	23	Ø 38 x 4.5 mm	<b>0 545 277</b>		
	Ø 1.5 – 1.8 mm	Ø 6 x 40 mm	27	Ø 25 x 8.5 mm	<b>0 545 281</b>		
	Ø 3 mm	Ø 6 x 40 mm	33	Ø 45 x 6 mm	<b>0 545 269</b>		
	Ø 6 mm	Ø 6 x 25 mm	41	Ø 75 x 9.5 mm	<b>0 545 282</b>		
	Ø 6 mm	Ø 6 x 40 mm	42	Ø 75 x 20 mm	<b>0 545 283</b>		
	Ø 1/4" / Ø 6.3 mm	Ø 6 x 30 mm	31	Ø 75 x 25 mm	<b>0 545 284</b>		
	Ø 1/4" / Ø 6.3 mm	Ø 6 x 40 mm	32	Ø 75 x 20 mm	<b>0 545 297</b>		

## Tool system CRATEX® rubber-bonded sticks for hand (filing machine) use

Dimensions	Grit size	Type	Order No.	Price from	
				1 piece	10 pieces
<b>CRATEX® rubber-bonded sticks</b>					
<b>square</b>					
	6 x 6 x 150 mm	C-coarse 40	6202	<b>0 545 171</b>	
		M-medium 90	6202	<b>0 545 172</b>	
		F-fine 120	6202	<b>0 545 173</b>	
		XF-very fine 240	6202	<b>0 545 174</b>	
	12.5 x 12.5 x 150 mm	C-coarse 40	6404	<b>0 545 175</b>	
		M-medium 90	6404	<b>0 545 176</b>	
		F-fine 120	6404	<b>0 545 177</b>	
		XF-very fine 240	6404	<b>0 545 178</b>	
	18 x 18 x 150 mm	C-coarse 40	6606	<b>0 545 179</b>	
		M-medium 90	6606	<b>0 545 180</b>	
		F-fine 120	6606	<b>0 545 181</b>	
		XF-very fine 240	6606	<b>0 545 182</b>	
<b>round</b>					
	Ø 4.8 x 150 mm	M-medium 90	036	<b>0 545 228</b>	
		F-fine 120	036	<b>0 545 229</b>	
	Ø 6 x 150 mm	C-coarse 40	046	<b>0 545 231</b>	
		M-medium 90	046	<b>0 545 232</b>	
		F-fine 120	046	<b>0 545 233</b>	
		XF-very fine 240	046	<b>0 545 234</b>	
	Ø 9.5 x 150 mm	M-medium 90	066	<b>0 545 240</b>	
		F-fine 120	066	<b>0 545 241</b>	
		XF-very fine 240	066	<b>0 545 242</b>	
	Ø 12.5 x 150 mm	C-coarse 40	086	<b>0 545 243</b>	
		M-medium 90	086	<b>0 545 244</b>	
		F-fine 120	086	<b>0 545 245</b>	
		XF-very fine 240	086	<b>0 545 246</b>	
	Ø 16 x 150 mm	M-medium 90	0106	<b>0 545 248</b>	
		F-fine 120	0106	<b>0 545 249</b>	
	Ø 18 x 150 mm	C-coarse 40	0126	<b>0 545 251</b>	
		M-medium 90	0126	<b>0 545 252</b>	
		F-fine 120	0126	<b>0 545 253</b>	
	Ø 25 x 150 mm	F-fine 120	0166	<b>0 545 261</b>	
<b>rectangular</b>					
	25 x 3 x 150 mm	C-coarse 40	6801	<b>0 545 191</b>	
		M-medium 90	6801	<b>0 545 192</b>	
		F-fine 120	6801	<b>0 545 193</b>	
	25 x 6 x 150 mm	C-coarse 40	6802	<b>0 545 199</b>	
		M-medium 90	6802	<b>0 545 200</b>	
		F-fine 120	6802	<b>0 545 201</b>	
	25 x 9.5 x 150 mm	C-coarse 40	6803	<b>0 545 203</b>	
		M-medium 90	6803	<b>0 545 204</b>	
		F-fine 120	6803	<b>0 545 205</b>	
		XF-very fine 240	6803	<b>0 545 206</b>	

# Grinding and polishing stones

237 joke stones

242 Gesswein® stones

253 Boride® stones

260 Bench stones

263 Holder for grinding and polishing stones



Type	Page	Tool steel	Steels	Erosion structures	Stainless steel	Aluminium	Non-ferrous metals	Carbide metals
joke	FD	237	◆					◆
	JB 1	238	◆	◆	◆			
	JB 2	239	◆	◆	◆			
	C-AS	240	◆	◆		◆	◆	◆
	Royal S	241	◆	◆	◆			
Gesswein®	EDM BLUE	242	◆	◆	◆			
	OT	243	◆	◆	◆			
	EDM	244	◆	◆	◆			
	DIEMAKER	245	◆	◆			◆	◆
	MOLDMAKER	247	◆	◆		◆	◆	◆
	ULTRASOFT	248	◆	◆	◆	◆	◆	◆
	PREMIUM WHITE	249	◆	◆		◆	◆	◆
	G2	250	◆	◆		◆		
	SUPER FINE	251	◆	◆		◆	◆	◆
	GP-STONE	252	◆	◆	◆			
Boride®	CS-HD	253	◆	◆	◆			
	T2	253	◆		◆	◆		
	Orange EDM	254	◆	◆	◆			
	A0	255	◆	◆	◆			
	Golden Star	256	◆	◆				
	AM-2	257	◆	◆		◆	◆	◆
	RO-MED	258	◆	◆	◆			
	RASP	259	◆	◆	◆	◆	◆	◆
	CS-M	260	◆	◆				

# Grinding and polishing stones

## joke FD

These ceramic oxide stones consist of mixed crystals of outstanding hardness. The main component is aluminium oxide. This crystal occurs naturally as ruby, hence the name "ruby stones" or "degussit".

The stones are free of bonding agents, absolutely dimensionally stable and low-wear. Ideal for manual use and in ultrasonic polishing systems.

**Tip: well suited for carbide metal processing and very fine finishing after grinding.**



### Bonding

1	2	3	4	5
soft				hard

### Stock removal

1	2	3	4	5
slow			fast	

### Wear

1	2	3	4	5
slow				fast

### Application

1	2	3	4	5
Preparatory work			Finishing	

Dimensions	Grit size	Type	Order No.	Price from 1 piece
<b>Grinding and polishing stones, joke FD</b>				
<b>crossing</b>				
4 x 1.5 x 100 mm	fine	FD		<b>0 401 570</b>
<b>triangular</b>				
2 x 50 mm	fine	FD		<b>0 401 566</b>
3 x 100 mm	fine	FD		<b>0 401 567</b>
4 x 100 mm	fine	FD		<b>0 401 586</b>
	medium	FD		<b>0 401 587</b>
5 x 1.5 x 100 mm	fine	FD		<b>0 401 571</b>
6 x 100 mm	fine	FD		<b>0 401 588</b>
	medium	FD		<b>0 401 589</b>
8 x 100 mm	fine	FD		<b>0 401 590</b>
	medium	FD		<b>0 401 591</b>
<b>square</b>				
1 x 50 mm	fine	FD		<b>0 401 568</b>
2 x 100 mm	fine	FD		<b>0 401 569</b>
4 x 100 mm	fine	FD		<b>0 401 592</b>
	medium	FD		<b>0 401 593</b>
6 x 100 mm	fine	FD		<b>0 401 594</b>
	medium	FD		<b>0 401 595</b>
8 x 100 mm	fine	FD		<b>0 401 596</b>
	medium	FD		<b>0 401 597</b>
<b>round</b>				
Ø 1 x 50 mm	fine	FD		<b>0 401 563</b>
Ø 2 x 100 mm	fine	FD		<b>0 401 564</b>
Ø 3 x 100 mm	fine	FD		<b>0 401 565</b>
Ø 4 x 100 mm	fine	FD		<b>0 401 580</b>
	medium	FD		<b>0 401 581</b>
Ø 6 x 100 mm	fine	FD		<b>0 401 582</b>
	medium	FD		<b>0 401 583</b>
Ø 8 x 100 mm	fine	FD		<b>0 401 584</b>
	medium	FD		<b>0 401 585</b>
<b>halfround</b>				
Ø 4 x 100 mm	fine	FD		<b>0 401 562</b>
<b>rectangular</b>				
3 x 0.3 x 50 mm	fine	FD		<b>0 401 561</b>
6 x 3 x 100 mm	fine	FD		<b>0 401 576</b>
	medium	FD		<b>0 401 577</b>
8 x 6 x 100 mm	fine	FD		<b>0 401 578</b>
	medium	FD		<b>0 401 579</b>



## 2 Grinding and polishing stones

### joke JB1

These grinding and polishing stones are made of pink highgrade corundum in a soft bond. They can be used dry. When used without oil, the grinding residues are simply removed with a brush. The JB1 grinding and polishing stones are suitable for both soft and hard materials and are used, for example, on milled or ground surfaces and contours.



#### Bonding

1	2	3	4	5
soft				hard

#### Stock removal

1	2	3	4	5
slow				fast

#### Wear

1	2	3	4	5
slow				fast

#### Application

1	2	3	4	5
Preparatory work				Finishing

Dimensions	Grit size	Type	Order No.	Price from		
				1 piece	12 pieces	60 pieces
<b>Grinding and polishing stones, joke JB1</b>						
<b>square</b>						
6 x 6 x 150 mm	80	JB1	<b>0 401 675</b>			
	120	JB1	<b>0 401 676</b>			
	180	JB1	<b>0 401 677</b>			
4 x 4 x 150 mm	120	JB1	<b>0 401 805</b>			
	180	JB1	<b>0 401 815</b>			
<b>rectangular</b>						
6 x 3 x 150 mm	80	JB1	<b>0 401 801</b>			
	120	JB1	<b>0 401 806</b>			
	180	JB1	<b>0 401 816</b>			
13 x 3 x 150 mm	80	JB1	<b>0 401 802</b>			
	120	JB1	<b>0 401 807</b>			
	180	JB1	<b>0 401 817</b>			
13 x 6 x 150 mm	80	JB1	<b>0 401 803</b>			
	120	JB1	<b>0 401 808</b>			
	180	JB1	<b>0 401 818</b>			
20 x 10 x 150 mm	80	JB1	<b>0 401 804</b>			
	120	JB1	<b>0 401 809</b>			
	180	JB1	<b>0 401 819</b>			

## Grinding and polishing stone oil (fluid)

### for all grinding and polishing stones

The oil/fluid suitable for all grinding and polishing stones. Very economical to use and practically odourless. The use of this fluid prevents clogging of stones during processing. The grinding tools cut better, producing a brilliant, uniform surface.

Content	Order No.	Price from	
		1 piece	5 pieces
<b>Grinding and polishing stone oil (fluid)</b>			
1 litre	<b>0 401 870</b>		
5 litres	<b>0 401 870-5</b>		



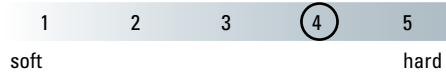
# Grinding and polishing stones

## joke JB2

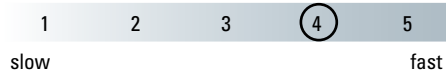
These stones of sulphured high-grade corundum are particularly suitable for grinding eroded surfaces and contours. The hard bond guarantees a very high edge strength for the stones and at the same time prevents excessive clogging. The additional use of abrasive stone oil (fluid) is recommended.



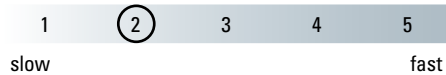
### Bonding



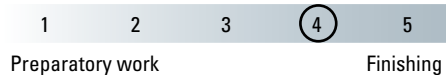
### Stock removal



### Wear



### Application



Dimensions	Grit size	Type	Order No.	Price from		
				1 piece	12 pieces	60 pieces
<b>Grinding and polishing stones joke JB2</b>						
<b>rectangular</b>						
6 x 3 x 150 mm	180	JB2	<b>0 401 821</b>			
	320	JB2	<b>0 401 826</b>			
	600	JB2	<b>0 401 841</b>			
13 x 3 x 150 mm	180	JB2	<b>0 401 822</b>			
	320	JB2	<b>0 401 827</b>			
13 x 6 x 150 mm	120	JB2	<b>0 401 813</b>			
	180	JB2	<b>0 401 823</b>			
	320	JB2	<b>0 401 828</b>			
20 x 10 x 150 mm	120	JB2	<b>0 401 814</b>			
	320	JB2	<b>0 401 829</b>			

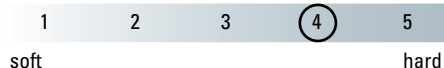
## 2 Grinding and polishing stones

### joke C-AS

joke C-AS stones are made from white high-grade corundum with sulphured graphite to prevent tearing on the surface. The bond is hard and therefore edge-stable. Use with a fluid or file oil is recommended.



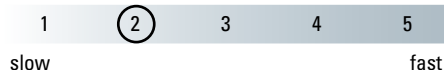
#### Bonding



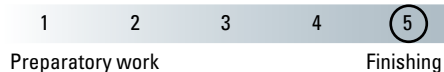
#### Stock removal



#### Wear



#### Application



Dimensions	Grit size	Type	Order No.	Price from		
				1 piece	12 pieces	60 pieces
<b>Grinding and polishing stones, joke C-AS</b>						
<b>square</b>						
6 x 6 x 125 mm	220	C-AS	<b>0 414 023</b>			
	320	C-AS	<b>0 414 024</b>			
	400	C-AS	<b>0 414 025</b>			
	600	C-AS	<b>0 414 026</b>			
	800	C-AS	<b>0 414 027</b>			
	1000	C-AS	<b>0 414 028</b>			
	1200	C-AS	<b>0 414 029</b>			
<b>rectangular</b>						
12 x 3 x 125 mm	220	C-AS	<b>0 414 033</b>			
	320	C-AS	<b>0 414 034</b>			
	400	C-AS	<b>0 414 035</b>			
	600	C-AS	<b>0 414 036</b>			
	800	C-AS	<b>0 414 037</b>			
	1000	C-AS	<b>0 414 038</b>			
	1200	C-AS	<b>0 414 039</b>			
12 x 6 x 125 mm	220	C-AS	<b>0 414 043</b>			
	320	C-AS	<b>0 414 044</b>			
	400	C-AS	<b>0 414 045</b>			
	600	C-AS	<b>0 414 046</b>			
	800	C-AS	<b>0 414 047</b>			
	1000	C-AS	<b>0 414 048</b>			
	1200	C-AS	<b>0 414 049</b>			

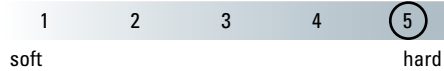
# Grinding and polishing stones

## joke Royal S

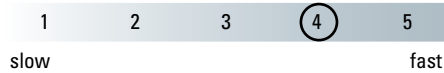
These aluminium oxide grinding stones with a special oil impregnation have very good dry running properties and a very hard bond. The stones are used for finishing soft and hard metals. The very mild microsection makes it possible to achieve optimum surfaces up to superfinish. Contours can be retained easily.



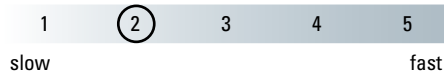
### Bonding



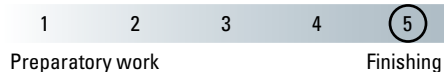
### Stock removal



### Wear



### Application

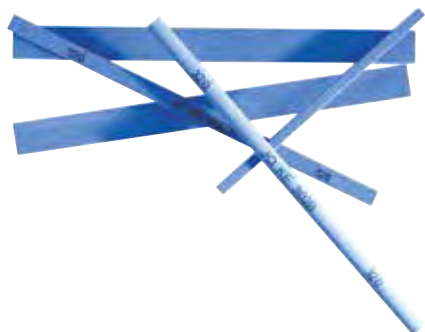


Dimensions	Grit size	Type	Order No.	Price from		
				1 piece	12 pieces	60 pieces
<b>Grinding and polishing stones, joke Royal S</b>						
<b>square</b>						
6 x 6 x 150 mm	320	Royal S	<b>0 401 862</b>			
	400	Royal S	<b>0 401 863</b>			
	600	Royal S	<b>0 401 864</b>			
	800	Royal S	<b>0 401 865</b>			
	1000	Royal S	<b>0 401 866</b>			
<b>rectangular</b>						
6 x 3 x 150 mm	320	Royal S	<b>0 401 831</b>			
	400	Royal S	<b>0 401 836</b>			
	600	Royal S	<b>0 401 846</b>			
	800	Royal S	<b>0 401 851</b>			
	1000	Royal S	<b>0 401 856</b>			
13 x 3 x 150 mm	320	Royal S	<b>0 401 832</b>			
	400	Royal S	<b>0 401 837</b>			
	600	Royal S	<b>0 401 847</b>			
	800	Royal S	<b>0 401 852</b>			
	1000	Royal S	<b>0 401 857</b>			
13 x 6 x 150 mm	320	Royal S	<b>0 401 833</b>			
	400	Royal S	<b>0 401 838</b>			
	600	Royal S	<b>0 401 848</b>			
	800	Royal S	<b>0 401 853</b>			
	1000	Royal S	<b>0 401 858</b>			

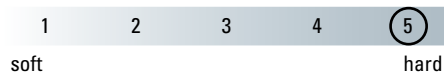
## 2 Grinding and polishing stones

### Gesswein® EDM BLUE

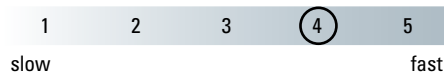
Premium aluminium oxide stones. The hardest Gesswein® stones. Ideal for use with hand-filing machines and ultrasonic polishing systems. As these stones are a lot harder than the EDM series, they are better suited for the quick removal of hard erosion skin. Optimum results in conjunction with fluid.



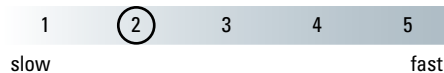
#### Bonding



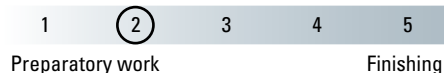
#### Stock removal



#### Wear



#### Application



Dimensions	Grit size	Type	Order No.	Price from		
				1 piece	12 pieces	60 pieces
<b>Grinding and polishing stones Gesswein® EDM BLUE</b>						
<b>square</b>						
4 x 4 x 100 mm	120	EDM BLUE 61	<b>0 401 601</b>			
	180	EDM BLUE 62	<b>0 401 602</b>			
	220	EDM BLUE 622	<b>0 401 603</b>			
	320	EDM BLUE 63	<b>0 401 604</b>			
	400	EDM BLUE 64	<b>0 401 605</b>			
	600	EDM BLUE 66	<b>0 401 606</b>			
6 x 6 x 150 mm	120	EDM BLUE 6122	<b>0 401 613</b>			
	180	EDM BLUE 6182	<b>0 401 614</b>			
	220	EDM BLUE 6202	<b>0 401 615</b>			
	320	EDM BLUE 6302	<b>0 401 616</b>			
	400	EDM BLUE 6402	<b>0 401 617</b>			
	600	EDM BLUE 6602	<b>0 401 618</b>			
<b>round</b>						
Ø 6 x 150 mm	120	EDM BLUE E122	<b>0 401 637</b>			
	180	EDM BLUE E182	<b>0 401 638</b>			
	320	EDM BLUE E302	<b>0 401 639</b>			
<b>rectangular</b>						
6 x 3 x 150 mm	120	EDM BLUE 6121	<b>0 401 607</b>			
	180	EDM BLUE 6181	<b>0 401 608</b>			
	220	EDM BLUE 6201	<b>0 401 609</b>			
	320	EDM BLUE 6301	<b>0 401 610</b>			
	400	EDM BLUE 6401	<b>0 401 611</b>			
	600	EDM BLUE 6601	<b>0 401 612</b>			
13 x 1.6 x 150 mm	120	EDM BLUE 6120	<b>0 401 619</b>			
	180	EDM BLUE 6180	<b>0 401 620</b>			
	220	EDM BLUE 6200	<b>0 401 621</b>			
	320	EDM BLUE 6300	<b>0 401 622</b>			
	400	EDM BLUE 6400	<b>0 401 623</b>			
	600	EDM BLUE 6600	<b>0 401 624</b>			
13 x 3 x 150 mm	120	EDM BLUE 6123	<b>0 401 625</b>			
	180	EDM BLUE 6183	<b>0 401 626</b>			
	220	EDM BLUE 6203	<b>0 401 627</b>			
	320	EDM BLUE 6303	<b>0 401 628</b>			
	400	EDM BLUE 6403	<b>0 401 629</b>			
	600	EDM BLUE 6603	<b>0 401 630</b>			
13 x 6 x 150 mm	120	EDM BLUE 6124	<b>0 401 631</b>			
	180	EDM BLUE 6184	<b>0 401 632</b>			
	220	EDM BLUE 6204	<b>0 401 633</b>			
	320	EDM BLUE 6304	<b>0 401 634</b>			
	400	EDM BLUE 6404	<b>0 401 635</b>			
	600	EDM BLUE 6604	<b>0 401 636</b>			

# Grinding and polishing stones

## Gesswein® OT

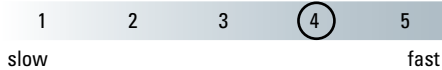
These hard white aluminium oxide stones are ideal for fine work on both hard and soft metals and in particular for the finishing of slots and points that are difficult to reach. A sophisticated oil impregnation ensures that the OT stones do not clog up and an excellent grinding pattern is achieved.



### Bonding



### Stock removal



### Wear



### Application



Dimensions	Grit size	Type	Order No.	Price from		
				1 piece	12 pieces	60 pieces
<b>Grinding and polishing stones, Gesswein® OT</b>						
<b>square</b>						
4 x 4 x 100 mm	120	OT 51	0 401 276			
	220	OT 52	0 401 277			
	320	OT 53	0 401 278			
	400	OT 54	0 401 279			
	600	OT 56	0 401 280			
4 x 4 x 150 mm	120	OT 51	0 401 202			
	220	OT 52	0 401 203			
	320	OT 53	0 401 204			
	400	OT 54	0 401 205			
	600	OT 56	0 401 206			
6 x 6 x 150 mm	120	OT 5102	0 401 286			
	220	OT 5202	0 401 287			
	320	OT 5302	0 401 288			
	400	OT 5402	0 401 289			
	600	OT 5602	0 401 290			
<b>rectangular</b>						
6 x 3 x 150 mm	120	OT 5101	0 401 281			
	220	OT 5201	0 401 282			
	320	OT 5301	0 401 283			
	400	OT 5401	0 401 284			
	600	OT 5601	0 401 285			
13 x 3 x 150 mm	120	OT 5103	0 401 291			
	220	OT 5203	0 401 292			
	320	OT 5303	0 401 293			
	400	OT 5403	0 401 294			
	600	OT 5603	0 401 295			
13 x 6 x 150 mm	120	OT 5104	0 401 296			
	220	OT 5204	0 401 297			
	320	OT 5304	0 401 298			
	400	OT 5404	0 401 299			
	600	OT 5604	0 401 300			
25 x 13 x 150 mm	120	OT	0 401 641			
	220	OT	0 401 642			
	320	OT	0 401 643			
	400	OT	0 401 644			
	600	OT	0 401 645			



## 2 Grinding and polishing stones Gesswein® EDM

The cutting effect of these stones makes them ideal for processing of moulds manufactured by electroerosion. The sharp and easy-cutting premium aluminium oxide strips the extremely hard surface layer that remains after electroerosion in a very short time. EDM stones are very hard and therefore dimensionally stable and do not clog. Further surface refinement can be achieved with the subsequent use of finer grit sizes of DF quality.



### Bonding

1	2	3	4	5
soft				hard

### Stock removal

1	2	3	4	5
slow				fast

### Wear

1	2	3	4	5
slow				fast

### Application

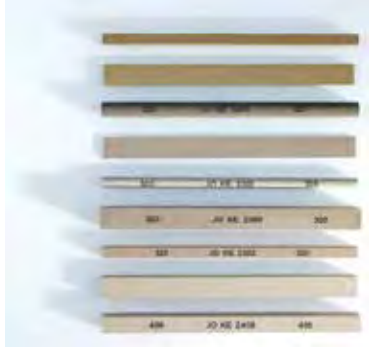
1	2	3	4	5
Preparatory work				Finishing

Dimensions	Grit size	Type	Order No.	Price from		
				1 piece	12 pieces	60 pieces
<b>Grinding and polishing stones, Gesswein® EDM</b>						
<b>square</b>						
4 x 4 x 100 mm	180	EDM 62	<b>0 401 002</b>			
	220	EDM 622	<b>0 401 755</b>			
	320	EDM 63	<b>0 401 003</b>			
	400	EDM 64	<b>0 401 710</b>			
	600	EDM 66	<b>0 401 711</b>			
	6 x 6 x 150 mm	120	EDM 6122	<b>0 401 010</b>		
180		EDM 6182	<b>0 401 011</b>			
220		EDM 6202	<b>0 401 752</b>			
320		EDM 6302	<b>0 401 012</b>			
400		EDM 6402	<b>0 401 716</b>			
600		EDM 6602	<b>0 401 717</b>			
10 x 10 x 150 mm	120	EDM 6128	<b>0 401 019</b>			
	180	EDM 6188	<b>0 401 020</b>			
	320	EDM 6308	<b>0 401 021</b>			
<b>round</b>						
Ø 6 x 150 mm	120	EDM 122	<b>0 401 264</b>			
	180	EDM 182	<b>0 401 265</b>			
	320	EDM 302	<b>0 401 266</b>			
	400	EDM 402	<b>0 401 722</b>			
	220	EDM 222	<b>0 401 750</b>			
<b>rectangular</b>						
6 x 3 x 150 mm	120	EDM 6121	<b>0 401 007</b>			
	180	EDM 6181	<b>0 401 008</b>			
	220	EDM 6201	<b>0 401 751</b>			
	320	EDM 6301	<b>0 401 009</b>			
	400	EDM 6401	<b>0 401 714</b>			
	600	EDM 6601	<b>0 401 715</b>			
13 x 1.6 x 150 mm	120	EDM 6120	<b>0 401 004</b>			
	180	EDM 6180	<b>0 401 005</b>			
	320	EDM 6300	<b>0 401 006</b>			
	400	EDM 6400	<b>0 401 712</b>			
13 x 3 x 150 mm	120	EDM 6123	<b>0 401 013</b>			
	180	EDM 6183	<b>0 401 014</b>			
	220	EDM 6203	<b>0 401 753</b>			
	320	EDM 6303	<b>0 401 015</b>			
	400	EDM 6403	<b>0 401 718</b>			
	600	EDM 6603	<b>0 401 719</b>			
13 x 6 x 150 mm	120	EDM 6124	<b>0 401 016</b>			
	180	EDM 6184	<b>0 401 017</b>			
	220	EDM 6204	<b>0 401 708</b>			
	320	EDM 6304	<b>0 401 018</b>			
	400	EDM 6404	<b>0 401 720</b>			
	600	EDM 6604	<b>0 401 721</b>			
40 x 25 x 150 mm	120	EDM	<b>0 401 273</b>			
	180	EDM	<b>0 401 274</b>			
	320	EDM	<b>0 401 275</b>			

# Grinding and polishing stones

## Gesswein® DIEMAKER

The original "diemaker stones". Medium hard aluminium oxide combined with a semi-soft bond results in a DF stone quality with high dimensional stability and existing contours are therefore easily rectified. They are mainly used for cutting and punching tools, but are also very suitable for mould and tool making.



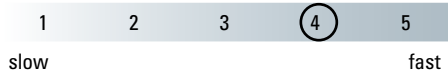
### Bonding



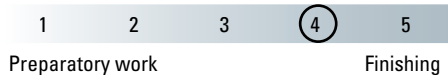
### Stock removal



### Wear



### Application

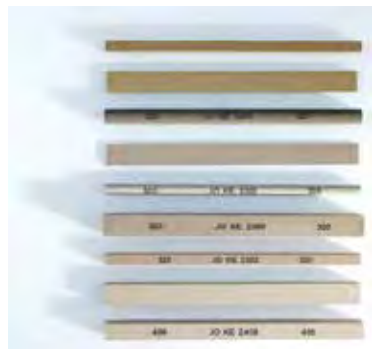


Dimensions	Grit size	Type	Order No.	Price from			
				1 piece	12 pieces	60 pieces	
<b>Grinding and polishing stones Gesswein® DIEMAKER</b>							
<b>triangular</b>							
10 x 10 x 10 x 150 mm	150	DIEMAKER 2198	<b>0 401 249</b>				
	220	DIEMAKER 2298	<b>0 401 250</b>				
	320	DIEMAKER 2398	<b>0 401 251</b>				
	400	DIEMAKER 2498	<b>0 401 252</b>				
<b>square</b>							
4 x 4 x 100 mm	150	DIEMAKER 0010	<b>0 401 786</b>				
	220	DIEMAKER 2	<b>0 401 141</b>				
	320	DIEMAKER 3	<b>0 401 142</b>				
	400	DIEMAKER 4	<b>0 401 143</b>				
	600	DIEMAKER 6	<b>0 401 144</b>				
	800	DIEMAKER 8	<b>0 401 145</b>				
	900	DIEMAKER 9	<b>0 401 146</b>				
	6 x 6 x 150 mm	150	DIEMAKER 2102	<b>0 401 748</b>			
		220	DIEMAKER 2202	<b>0 401 158</b>			
320		DIEMAKER 2302	<b>0 401 159</b>				
400		DIEMAKER 2402	<b>0 401 160</b>				
600		DIEMAKER 2602	<b>0 401 161</b>				
900		DIEMAKER 2902	<b>0 401 162</b>				
10 x 10 x 150 mm	150	DIEMAKER 2108	<b>0 401 757</b>				
	220	DIEMAKER 2208	<b>0 401 163</b>				
	320	DIEMAKER 2308	<b>0 401 164</b>				
	400	DIEMAKER 2408	<b>0 401 165</b>				
	600	DIEMAKER 2608	<b>0 401 166</b>				
	900	DIEMAKER 2908	<b>0 401 167</b>				
13 x 13 x 150 mm	150	DIEMAKER 2105	<b>0 401 789</b>				
	220	DIEMAKER 2205	<b>0 401 183</b>				
	320	DIEMAKER 2305	<b>0 401 184</b>				
	400	DIEMAKER 2405	<b>0 401 185</b>				
	25 x 25 x 150 mm	150	DIEMAKER 2106	<b>0 401 237</b>			
		220	DIEMAKER 2206	<b>0 401 238</b>			
<b>round</b>							
Ø 6 x 150 mm	220	DIEMAKER 3202	<b>0 401 188</b>				
	320	DIEMAKER 3302	<b>0 401 189</b>				
	400	DIEMAKER 3402	<b>0 401 190</b>				
	600	DIEMAKER 3602	<b>0 401 191</b>				
	900	DIEMAKER 3902	<b>0 401 192</b>				
Ø 10 x 150 mm	220	DIEMAKER 3208	<b>0 401 193</b>				
	320	DIEMAKER 3308	<b>0 401 194</b>				
	400	DIEMAKER 3408	<b>0 401 195</b>				
	600	DIEMAKER 3608	<b>0 401 196</b>				

## 2 Grinding and polishing stones

### Gesswein® DIEMAKER

The original "diemaker stones". Medium hard aluminium oxide combined with a semi-soft bond results in a DF stone quality with high dimensional stability and existing contours are therefore easily rectified. They are mainly used for cutting and punching tools, but are also very suitable for mould and tool making.



#### Bonding

1	2	3	4	5
soft				hard

#### Stock removal

1	2	3	4	5
slow				fast

#### Wear

1	2	3	4	5
slow				fast

#### Application

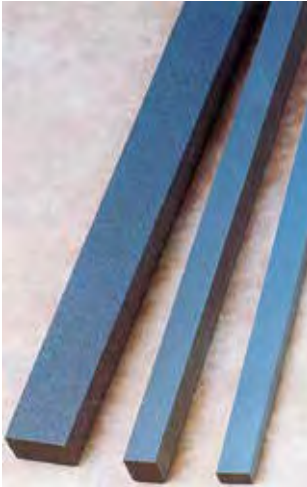
1	2	3	4	5
Preparatory work				Finishing

Dimensions	Grit size	Type	Order No.	Price from		
				1 piece	12 pieces	60 pieces
<b>rectangular</b>						
6 x 1,6 x 100 mm	220	DIEMAKER 2210	<b>0 401 148</b>			
	320	DIEMAKER 2310	<b>0 401 149</b>			
	400	DIEMAKER 2410	<b>0 401 150</b>			
	600	DIEMAKER 2610	<b>0 401 151</b>			
6 x 3 x 150 mm	150	DIEMAKER 2101	<b>0 401 242</b>			
	220	DIEMAKER 2201	<b>0 401 153</b>			
	320	DIEMAKER 2301	<b>0 401 154</b>			
	400	DIEMAKER 2401	<b>0 401 155</b>			
	600	DIEMAKER 2601	<b>0 401 156</b>			
13 x 1,6 x 150 mm	220	DIEMAKER 2200	<b>0 401 168</b>			
	320	DIEMAKER 2300	<b>0 401 169</b>			
	400	DIEMAKER 2400	<b>0 401 170</b>			
	600	DIEMAKER 2600	<b>0 401 171</b>			
13 x 3 x 150 mm	150	DIEMAKER 2103	<b>0 401 705</b>			
	220	DIEMAKER 2203	<b>0 401 173</b>			
	320	DIEMAKER 2303	<b>0 401 174</b>			
	400	DIEMAKER 2403	<b>0 401 175</b>			
	600	DIEMAKER 2603	<b>0 401 176</b>			
13 x 6 x 150 mm	900	DIEMAKER 2903	<b>0 401 177</b>			
	150	DIEMAKER 2104	<b>0 401 747</b>			
	220	DIEMAKER 2204	<b>0 401 178</b>			
	320	DIEMAKER 2304	<b>0 401 179</b>			
	400	DIEMAKER 2404	<b>0 401 180</b>			
25 x 12 x 150 mm	600	DIEMAKER 2604	<b>0 401 181</b>			
	900	DIEMAKER 2904	<b>0 401 182</b>			
	150	DIEMAKER 2107	<b>0 401 231</b>			
	220	DIEMAKER 2207	<b>0 401 232</b>			
	320	DIEMAKER 2307	<b>0 401 233</b>			
	400	DIEMAKER 2407	<b>0 401 234</b>			
600	DIEMAKER 2607	<b>0 401 235</b>				

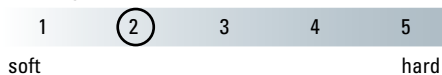
# Grinding and polishing stones

## Gesswein® MOLDMAKER / MOLDMAKER PLUS

These stones produce a semi-gloss surface. As abrasive for these stones, silicon carbide or Premium silicon carbide is used. The soft bonding results in fast cutting action and largely prevents clogging. Since these stones easily adapt to the required profile, they are ideal for outlines and radii.



### Bonding



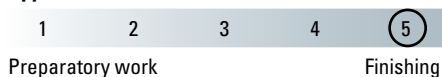
### Stock removal



### Wear




### Application



Dimensions	Grit size	Type	Order No.	Price from		
				1 piece	12 pieces	60 pieces
<b>Grinding and polishing stones Gesswein® MOLDMAKER</b>						
<b>square</b>						
6 x 6 x 100 mm	220	MOLDMAKER 202	0 401 089			
	320	MOLDMAKER 302	0 401 090			
	400	MOLDMAKER 402	0 401 091			
	600	MOLDMAKER 602	0 401 092			
6 x 6 x 150 mm	220	MOLDMAKER 1202	0 401 109			
	320	MOLDMAKER 1302	0 401 110			
	400	MOLDMAKER 1402	0 401 111			
	600	MOLDMAKER 1602	0 401 112			
13 x 13 x 150 mm	220	MOLDMAKER 1205	0 401 101-1			
	320	MOLDMAKER 1305	0 401 102-1			
	400	MOLDMAKER 1405	0 401 103-1			
	600	MOLDMAKER 1605	0 401 104-1			
<b>rectangular</b>						
6 x 3 x 100 mm	220	MOLDMAKER 201	0 401 085			
	320	MOLDMAKER 301	0 401 086			
	400	MOLDMAKER 401	0 401 087			
	600	MOLDMAKER 601	0 401 088			
6 x 3 x 150 mm	220	MOLDMAKER 1201	0 401 105			
	320	MOLDMAKER 1301	0 401 106			
	400	MOLDMAKER 1401	0 401 107			
	600	MOLDMAKER 1601	0 401 108			
13 x 3 x 150 mm	220	MOLDMAKER 1203	0 401 113			
	320	MOLDMAKER 1303	0 401 114			
	400	MOLDMAKER 1403	0 401 115			
	600	MOLDMAKER 1603	0 401 116			
13 x 6 x 100 mm	220	MOLDMAKER 204	0 401 097			
	320	MOLDMAKER 304	0 401 098			
	400	MOLDMAKER 404	0 401 099			
	600	MOLDMAKER 604	0 401 100			
13 x 6 x 150 mm	220	MOLDMAKER 1204	0 401 117			
	320	MOLDMAKER 1304	0 401 118			
	400	MOLDMAKER 1404	0 401 119			
	600	MOLDMAKER 1604	0 401 120			
<b>Grinding and polishing stones Gesswein® MOLDMAKER PLUS</b>						
<b>square</b>						
4 x 4 x 100 mm	220	MOLDMAKER PLUS 1020P	0 401 766			
	320	MOLDMAKER PLUS 1030P	0 401 767			
	400	MOLDMAKER PLUS 1040P	0 401 768			
	600	MOLDMAKER PLUS 1060P	0 401 769			
	800	MOLDMAKER PLUS 1080P	0 401 770			
6 x 6 x 150 mm	800	MOLDMAKER PLUS 1802P	0 401 774			
<b>rectangular</b>						
6 x 3 x 150 mm	800	MOLDMAKER PLUS 1801P	0 401 772			
13 x 3 x 150 mm	800	MOLDMAKER PLUS 1803P	0 401 776			
13 x 6 x 150 mm	100	MOLDMAKER PLUS 1104P	0 401 125			
	150	MOLDMAKER PLUS 1154P	0 401 123			
	800	MOLDMAKER PLUS 1804P	0 401 778			
	1200	MOLDMAKER PLUS 2004P	0 401 779			

# 2 Grinding and polishing stones

## Gesswein® Hybrid test set

	Order No.	Price from
<b>Hybrid test set Gesswein®</b>		1 set
 <p>20 stones (dimensions: 6 x 6 x 150 mm), 1 piece each in grit size 220, 320, 400, 600:</p> <ul style="list-style-type: none"> <li>• DIEMAKER</li> <li>• EDM</li> <li>• GP</li> <li>• MOLDMAKER</li> <li>• OT</li> </ul>	<b>0 401 140</b>	

# Grinding and polishing stones

## Gesswein® ULTRASOFT

The abrasive used for the Super-Soft version is white aluminium oxide. The very soft bond allows for a quick adaption of these stones and prevents clogging. Perfectly suited for processing aluminium, beryllium, brass, bronze and stainless steel. These stones can be quickly and easily shaped.



Dimensions	Grit size	Type	Order No.	Price from		
				1 piece	12 pieces	60 pieces
<b>Grinding and polishing stones Gesswein® ULTRASOFT</b>						
<b>square</b>						
6 x 6 x 150 mm	120	ULTRASOFT 7102	<b>0 401 724</b>			
	320	ULTRASOFT 7302	<b>0 401 725</b>			
	600	ULTRASOFT 7602	<b>0 401 726</b>			
	1200	ULTRASOFT 7002	<b>0 401 727</b>			
<b>rectangular</b>						
13 x 3 x 150 mm	120	ULTRASOFT 7103	<b>0 401 728</b>			
	320	ULTRASOFT 7303	<b>0 401 729</b>			
	600	ULTRASOFT 7603	<b>0 401 730</b>			
	1200	ULTRASOFT 7003	<b>0 401 731</b>			
13 x 6 x 150 mm	120	ULTRASOFT 7104	<b>0 401 732</b>			
	320	ULTRASOFT 7304	<b>0 401 733</b>			
	600	ULTRASOFT 7604	<b>0 401 734</b>			
	1200	ULTRASOFT 7004	<b>0 401 735</b>			
25 x 13 x 150 mm	120	ULTRASOFT 7107	<b>0 401 736</b>			
	320	ULTRASOFT 7307	<b>0 401 737</b>			



**Bonding**



**Stock removal**



**Wear**



**Application**



# Grinding and polishing stones

## Gesswein® PREMIUM WHITE

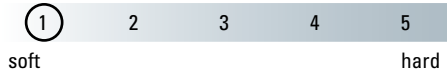
The medium-hard PREMIUM WHITE stones are ideally suited for all work on tool steels and have good dimensional stability. The stones are also suitable for use in ultrasonic polishing systems.



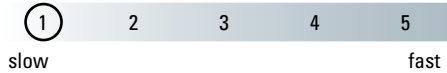
Dimensions	Grit size	Type	Packing quantity	Order No.	Price from	
					1 piece	60 pieces
<b>Grinding and polishing stones Gesswein® PREMIUM WHITE</b>						
<b>square</b>						
6 x 6 x 150 mm	600	PREMIUM WHITE 802	12 pieces	<b>0 401 131-1</b>		
<b>rectangular</b>						
6 x 3 x 150 mm	600	PREMIUM WHITE 801	12 pieces	<b>0 401 130-1</b>		
13 x 3 x 150 mm	600	PREMIUM WHITE 803	12 pieces	<b>0 401 132-1</b>		
13 x 6 x 150 mm	600	PREMIUM WHITE 804	12 pieces	<b>0 401 133-1</b>		



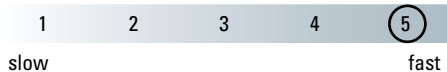
### Bonding



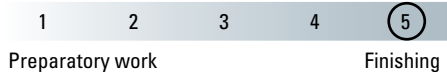
### Stock removal



### Wear



### Application





## 2 Grinding and polishing stones

### Gesswein® SUPER FINE

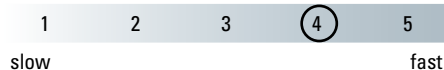
Very good all-round stone with rapid stock removal and high dimensional stability. Contains brown aluminium oxide, with tough, blocky abrasive grit. The special impregnation results in good self-lubrication and high load-bearing capacity of the polishing stones. G2 - Stones create a smooth and silky finish on the surface.



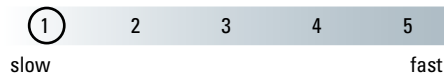
#### Bonding



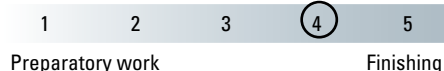
#### Stock removal



#### Wear



#### Application

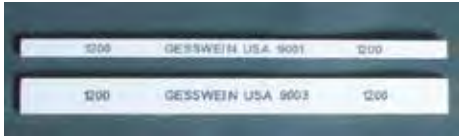


Dimensions	Grit size	Type	Packing quantity	Order No.	Price from	
					1 pieces	60 pieces
<b>Grinding and polishing stones Gesswein® G2</b>						
<b>square</b>						
6 x 6 x 150 mm	150	G2	12 pieces	<b>0 416 030</b>		
	220	G2	12 pieces	<b>0 416 031</b>		
	320	G2	12 pieces	<b>0 416 032</b>		
	400	G2	12 pieces	<b>0 416 033</b>		
	600	G2	12 pieces	<b>0 416 034</b>		
	800	G2	12 pieces	<b>0 416 035</b>		
	1200	G2	12 pieces	<b>0 416 036</b>		
<b>rectangular</b>						
13 x 6 x 150 mm	150	G2	12 pieces	<b>0 416 010</b>		
	220	G2	12 pieces	<b>0 416 011</b>		
	320	G2	12 pieces	<b>0 416 012</b>		
	400	G2	12 pieces	<b>0 416 013</b>		
	600	G2	12 pieces	<b>0 416 014</b>		
	800	G2	12 pieces	<b>0 416 015</b>		
	1200	G2	12 pieces	<b>0 416 016</b>		
6 x 3 x 150 mm	150	G2	12 pieces	<b>0 416 020</b>		
	220	G2	12 pieces	<b>0 416 021</b>		
	320	G2	12 pieces	<b>0 416 022</b>		
	400	G2	12 pieces	<b>0 416 023</b>		
	600	G2	12 pieces	<b>0 416 024</b>		
	800	G2	12 pieces	<b>0 416 025</b>		
	1200	G2	12 pieces	<b>0 416 026</b>		
13 x 3 x 150 mm	150	G2	12 pieces	<b>0 416 037</b>		
	220	G2	12 pieces	<b>0 416 038</b>		
	320	G2	12 pieces	<b>0 416 039</b>		
	400	G2	12 pieces	<b>0 416 040</b>		
	600	G2	12 pieces	<b>0 416 041</b>		
	800	G2	12 pieces	<b>0 416 042</b>		
	1200	G2	12 pieces	<b>0 416 043</b>		
25 x 6 x 150 mm	150	G2	12 pieces	<b>0 416 050</b>		
	220	G2	12 pieces	<b>0 416 051</b>		
	320	G2	12 pieces	<b>0 416 052</b>		
	400	G2	12 pieces	<b>0 416 053</b>		
	600	G2	12 pieces	<b>0 416 054</b>		
	800	G2	12 pieces	<b>0 416 055</b>		
	1200	G2	12 pieces	<b>0 416 056</b>		

# Grinding and polishing stones

## Gesswein® SUPER FINE

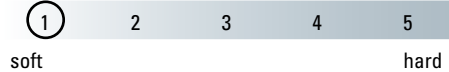
These stones are recommended for an extra-fine surface finish on the workpiece. They are made of levigated alumina in grit size finer than 1200. These stones are guaranteed not to scratch and are eminently suitable for polishing with a diamond compound.



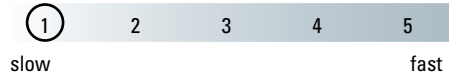
Dimensions	Grit size	Type	Order No.	Price from		
				1 piece	12 pieces	60 pieces
<b>Grinding and polishing stones Gesswein® SUPER FINE</b>						
<b>square</b>						
4 x 4 x 100 mm	1200	SUPER FINE 12	<b>0 401 210</b>			
6 x 6 x 150 mm	1200	SUPER FINE 9002	<b>0 401 212</b>			
<b>rectangular</b>						
6 x 3 x 150 mm	1200	SUPER FINE 9001	<b>0 401 211</b>			
13 x 3 x 150 mm	1200	SUPER FINE 9003	<b>0 401 213</b>			
13 x 6 x 150 mm	1200	SUPER FINE 9004	<b>0 401 214</b>			



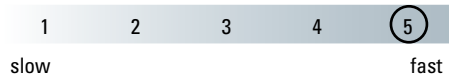
### Bonding



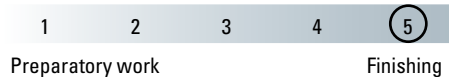
### Stock removal



### Wear



### Application



## 2 Grinding and polishing stones

### Gesswein® GP – General Purpose

The polishing stone GP from Gesswein® is ideally suited for both eroded and machined surfaces of all tool steels and hardened steels. Owing to its special, medium-hard bond made of extra sharp, white aluminium oxide particles, it guarantees high stock removal with simultaneously low wear and a high level of dimensional stability. Grinding stone oil (fluid) is also recommended for processing.



#### Bonding

1	2	3	4	5
soft				hard

#### Stock removal

1	2	3	4	5
slow				fast

#### Wear

1	2	3	4	5
slow				fast

#### Application

1	2	3	4	5
Preparatory work				Finishing

Dimensions	Grit size	Type	Packing quantity	Order No.	Price from	
					1 pieces	60 pieces
<b>Grinding and polishing stones Gesswein® GP – General Purpose</b>						
<b>square</b>						
4 x 4 x 100 mm	150	GP	12 pieces	<b>0 405 101</b>		
	320	GP	12 pieces	<b>0 405 100</b>		
6 x 6 x 150 mm	150	GP	12 pieces	<b>0 405 118</b>		
	180	GP	12 pieces	<b>0 405 119</b>		
	220	GP	12 pieces	<b>0 405 120</b>		
	320	GP	12 pieces	<b>0 405 121</b>		
	400	GP	12 pieces	<b>0 405 122</b>		
	600	GP	12 pieces	<b>0 405 123</b>		
	800	GP	12 pieces	<b>0 405 124</b>		
	1200	GP	12 pieces	<b>0 405 125</b>		
	<b>rectangular</b>					
6 x 3 x 150 mm	150	GP	12 pieces	<b>0 405 110</b>		
	180	GP	12 pieces	<b>0 405 111</b>		
	220	GP	12 pieces	<b>0 405 112</b>		
	320	GP	12 pieces	<b>0 405 113</b>		
	400	GP	12 pieces	<b>0 405 114</b>		
	600	GP	12 pieces	<b>0 405 115</b>		
	800	GP	12 pieces	<b>0 405 116</b>		
13 x 3 x 150 mm	1200	GP	12 pieces	<b>0 405 117</b>		
	150	GP	12 pieces	<b>0 405 126</b>		
	180	GP	12 pieces	<b>0 405 127</b>		
	220	GP	12 pieces	<b>0 405 128</b>		
	320	GP	12 pieces	<b>0 405 129</b>		
	400	GP	12 pieces	<b>0 405 130</b>		
	600	GP	12 pieces	<b>0 405 131</b>		
	800	GP	12 pieces	<b>0 405 132</b>		
	1200	GP	12 pieces	<b>0 405 133</b>		
	13 x 6 x 150 mm	150	GP	12 pieces	<b>0 405 134</b>	
180		GP	12 pieces	<b>0 405 135</b>		
220		GP	12 pieces	<b>0 405 136</b>		
320		GP	12 pieces	<b>0 405 137</b>		
400		GP	12 pieces	<b>0 405 138</b>		
600		GP	12 pieces	<b>0 405 139</b>		
800		GP	12 pieces	<b>0 405 140</b>		
1200		GP	12 pieces	<b>0 405 141</b>		

**Bonding**

1	2	3	4	5
soft				hard

**Stock removal**

1	2	3	4	5
slow				fast

**Wear**

1	2	3	4	5
slow				fast

**Application**

1	2	3	4	5
Preparatory work				Finishing

**Bonding**

1	2	3	4	5
soft				hard

**Stock removal**

1	2	3	4	5
slow				fast

**Wear**

1	2	3	4	5
slow				fast

**Application**

1	2	3	4	5
Preparatory work				Finishing

## Grinding and polishing stones Boride® CS-HD

2

Extremely hard stones made of silicon carbide for the pretreatment in hard moulds (> 47 HRC). Can be used manually or in a handfiling machine, dry or with a fluid.

Dimensions	Grit size	Type	Packing quantity	Order No.	Price from	
					1 pieces	60 pieces
<b>Grinding and polishing stones Boride® CS-HD</b>						
<b>rectangular</b>						
6 x 3 x 150 mm	120	CS-HD	12 pieces		<b>0 410 861</b>	
	150	CS-HD	12 pieces		<b>0 410 862</b>	
	220	CS-HD	12 pieces		<b>0 410 864</b>	
	320	CS-HD	12 pieces		<b>0 410 866</b>	
	400	CS-HD	12 pieces		<b>0 410 867</b>	
	600	CS-HD	12 pieces		<b>0 410 868</b>	
13 x 6 x 150 mm	120	CS-HD	12 pieces		<b>0 410 901</b>	
	150	CS-HD	12 pieces		<b>0 410 903</b>	
	220	CS-HD	12 pieces		<b>0 410 904</b>	
	320	CS-HD	12 pieces		<b>0 410 906</b>	
	400	CS-HD	12 pieces		<b>0 410 907</b>	
	600	CS-HD	12 pieces		<b>0 410 908</b>	

## Grinding and polishing stones Boride® T2

These stones are perfect for high-alloyed tools and high-grade steels. Thanks to their own impregnation, these stones work very efficiently and produce a semi matt surface on the workpiece. Can be used manually or in a handfiling machine, with a fluid.

Dimensions	Grit size	Type	Packing quantity	Order No.	Price from	
					1 pieces	60 pieces
<b>Grinding and polishing stones Boride® T2</b>						
<b>rectangular</b>						
6 x 3 x 150 mm	150	T2	12 pieces		<b>0 409 952</b>	
	220	T2	12 pieces		<b>0 409 954</b>	
	320	T2	12 pieces		<b>0 409 956</b>	
	400	T2	12 pieces		<b>0 409 957</b>	
	600	T2	12 pieces		<b>0 409 958</b>	
13 x 6 x 150 mm	150	T2	12 pieces		<b>0 409 932</b>	
	220	T2	12 pieces		<b>0 409 934</b>	
	320	T2	12 pieces		<b>0 409 936</b>	
	400	T2	12 pieces		<b>0 409 937</b>	
	600	T2	12 pieces		<b>0 409 938</b>	

## 2 Grinding and polishing stones

### Boride® Orange EDM

The EDM orange grinding and polishing stones in aluminium oxide have been developed for the removal of erosion layers. The bonding allows rapid adaptation to the contour with good dimensional stability. Good stock removal. Can be used manually or in a handfiling machine, either dry or with a fluid.



#### Bonding

1	2	3	4	5
soft				hard

#### Stock removal

1	2	3	4	5
slow				fast

#### Wear

1	2	3	4	5
slow				fast

#### Application

1	2	3	4	5
Preparatory work				Finishing

Dimensions	Grit size	Type	Packing quantity	Order No.	Price from	
					1 pieces	60 pieces
<b>Grinding and polishing stones Boride® Orange EDM</b>						
<b>square</b>						
6 x 6 x 150 mm	120	Orange EDM	12 pieces	<b>0 409 372</b>		
	180	Orange EDM	12 pieces	<b>0 409 373</b>		
	220	Orange EDM	12 pieces	<b>0 409 374</b>		
	320	Orange EDM	12 pieces	<b>0 409 376</b>		
	400	Orange EDM	12 pieces	<b>0 409 377</b>		
	600	Orange EDM	12 pieces	<b>0 409 378</b>		
<b>rectangular</b>						
6 x 3 x 150 mm	120	Orange EDM	12 pieces	<b>0 409 332</b>		
	180	Orange EDM	12 pieces	<b>0 409 333</b>		
	220	Orange EDM	12 pieces	<b>0 409 334</b>		
	320	Orange EDM	12 pieces	<b>0 409 336</b>		
	400	Orange EDM	12 pieces	<b>0 409 337</b>		
	600	Orange EDM	12 pieces	<b>0 409 338</b>		
13 x 3 x 150 mm	120	Orange EDM	12 pieces	<b>0 409 342</b>		
	180	Orange EDM	12 pieces	<b>0 409 343</b>		
	220	Orange EDM	12 pieces	<b>0 409 344</b>		
	320	Orange EDM	12 pieces	<b>0 409 346</b>		
	400	Orange EDM	12 pieces	<b>0 409 347</b>		
	600	Orange EDM	12 pieces	<b>0 409 348</b>		
13 x 6 x 150 mm	120	Orange EDM	12 pieces	<b>0 409 382</b>		
	180	Orange EDM	12 pieces	<b>0 409 383</b>		
	220	Orange EDM	12 pieces	<b>0 409 384</b>		
	320	Orange EDM	12 pieces	<b>0 409 386</b>		
	400	Orange EDM	12 pieces	<b>0 409 387</b>		
	600	Orange EDM	12 pieces	<b>0 409 388</b>		

# Grinding and polishing stones

## Boride® A0

2

Very aggressive allround stones in aluminium oxide for all steels in tool and mould building. These grinding stones have a semi-hard bonding and are oil impregnated, so that they do not clog easily. A0 stones are dimensionally stable and offer a good cutting performance. High stock removal rates with milling and erosion structures. Can be used manually or in a hand-filing machine, always with a fluid.



### Bonding

1	2	3	4	5
soft				hard

### Stock removal

1	2	3	4	5
slow				fast

### Wear

1	2	3	4	5
slow				fast

### Application

1	2	3	4	5
Preparatory work				Finishing

Dimensions	Grit size	Type	Packing quantity	Order No.	Price from	
					1 pieces	60 pieces
<b>Grinding and polishing stones Boride® A0</b>						
<b>round</b>						
Ø 10 x 140 mm	150	A0	12 pieces	<b>0 410 692</b>		
	220	A0	12 pieces	<b>0 410 694</b>		
	320	A0	12 pieces	<b>0 410 696</b>		
	400	A0	12 pieces	<b>0 410 697</b>		
<b>rectangular</b>						
6 x 3 x 150 mm	120	A0	12 pieces	<b>0 410 531</b>		
	150	A0	12 pieces	<b>0 410 532</b>		
	220	A0	12 pieces	<b>0 410 534</b>		
	320	A0	12 pieces	<b>0 410 536</b>		
	400	A0	12 pieces	<b>0 410 537</b>		
	600	A0	12 pieces	<b>0 410 538</b>		
13 x 3 x 150 mm	120	A0	12 pieces	<b>0 410 541</b>		
	150	A0	12 pieces	<b>0 410 542</b>		
	220	A0	12 pieces	<b>0 410 544</b>		
	320	A0	12 pieces	<b>0 410 546</b>		
	400	A0	12 pieces	<b>0 410 547</b>		
	600	A0	12 pieces	<b>0 410 548</b>		
13 x 6 x 150 mm	120	A0	12 pieces	<b>0 410 581</b>		
	150	A0	12 pieces	<b>0 410 582</b>		
	220	A0	12 pieces	<b>0 410 584</b>		
	320	A0	12 pieces	<b>0 410 586</b>		
	400	A0	12 pieces	<b>0 410 587</b>		
	600	A0	12 pieces	<b>0 410 588</b>		
25 x 13 x 150 mm	120	A0	12 pieces	<b>0 410 621</b>		
	150	A0	12 pieces	<b>0 410 622</b>		
	220	A0	12 pieces	<b>0 410 624</b>		
	320	A0	12 pieces	<b>0 410 626</b>		
	400	A0	12 pieces	<b>0 410 627</b>		
	600	A0	12 pieces	<b>0 410 628</b>		



## 2 Grinding and polishing stones

### Boride® Golden Star

The Golden Star is a premium corundum stone which, owing to its specially developed treatment, leaves a silky smooth finish. Excellent for eroded and milled surfaces. The stone is of moderate hardness and achieves rapid stock removal. The stone is used dry; even better results are achieved in conjunction with fluid.



#### Bonding

1	2	3	4	5
soft				hard

#### Stock removal

1	2	3	4	5
slow				fast

#### Wear

1	2	3	4	5
slow				fast

#### Application

1	2	3	4	5
Preparatory work				Finishing

Dimensions	Grit size	Type	Packing quantity	Order No.	Price from	
					1 piece	60 pieces
<b>Grinding and polishing stones Boride® Golden Star</b>						
<b>rectangular</b>						
6 x 3 x 150 mm	150	Golden Star	12 pieces	<b>0 407 811</b>		
	180	Golden Star	12 pieces	<b>0 407 812</b>		
	220	Golden Star	12 pieces	<b>0 407 813</b>		
	320	Golden Star	12 pieces	<b>0 407 814</b>		
	400	Golden Star	12 pieces	<b>0 407 815</b>		
	600	Golden Star	12 pieces	<b>0 407 816</b>		
	800	Golden Star	12 pieces	<b>0 407 817</b>		
13 x 3 x 150 mm	150	Golden Star	12 pieces	<b>0 407 821</b>		
	180	Golden Star	12 pieces	<b>0 407 822</b>		
	220	Golden Star	12 pieces	<b>0 407 823</b>		
	320	Golden Star	12 pieces	<b>0 407 824</b>		
	400	Golden Star	12 pieces	<b>0 407 825</b>		
	600	Golden Star	12 pieces	<b>0 407 826</b>		
	800	Golden Star	12 pieces	<b>0 407 827</b>		
13 x 6 x 150 mm	150	Golden Star	12 pieces	<b>0 407 851</b>		
	180	Golden Star	12 pieces	<b>0 407 852</b>		
	220	Golden Star	12 pieces	<b>0 407 853</b>		
	320	Golden Star	12 pieces	<b>0 407 854</b>		
	400	Golden Star	12 pieces	<b>0 407 855</b>		
	600	Golden Star	12 pieces	<b>0 407 856</b>		
	800	Golden Star	12 pieces	<b>0 407 857</b>		
1000	Golden Star	12 pieces	<b>0 407 858</b>			

# Grinding and polishing stones

## Boride® AM-2

2

These universal AM-2 grinding and polishing stones in aluminium oxide are used for all types of steel in mould and tool building. Owing to the uniform stock removal with a fine grinding pattern, the AM-2 abrasive stone is also very suitable for all non-ferrous metals, aluminium, copper and high-chrome and high-nickel steels. The semi-hard stones are used with fluid up to the very fine finishing stage with K 900.

Tip: When processing aluminum, work should be performed from 320 onwards with an abrasive cloth.



### Bonding

1	2	3	4	5
soft				hard

### Stock removal

1	2	3	4	5
slow				fast

### Wear

1	2	3	4	5
slow				fast

### Application

1	2	3	4	5
Preparatory work				Finishing

Dimensions	Grit size	Type	Packing quantity	Order No.	Price from	
					1 pieces	60 pieces
<b>Grinding and polishing stones Boride® AM-2</b>						
<b>square</b>						
6 x 6 x 150 mm	100	AM-2	12 pieces	<b>0 410 270</b>		
	150	AM-2	12 pieces	<b>0 410 272</b>		
	180	AM-2	12 pieces	<b>0 410 273</b>		
	220	AM-2	12 pieces	<b>0 410 274</b>		
	280	AM-2	12 pieces	<b>0 410 275</b>		
	320	AM-2	12 pieces	<b>0 410 276</b>		
	400	AM-2	12 pieces	<b>0 410 277</b>		
	600	AM-2	12 pieces	<b>0 410 278</b>		
	900	AM-2	12 pieces	<b>0 410 279</b>		
<b>rectangular</b>						
6 x 3 x 150 mm	100	AM-2	12 pieces	<b>0 410 230</b>		
	150	AM-2	12 pieces	<b>0 410 232</b>		
	180	AM-2	12 pieces	<b>0 410 233</b>		
	220	AM-2	12 pieces	<b>0 410 234</b>		
	280	AM-2	12 pieces	<b>0 410 235</b>		
	320	AM-2	12 pieces	<b>0 410 236</b>		
	400	AM-2	12 pieces	<b>0 410 237</b>		
	600	AM-2	12 pieces	<b>0 410 238</b>		
	900	AM-2	12 pieces	<b>0 410 239</b>		
13 x 3 x 150 mm	100	AM-2	12 pieces	<b>0 410 240</b>		
	150	AM-2	12 pieces	<b>0 410 242</b>		
	180	AM-2	12 pieces	<b>0 410 243</b>		
	220	AM-2	12 pieces	<b>0 410 244</b>		
	280	AM-2	12 pieces	<b>0 410 245</b>		
	320	AM-2	12 pieces	<b>0 410 246</b>		
	400	AM-2	12 pieces	<b>0 410 247</b>		
	600	AM-2	12 pieces	<b>0 410 248</b>		
	900	AM-2	12 pieces	<b>0 410 249</b>		
13 x 6 x 150 mm	100	AM-2	12 pieces	<b>0 410 280</b>		
	150	AM-2	12 pieces	<b>0 410 282</b>		
	180	AM-2	12 pieces	<b>0 410 283</b>		
	220	AM-2	12 pieces	<b>0 410 284</b>		
	280	AM-2	12 pieces	<b>0 410 285</b>		
	320	AM-2	12 pieces	<b>0 410 286</b>		
	400	AM-2	12 pieces	<b>0 410 287</b>		
	600	AM-2	12 pieces	<b>0 410 288</b>		
	900	AM-2	12 pieces	<b>0 410 289</b>		
25 x 13 x 150 mm	100	AM-2	12 pieces	<b>0 410 320</b>		
	150	AM-2	12 pieces	<b>0 410 322</b>		
	180	AM-2	12 pieces	<b>0 410 323</b>		
	220	AM-2	12 pieces	<b>0 410 324</b>		
	280	AM-2	12 pieces	<b>0 410 325</b>		
	400	AM-2	12 pieces	<b>0 410 327</b>		

## 2 Grinding and polishing stones Boride® RO-MED

These grinding and polishing stones have been especially developed for use in large moulds and are therefore only available in large grit sizes. They offer particularly fast and aggressive stock removal. Thanks to their medium-hard bond, they adapt quickly to the geometry.



Dimensions	Grit size	Type	Packing quantity	Order No.	Price from	
					1 piece	60 pieces
<b>Grinding and polishing stones Boride® RO-MED</b>						
<b>rectangular</b>						
25 x 13 x 200 mm	80	RO-MED	12 pieces	<b>0 410 970</b>		
	100	RO-MED	12 pieces	<b>0 410 971</b>		
	150	RO-MED	12 pieces	<b>0 410 972</b>		
	220	RO-MED	12 pieces	<b>0 410 974</b>		



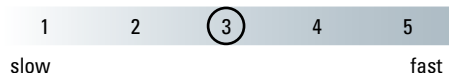
### Bonding



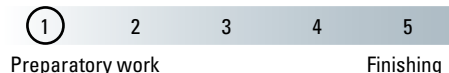
### Stock removal




### Wear



### Application



## Fluid for grinding and polishing stones Boride® Bori Lube 10

Fluid Boride®	Content	Order No.	Price from
			1 piece
 <p>Experience improved cutting performance and cleaning with original Boride® abrasive stone fluid. Our recommendation for all our grinding and polishing stones.</p>	3.8 l	<b>0 409 046</b>	

# Grinding and polishing stones

## Boride® RASP

The RASP stones from Boride® are now also available from joke and are manufactured from the finest quality aluminium dioxide. This universal stone is optimally suited for most tool steels, aluminium and even EDM surfaces. They are often used for cutting and finishing, but the stones can also cope with surface lapping. RASP stones are of very high quality, are durable and readily adapt to your workpiece. Owing to its special composition, it is to be used wet and dry.



### Bonding



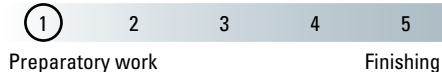
### Stock removal



### Wear



### Application



Dimensions	Grit size	Type	Packing quantity	Order No.	Price from	
					1 pieces	60 pieces
<b>Grinding and polishing stones Boride® RASP</b>						
<b>square</b>						
6 x 6 x 150 mm	150	RASP	12 pieces	<b>0 407 892</b>		
	220	RASP	12 pieces	<b>0 407 893</b>		
	320	RASP	12 pieces	<b>0 407 894</b>		
	400	RASP	12 pieces	<b>0 407 895</b>		
	600	RASP	12 pieces	<b>0 407 896</b>		
	900	RASP	12 pieces	<b>0 407 897</b>		
	1200	RASP	12 pieces	<b>0 407 898</b>		
13 x 13 x 150 mm	150	RASP	12 pieces	<b>0 407 926</b>		
	220	RASP	12 pieces	<b>0 407 927</b>		
	320	RASP	12 pieces	<b>0 407 928</b>		
	400	RASP	12 pieces	<b>0 407 929</b>		
	600	RASP	12 pieces	<b>0 407 930</b>		
	900	RASP	12 pieces	<b>0 407 931</b>		
	1200	RASP	12 pieces	<b>0 407 932</b>		
<b>rectangular</b>						
6 x 3 x 150 mm	150	RASP	12 pieces	<b>0 407 869</b>		
	220	RASP	12 pieces	<b>0 407 879</b>		
	320	RASP	12 pieces	<b>0 407 880</b>		
	400	RASP	12 pieces	<b>0 407 881</b>		
	600	RASP	12 pieces	<b>0 407 882</b>		
	900	RASP	12 pieces	<b>0 407 883</b>		
	1200	RASP	12 pieces	<b>0 407 884</b>		
13 x 3 x 150 mm	150	RASP	12 pieces	<b>0 407 885</b>		
	220	RASP	12 pieces	<b>0 407 886</b>		
	320	RASP	12 pieces	<b>0 407 887</b>		
	400	RASP	12 pieces	<b>0 407 888</b>		
	600	RASP	12 pieces	<b>0 407 889</b>		
	900	RASP	12 pieces	<b>0 407 890</b>		
	1200	RASP	12 pieces	<b>0 407 891</b>		
13 x 6 x 150 mm	150	RASP	12 pieces	<b>0 407 899</b>		
	220	RASP	12 pieces	<b>0 407 920</b>		
	320	RASP	12 pieces	<b>0 407 921</b>		
	400	RASP	12 pieces	<b>0 407 922</b>		
	600	RASP	12 pieces	<b>0 407 923</b>		
	900	RASP	12 pieces	<b>0 407 924</b>		
	1200	RASP	12 pieces	<b>0 407 925</b>		

## 2 Grinding and polishing stones

### Boride® CS-M

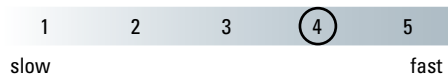
The medium-soft bond of these premium silicon carbide stones allows high stock removal rates without clogging. CS-M stones are generally used with a fluid, either manually or with a hand-filing machine.



#### Bonding



#### Stock removal



#### Wear





#### Application



Dimensions	Grit size	Type	Packing quantity	Order No.	Price from	
					1 pieces	60 pieces
<b>Grinding and polishing stones Boride® CS-M</b>						
<b>rectangular</b>						
13 x 6 x 150 mm	120	CS-M	12 pieces	<b>0 410 761</b>		
	150	CS-M	12 pieces	<b>0 410 762</b>		
	220	CS-M	12 pieces	<b>0 410 764</b>		
	320	CS-M	12 pieces	<b>0 410 766</b>		
	400	CS-M	12 pieces	<b>0 410 767</b>		
	600	CS-M	12 pieces	<b>0 410 768</b>		

## Bench stones


These stones can be used on both sides and are available in aluminium oxide or silicon carbide. Combination of K 120 and 320.


Design	Dimensions	Grit size	Order No.	Price from
				1 piece
<b>Bench stones</b>				
<b>rectangular</b>				
	Aluminium oxide	25 x 50 x 200 mm	# 120 / 320	<b>0 401 754</b>
	silicon carbide	25 x 50 x 150 mm	# 120 / 320	<b>0 401 758</b>


# Grinding and polishing stones


## Boride® Test sets

Our Boride® test sets are ideal for trying out these products. Without minimum order, you can easily send an order for 5 grinding and polishing stones respectively in different grit sizes.

	Order No.	Price from 1 set
<b>Test set Boride® Golden Star</b>		
	5 abrasive test stones (13 x 3 x 150 mm), grit sizes 150, 220, 320, 400, 600	<b>0 407 800</b>

	Order No.	Price from 1 set
<b>Test set Boride® Golden Star</b>		
	5 abrasive test stones (13 x 3 x 150 mm), grit sizes 320, 400, 600, 800, 1000	<b>0 407 820</b>

	Order No.	Price from 1 set
<b>Test set Boride® Orange EDM</b>		
	5 abrasive test stones (13 x 3 x 150 mm), grit sizes 150, 220, 320, 400, 600	<b>0 409 300</b>




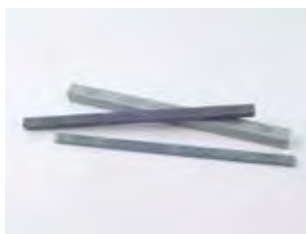
	Order No.	Price from 1 set
<b>Test set Boride® T2</b>		
	5 abrasive test stones (13 x 3 x 150 mm), grit sizes 150, 220, 320, 400, 600	<b>0 409 900</b>















## 2 Grinding and polishing stones

### Boride® Test sets





Our Boride® test sets are ideal for trying out these products. Without minimum order, you can easily send an order for 5 grinding and polishing stones respectively in different grit sizes.

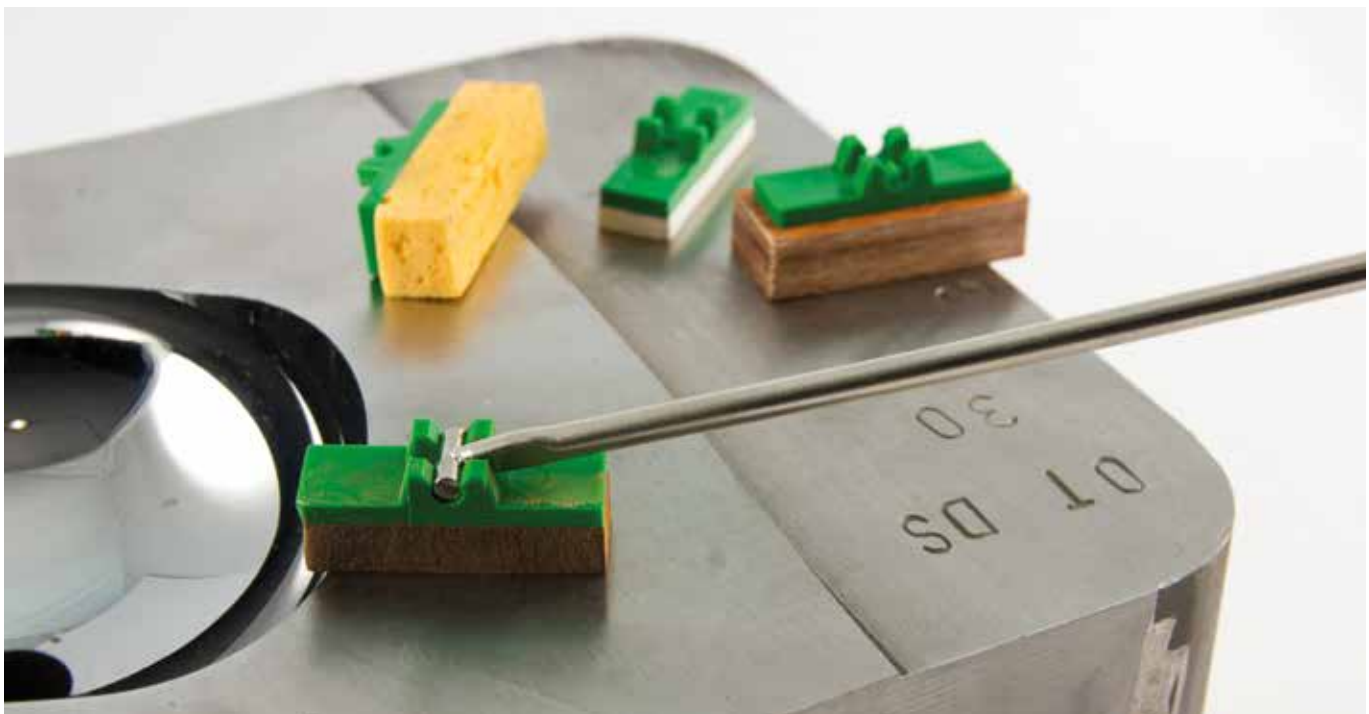
	Order No.	Price from 1 set
<b>Test set Boride® AM-2</b> 		<b>0 410 390</b>
<b>Test set Boride® AO</b> 		<b>0 410 500</b>
<b>Test set Boride® CS-M</b> 		<b>0 410 700</b>
<b>Test set Boride® CS-HD</b> 		<b>0 410 850</b>

## 2 Holders for grinding and polishing stones for hand and machine use

	Shank dimensions	Packing quantity	Order No.	Price from		
				1 piece	1 set	1 pack
<b>Tool holder for grinding stones</b>						
	for receiving grinding stones up to 6 mm, on both sides, for round and square stones		<b>0 401 215-0</b>			
<b>Tool holder B</b>						
	for receiving grinding stones 4 x 4, 6 x 6 or 6 x 3 mm		<b>0 401 216</b>			
<b>Tool holder, single</b>						
	for grinding stones 6 x 13 mm		<b>0 401 228</b>			
<b>Tool holder, double</b>						
	for receiving stones 1.6 x 13, 6 x 6 or 6 x 3 mm		<b>0 401 227</b>			
<b>Tool holder range</b>						
	for receiving grinding stones 4 x 4, 6 x 6 or 6 x 3 mm on both sides (3 pieces, blue, red, black)	3 pieces	<b>0 401 500</b>			
<b>Tool holder for lapping sticks</b>						
	head pivotable through 90°, for receiving tool up to 10 x 10 mm	Ø 3 x 35 mm	<b>0 411 291</b>			
	for receiving tool up to 8 mm high	Ø 3.5 x 30 mm	<b>0 411 292</b>			
	for receiving tool up to 8 mm high	Ø 6 x 30 mm	<b>0 411 201</b>			
<b>Holder for grinding files</b>						
	clamping height up to 11 mm	Ø 4 x 50 mm	<b>0 401 959</b>			
<b>Tool holder Premium, mini</b>						
	clamping range: height up to 8 mm, hardened finish, high-strength clamping plate	Ø 3 mm	<b>0 401 951</b>			
<b>Tool holder Premium, medium</b>						
	clamping range: height 6 mm, hardened finish. Shank and body manufactured from a piece of high-strength clamping plate. With recess for 6 mm flat and round stones.	Ø 3 mm	<b>0 401 972</b>			
<b>Tool holder with counter-clamping</b>						
	sturdy holder for clamping round and flat tools up to max. 3 mm. All solid carbide (VHM) round rods (see articles: 2 012 498 and 2 012 499) are used as a clamping shank for handpieces and/or hand-filing machines and are simply clamped and screwed to the rear of the holder		<b>0 750 710</b>			




## 2 Holders for grinding and polishing stones for hand and machine use

	Shank dimensions	Packing quantity	Order No.	Price from		
				1 piece	1 set	1 pack
<b>VHM round rod head Ø 3 mm</b>						
 length 50 mm			<b>2 012 498</b>			
<b>VHM round rod head Ø 6 mm</b>						
 length 50 mm			<b>2 012 499</b>			
<b>Tool carrier, 30 x 9 x 2 mm (pack: 10 pieces)</b>						
 without tool		10 pieces	<b>0 411 009</b>			
<b>Toggle rod for tool carrier</b>						
	Ø 3.5 mm x 140 mm	Ø 3.5 mm	<b>0 411 008</b>			



## Tool holder system with counter clamping **2**

An ergonomically designed handle, which can be used with eight different inserts. The lock nut fixes the insert and therefore clamps the inserted tools. Available as single pieces on demand or in a set with eight "completely equipped" handles.

Dimensions	Order No.	Price from 1 piece
<b>Tool holder handle, without lock nut</b>		
	<b>0 401 981</b>	
<b>Tool holder lock nut</b>		
	<b>0 401 982</b>	
<b>Tool holder insert</b>		
 3 x 6 mm	<b>0 401 984</b>	
3 x 13 mm	<b>0 401 983</b>	
4 x 4 mm	<b>0 401 985</b>	
6 x 6 mm	<b>0 401 986</b>	
6 x 13 mm	<b>0 401 987</b>	
10 x 10 mm	<b>0 401 988</b>	
Ø 6 mm	<b>0 401 989</b>	
Ø 10 mm	<b>0 401 990</b>	

 *matching set*

	Order No.	Price from 1 set
<b>Tool holder set</b>		
The set contains 8 complete handles with inserts for the following tools: flat: 3 x 6 mm, 3 x 13 mm and 6 x 13 mm, square: 3 x 4 mm, 3 x 13 mm and 10 x 13 mm, round: Ø 6 mm and Ø 10 mm	<b>0 401 980</b>	



# Ceramic-fibre tools

The ceramic-fibre files from JOKER are highly versatile tools. They are above all used wherever you get bogged down with conventional tools, for example at highly filigree spots such as slots, ribs and ridges, etc. Ideal for removing erosion structures. Very good results are achieved during use as lapping and polishing tools in conjunction with diamond compounds. They can be used manually (e.g. in special file holders, see page 281) or with the aid of a hand-filing machine. Ceramic-fibre files make a perfect team in conjunction with ultrasonic polishing systems.

In this case however, we recommend the special HT-140 or the particularly heat-resistant Ultra-HT files, which with greater heat resistance also withstand very high output ratings, without proverbially "burning away". With the mini ceramic files, you can process even the most filigree areas; the soft files are highly adaptable owing to the rubbery bond and do not leave any scratches whatsoever. You will also find a matching selection of holders available from us for convenient manual use of the files. The range is rounded off by the ceramic fibre files and brushes on a shank.



## Five facts about the JOKER ceramic-fibre files

1. The files are no. 1 when it comes to heat resistance (an upper temperature limit higher by 30 °C in comparison!)
2. The JOKER files and the ENESKAsonic system have been optimally adapted to one another!
3. Specially developed polishing fibres allow maximum stock removals and absolutely uniform finishing quality!
4. A combination of polishing fibres and a special bond prevent splintering at the tip!
5. Integrated development and production from the initial fibre to the finished product guarantee consistent product quality and constant optimisation!

**267** Ceramic-fibre files  
JOKER ULTRA-HT

**268** Ceramic-fibre files  
JOKER HT-140

**270** Ceramic-fibre files  
NEW Super Stone

**278** Diamond ceramic-fibre files

**279** Ceramic-fibre files  
JOKER Mini

**279** Ceramic-fibre files  
JOKER Soft

**279** Set: Holder +  
ceramic-fibre files

**281** Holders for  
ceramic-fibre files

**281** Ceramic-fibre files on a shank

**282** Ceramic-fibre brushes

**283** Ceramic-fibre brushes  
Cross Hole

**284** Crystal fibre cutting disc  
Cristone

# Ceramic-fibre files joke Ultra-HT

## heat-resistant up to 200 °C

**2**

These files are heat-resistant up to 200 °C and therefore optimally suitable for the high-performance ultrasonic polishing systems. Even under high loads, the ceramic-fibre files remain break-resistant and do not get clogged up during processing.



	Dimensions	Grit size	Colour	Order No.	Price from		
					1 piece	5 pieces	10 pieces
<b>Ceramic-fibre files joke Ultra-HT</b>							
<b>flat</b>							
ⓘ You'll find suitable holders for these files on page 281!	1 x 4 x 100 mm	# 120 / 110 µm	violet	<b>0 424 601</b>			
		# 220 / 50 µm	dark brown	<b>0 424 611</b>			
		# 400 / 30 µm	orange	<b>0 424 641</b>			
		# 800 / 20 µm	blue	<b>0 424 621</b>			
		# 1200 / 10 µm	red	<b>0 424 631</b>			
	1 x 6 x 100 mm	# 120 / 110 µm	violet	<b>0 424 602</b>			
		# 220 / 50 µm	dark brown	<b>0 424 612</b>			
		# 400 / 30 µm	orange	<b>0 424 642</b>			
		# 800 / 20 µm	blue	<b>0 424 622</b>			
		# 1200 / 10 µm	red	<b>0 424 632</b>			
	1 x 10 x 100 mm	# 120 / 110 µm	violet	<b>0 424 603</b>			
		# 220 / 50 µm	dark brown	<b>0 424 613</b>			
		# 400 / 30 µm	orange	<b>0 424 643</b>			
		# 800 / 20 µm	blue	<b>0 424 623</b>			
		# 1200 / 10 µm	red	<b>0 424 633</b>			
	2 x 4 x 100 mm	# 120 / 110 µm	violet	<b>0 424 604</b>			
		# 220 / 50 µm	dark brown	<b>0 424 614</b>			
		# 400 / 30 µm	orange	<b>0 424 644</b>			
		# 800 / 20 µm	blue	<b>0 424 624</b>			
		# 1200 / 10 µm	red	<b>0 424 634</b>			
2 x 6 x 100 mm	# 120 / 110 µm	violet	<b>0 424 605</b>				
	# 220 / 50 µm	dark brown	<b>0 424 615</b>				
	# 400 / 30 µm	orange	<b>0 424 645</b>				
	# 800 / 20 µm	blue	<b>0 424 625</b>				
	# 1200 / 10 µm	red	<b>0 424 635</b>				
2 x 10 x 100 mm	# 120 / 110 µm	violet	<b>0 424 606</b>				
	# 220 / 50 µm	dark brown	<b>0 424 616</b>				
	# 400 / 30 µm	orange	<b>0 424 646</b>				
	# 800 / 20 µm	blue	<b>0 424 626</b>				
	# 1200 / 10 µm	red	<b>0 424 636</b>				


 1  
2  
3  
4  
5  
6  
7



## 2 Ceramic-fibre files joke HT-140

### The advantages at a glance:

- unbreakable files
- very high heat resistance
- developed specifically for ultrasonic systems
- perfect for ribs and ridges
- files do not splinter



Dimensions	Grit size	Colour	Order No.	Price from			
				1 piece	5 pieces	10 pieces	
0.5 x 4 x 150 mm	# 220 / 50 µm	dark brown	<b>0 406 160-2</b>				
	# 300 / 40 µm	light brown	<b>0 406 110-2</b>				
	# 400 / 30 µm	orange	<b>0 406 120-2</b>				
	# 600 / 25 µm	black	<b>0 406 170-2</b>				
	# 800 / 20 µm	blue	<b>0 406 180-2</b>				
	# 1000 / 15 µm	white	<b>0 406 140-2</b>				
	# 1200 / 10 µm	red	<b>0 406 100-2</b>				
1 x 1 x 100 mm	# 1500	yellow	<b>0 406 371</b>				
	# 2000	cream	<b>0 406 381</b>				
	# 3000	pink	<b>0 406 391</b>				
1 x 2 x 100 mm	# 1500	yellow	<b>0 406 372</b>				
	# 2000	cream	<b>0 406 382</b>				
	# 3000	pink	<b>0 406 392</b>				
1 x 4 x 100 mm	# 1500	yellow	<b>0 406 373</b>				
1 x 4 x 150 mm	# 120 / 110 µm	violet	<b>0 406 211</b>				
	# 220 / 50 µm	dark brown	<b>0 406 161-2</b>				
	# 300 / 40 µm	light brown	<b>0 406 111-2</b>				
	# 400 / 30 µm	orange	<b>0 406 121-2</b>				
	# 600 / 25 µm	black	<b>0 406 171-2</b>				
	# 800 / 20 µm	blue	<b>0 406 181-2</b>				
	# 1000 / 15 µm	white	<b>0 406 141-2</b>				
	# 1200 / 10 µm	red	<b>0 406 101-2</b>				
	# 1500	yellow	<b>0 406 374</b>				
	1 x 6 x 150 mm	# 120 / 110 µm	violet	<b>0 406 212</b>			
		# 220 / 50 µm	dark brown	<b>0 406 162-2</b>			
		# 300 / 40 µm	light brown	<b>0 406 112-2</b>			
		# 400 / 30 µm	orange	<b>0 406 122-2</b>			
# 600 / 25 µm		black	<b>0 406 172-2</b>				
# 800 / 20 µm		blue	<b>0 406 182-2</b>				
# 1000 / 15 µm		white	<b>0 406 142-2</b>				
# 1200 / 10 µm		red	<b>0 406 102-2</b>				
# 1500		yellow	<b>0 406 375</b>				
1 x 10 x 150 mm	# 120 / 110 µm	violet	<b>0 406 213</b>				
	# 220 / 50 µm	dark brown	<b>0 406 163-2</b>				
	# 300 / 40 µm	light brown	<b>0 406 113-2</b>				
	# 400 / 30 µm	orange	<b>0 406 123-2</b>				
	# 600 / 25 µm	black	<b>0 406 173-2</b>				
	# 800 / 20 µm	blue	<b>0 406 183-2</b>				
	# 1000 / 15 µm	white	<b>0 406 143-2</b>				
2 x 6 x 150 mm	# 120 / 110 µm	violet	<b>0 406 214</b>				
	# 220 / 50 µm	dark brown	<b>0 406 164-2</b>				
	# 300 / 40 µm	light brown	<b>0 406 114-2</b>				
	# 400 / 30 µm	orange	<b>0 406 124-2</b>				
	# 600 / 25 µm	black	<b>0 406 174-2</b>				
	# 800 / 20 µm	blue	<b>0 406 184-2</b>				
	# 1000 / 15 µm	white	<b>0 406 144-2</b>				
# 1200 / 10 µm	red	<b>0 406 104-2</b>					



# Ceramic-fibre files joke HT-140

heat-resistant up to 140 °C

2

Dimensions	Grit size	Colour	Order No.	Price from		
				1 piece	5 pieces	10 pieces
<b>Ceramic-fibre files joke HT-140</b>						
<b>round</b>						
Ø 2.35 x 100 mm	# 220 / 50 µm	grey	0 406 200-2			
	# 300 / 40 µm	light brown	0 406 201-2			
	# 400 / 30 µm	orange	0 406 202-2			
	# 600 / 25 µm	black	0 406 203-2			
	# 800 / 20 µm	blue	0 406 204-2			
	# 1200 / 10 µm	red	0 406 206-2			
Ø 2.35 x 150 mm	# 300 / 40 µm	light brown	0 406 342			
	# 400 / 30 µm	orange	0 406 243			
	# 600 / 25 µm	dark brown	0 406 244			
	# 800 / 20 µm	blue	0 406 245			
	# 1000 / 15 µm	white	0 406 246			
	# 1200 / 10 µm	red	0 406 247			
Ø 3 x 100 mm	# 220 / 50 µm	grey	0 406 190-2			
	# 300 / 40 µm	light brown	0 406 191-2			
	# 400 / 30 µm	orange	0 406 192-2			
	# 600 / 25 µm	black	0 406 193-2			
	# 800 / 20 µm	blue	0 406 194-2			
	# 1000 / 15 µm	white	0 406 195-2			
Ø 3 x 150 mm	# 220 / 50 µm	grey	0 406 251			
	# 300 / 40 µm	light brown	0 406 352			
	# 400 / 30 µm	orange	0 406 253			
	# 600 / 25 µm	black	0 406 254			
	# 800 / 20 µm	blue	0 406 255			
	# 1000 / 15 µm	white	0 406 256			
	# 1200 / 10 µm	red	0 406 257			

**i** **There is even more to it!**

Please let us know your special requests regarding ceramic-fibre files. We can make almost anything possible. For further information, please contact

**Markus Abstoss:**  
**+49 22 04 839-0**  
**m.abstoss@joke.de**



## 2 Ceramic-fibre files NEW Super Stone

Total length: 50 mm

### The advantages at a glance:

- unbreakable files
- very high heat resistance
- developed specifically for ultrasonic systems
- perfect for ribs and ridges
- files do not splinter



	Dimensions	Grit size	Colour	Order No.	Price from		
					1 piece	5 pieces	10 pieces
	0.5 x 4 x 50 mm	# 120 / 110 µm	green	<b>0 424 571-1</b>			
		# 180 / 80 µm	gold	<b>0 424 572-1</b>			
		# 300 / 40 µm	light brown	<b>0 424 573-1</b>			
		# 400 / 30 µm	orange	<b>0 424 574-1</b>			
		# 600 / 25 µm	dark brown	<b>0 424 575-1</b>			
		# 800 / 20 µm	blue	<b>0 424 576-1</b>			
		# 1000 / 15 µm	white	<b>0 424 577-1</b>			
		# 1200 / 10 µm	red	<b>0 424 578-1</b>			

## Ceramic-fibre files NEW Super Stone

extra fine grain, total length 100 mm

**NEW!**

	Dimensions	Grit	Colour	Bestell-Nr	Price from		
					1 piece	5 pieces	10 pieces
	0,5 x 2 x 100 mm	# 1500	gelb	<b>0 428 720</b>			
		# 2000	creme	<b>0 428 730</b>			
		# 3000	rosa	<b>0 428 740</b>			
	1 x 1 x 100 mm	# 1500	gelb	<b>0 428 721</b>			
		# 2000	creme	<b>0 428 731</b>			
		# 3000	rosa	<b>0 428 741</b>			
	1 x 2 x 100 mm	# 1500	gelb	<b>0 428 722</b>			
		# 2000	creme	<b>0 428 732</b>			
		# 3000	rosa	<b>0 428 742</b>			
	1 x 4 x 100 mm	# 1500	gelb	<b>0 428 723</b>			
	1 x 6 x 100 mm	# 1500	gelb	<b>0 428 724</b>			
	1 x 10 x 100 mm	# 1500	gelb	<b>0 428 725</b>			



# Ceramic-fibre files NEW Super Stone

Total length: 100 mm

**2**


Dimensions	Grit size	Colour	Order No.	Price from		
				1 piece	5 pieces	10 pieces
0.5 x 1 x 100 mm	# 80 / 150 µm	violet	<b>0 426 810</b>			
	# 120 / 110 µm	green	<b>0 426 001</b>			
	# 180 / 80 µm	gold	<b>0 426 101</b>			
	# 300 / 40 µm	light brown	<b>0 426 201</b>			
	# 400 / 30 µm	orange	<b>0 426 301</b>			
	# 600 / 25 µm	dark brown	<b>0 426 401</b>			
	# 800 / 20 µm	blue	<b>0 426 501</b>			
	# 1000 / 15 µm	white	<b>0 426 601</b>			
	# 1200 / 10 µm	red	<b>0 426 701</b>			
1 x 2 x 100 mm	# 120 / 110 µm	green	<b>0 426 012</b>			
	# 180 / 80 µm	gold	<b>0 426 112</b>			
	# 300 / 40 µm	light brown	<b>0 426 212</b>			
	# 400 / 30 µm	orange	<b>0 426 312</b>			
	# 600 / 25 µm	dark brown	<b>0 426 412</b>			
	# 800 / 20 µm	blue	<b>0 426 512</b>			
	# 1000 / 15 µm	white	<b>0 426 612</b>			
	# 1200 / 10 µm	red	<b>0 426 712</b>			
	1 x 4 x 100 mm	# 120 / 110 µm	green	<b>0 426 013</b>		
# 180 / 80 µm		gold	<b>0 426 113</b>			
# 300 / 40 µm		light brown	<b>0 426 213</b>			
# 400 / 30 µm		orange	<b>0 426 313</b>			
# 600 / 25 µm		dark brown	<b>0 426 413</b>			
# 800 / 20 µm		blue	<b>0 426 513</b>			
# 1000 / 15 µm		white	<b>0 426 613</b>			
# 1200 / 10 µm		red	<b>0 426 713</b>			
1 x 6 x 100 mm		# 120 / 110 µm	green	<b>0 426 014</b>		
	# 180 / 80 µm	gold	<b>0 426 114</b>			
	# 300 / 40 µm	light brown	<b>0 426 214</b>			
	# 400 / 30 µm	orange	<b>0 426 314</b>			
	# 600 / 25 µm	dark brown	<b>0 426 414</b>			
	# 800 / 20 µm	blue	<b>0 426 514</b>			
	# 1000 / 15 µm	white	<b>0 426 614</b>			
	# 1200 / 10 µm	red	<b>0 426 714</b>			
	1 x 10 x 100 mm	# 120 / 110 µm	green	<b>0 426 015</b>		
# 180 / 80 µm		gold	<b>0 426 115</b>			
# 300 / 40 µm		light brown	<b>0 426 215</b>			
# 400 / 30 µm		orange	<b>0 426 315</b>			
# 600 / 25 µm		dark brown	<b>0 426 415</b>			
# 800 / 20 µm		blue	<b>0 426 515</b>			
# 1000 / 15 µm		white	<b>0 426 615</b>			
# 1200 / 10 µm		red	<b>0 426 715</b>			
1.5 x 2 x 100 mm		# 120 / 110 µm	green	<b>0 426 017</b>		
	# 180 / 80 µm	gold	<b>0 426 117</b>			
	# 300 / 40 µm	light brown	<b>0 426 217</b>			
	# 400 / 30 µm	orange	<b>0 426 317</b>			
	# 600 / 25 µm	dark brown	<b>0 426 417</b>			
	# 800 / 20 µm	blue	<b>0 426 517</b>			
	# 1000 / 15 µm	white	<b>0 426 617</b>			
	# 1200 / 10 µm	red	<b>0 426 717</b>			

## 2 Ceramic-fibre files NEW Super Stone

Total length: 100 mm

Dimensions	Grit size	Colour	Order No.	Price from		
				1 piece	5 pieces	10 pieces
1.5 x 6 x 100 mm	# 120 / 110 µm	green	<b>0 426 019</b>			
	# 180 / 80 µm	gold	<b>0 426 119</b>			
	# 300 / 40 µm	light brown	<b>0 426 219</b>			
	# 400 / 30 µm	orange	<b>0 426 319</b>			
	# 600 / 25 µm	dark brown	<b>0 426 419</b>			
	# 800 / 20 µm	blue	<b>0 426 519</b>			
	# 1000 / 15 µm	white	<b>0 426 619</b>			
	# 1200 / 10 µm	red	<b>0 426 719</b>			
2 x 4 x 100 mm	# 120 / 110 µm	green	<b>0 426 022</b>			
	# 180 / 80 µm	gold	<b>0 426 122</b>			
	# 300 / 40 µm	light brown	<b>0 426 222</b>			
	# 400 / 30 µm	orange	<b>0 426 322</b>			
	# 600 / 25 µm	dark brown	<b>0 426 422</b>			
	# 800 / 20 µm	blue	<b>0 426 522</b>			
	# 1000 / 15 µm	white	<b>0 426 622</b>			
	# 1200 / 10 µm	red	<b>0 426 722</b>			
2 x 6 x 100 mm	# 120 / 110 µm	green	<b>0 426 023</b>			
	# 180 / 80 µm	gold	<b>0 426 123</b>			
	# 300 / 40 µm	light brown	<b>0 426 223</b>			
	# 400 / 30 µm	orange	<b>0 426 323</b>			
	# 600 / 25 µm	dark brown	<b>0 426 423</b>			
	# 800 / 20 µm	blue	<b>0 426 523</b>			
	# 1000 / 15 µm	white	<b>0 426 623</b>			
	# 1200 / 10 µm	red	<b>0 426 723</b>			
3 x 6 x 100 mm	# 120 / 110 µm	green	<b>0 426 028</b>			
	# 180 / 80 µm	gold	<b>0 426 128</b>			
	# 300 / 40 µm	light brown	<b>0 426 228</b>			
	# 400 / 30 µm	orange	<b>0 426 328</b>			
	# 600 / 25 µm	dark brown	<b>0 426 428</b>			
	# 800 / 20 µm	blue	<b>0 426 528</b>			
	# 1000 / 15 µm	white	<b>0 426 628</b>			
	# 1200 / 10 µm	red	<b>0 426 728</b>			
1 x 1 x 100 mm	# 120 / 110 µm	green	<b>0 426 011</b>			
	# 180 / 80 µm	gold	<b>0 426 111</b>			
	# 300 / 40 µm	light brown	<b>0 426 211</b>			
	# 400 / 30 µm	orange	<b>0 426 311</b>			
	# 600 / 25 µm	dark brown	<b>0 426 411</b>			
	# 800 / 20 µm	blue	<b>0 426 511</b>			
	# 1000 / 15 µm	white	<b>0 426 611</b>			
	# 1200 / 10 µm	red	<b>0 426 711</b>			
2 x 2 x 100 mm	# 120 / 110 µm	green	<b>0 426 021</b>			
	# 180 / 80 µm	gold	<b>0 426 121</b>			
	# 300 / 40 µm	light brown	<b>0 426 221</b>			
	# 400 / 30 µm	orange	<b>0 426 321</b>			
	# 600 / 25 µm	dark brown	<b>0 426 421</b>			
	# 800 / 20 µm	blue	<b>0 426 521</b>			
	# 1000 / 15 µm	white	<b>0 426 621</b>			
	# 1200 / 10 µm	red	<b>0 426 721</b>			



# Ceramic-fibre files NEW Super Stone

Total length: 150 mm

**2**

 3  
4  
5  
6  
7

Dimensions	Grit size	Colour	Order No.	Price from		
				1 piece	5 pieces	10 pieces
0.5 x 1 x 150 mm	# 80 / 150 µm	violet	0 426 839			
0.5 x 2 x 150 mm	# 80 / 150 µm	violet	0 426 840			
	# 120 / 110 µm	green	0 426 031			
	# 180 / 80 µm	gold	0 426 131			
	# 300 / 40 µm	light brown	0 426 231			
	# 400 / 30 µm	orange	0 426 331			
	# 600 / 25 µm	dark brown	0 426 431			
	# 800 / 20 µm	blue	0 426 531			
	# 1000 / 15 µm	white	0 426 631			
	# 1200 / 10 µm	red	0 426 731			
	0.5 x 4 x 150 mm	# 80 / 150 µm	violet	0 426 841		
# 120 / 110 µm		green	0 426 032			
# 180 / 80 µm		gold	0 426 132			
# 300 / 40 µm		light brown	0 426 232			
# 400 / 30 µm		orange	0 426 332			
# 600 / 25 µm		dark brown	0 426 432			
# 800 / 20 µm		blue	0 426 532			
# 1000 / 15 µm		white	0 426 632			
# 1200 / 10 µm		red	0 426 732			
0.5 x 6 x 150 mm		# 80 / 150 µm	violet	0 426 842		
	# 120 / 110 µm	green	0 426 033			
	# 180 / 80 µm	gold	0 426 133			
	# 300 / 40 µm	light brown	0 426 233			
	# 400 / 30 µm	orange	0 426 333			
	# 600 / 25 µm	dark brown	0 426 433			
	# 800 / 20 µm	blue	0 426 533			
	# 1000 / 15 µm	white	0 426 633			
	# 1200 / 10 µm	red	0 426 733			
	0.5 x 10 x 150 mm	# 80 / 150 µm	violet	0 426 843		
# 120 / 110 µm		green	0 426 034			
# 180 / 80 µm		gold	0 426 134			
# 300 / 40 µm		light brown	0 426 234			
# 400 / 30 µm		orange	0 426 334			
# 600 / 25 µm		dark brown	0 426 434			
# 800 / 20 µm		blue	0 426 534			
# 1000 / 15 µm		white	0 426 634			
# 1200 / 10 µm		red	0 426 734			
0.8 x 1 x 150 mm		# 80 / 150 µm	violet	0 426 844		
0.8 x 2 x 150 mm	# 80 / 150 µm	violet	0 426 845			
0.8 x 4 x 150 mm	# 80 / 150 µm	violet	0 426 846			
0.8 x 6 x 150 mm	# 80 / 150 µm	violet	0 426 847			
0.8 x 10 x 150 mm	# 80 / 150 µm	violet	0 426 848			
1 x 2 x 150 mm	# 80 / 150 µm	violet	0 426 850			
	# 120 / 110 µm	green	0 426 041			
	# 180 / 80 µm	gold	0 426 141			
	# 300 / 40 µm	light brown	0 426 241			
	# 400 / 30 µm	orange	0 426 341			
	# 600 / 25 µm	dark brown	0 426 441			
	# 800 / 20 µm	blue	0 426 541			
	# 1000 / 15 µm	white	0 426 641			
# 1200 / 10 µm	red	0 426 741				





## 2 Ceramic-fibre files NEW Super Stone

Total length: 150 mm

Dimensions	Grit size	Colour	Order No.	Price from		
				1 piece	5 pieces	10 pieces
1 x 4 x 150 mm	# 80 / 150 µm	violet	<b>0 426 851</b>			
	# 120 / 110 µm	green	<b>0 426 042</b>			
	# 180 / 80 µm	gold	<b>0 426 142</b>			
	# 300 / 40 µm	light brown	<b>0 426 242</b>			
	# 400 / 30 µm	orange	<b>0 426 342</b>			
	# 600 / 25 µm	dark brown	<b>0 426 442</b>			
	# 800 / 20 µm	blue	<b>0 426 542</b>			
	# 1000 / 15 µm	white	<b>0 426 642</b>			
	# 1200 / 10 µm	red	<b>0 426 742</b>			
1 x 6 x 150 mm	# 80 / 150 µm	violet	<b>0 426 852</b>			
	# 120 / 110 µm	green	<b>0 426 043</b>			
	# 180 / 80 µm	gold	<b>0 426 143</b>			
	# 300 / 40 µm	light brown	<b>0 426 243</b>			
	# 400 / 30 µm	orange	<b>0 426 343</b>			
	# 600 / 25 µm	dark brown	<b>0 426 443</b>			
	# 800 / 20 µm	blue	<b>0 426 543</b>			
	# 1000 / 15 µm	white	<b>0 426 643</b>			
	# 1200 / 10 µm	red	<b>0 426 743</b>			
1 x 10 x 150 mm	# 80 / 150 µm	violet	<b>0 426 853</b>			
	# 120 / 110 µm	green	<b>0 426 044</b>			
	# 180 / 80 µm	gold	<b>0 426 144</b>			
	# 300 / 40 µm	light brown	<b>0 426 244</b>			
	# 400 / 30 µm	orange	<b>0 426 344</b>			
	# 600 / 25 µm	dark brown	<b>0 426 444</b>			
	# 800 / 20 µm	blue	<b>0 426 544</b>			
	# 1000 / 15 µm	white	<b>0 426 644</b>			
	# 1200 / 10 µm	red	<b>0 426 744</b>			
1.5 x 1 x 150 mm	# 80 / 150 µm	violet	<b>0 426 854</b>			
1.5 x 2 x 150 mm	# 80 / 150 µm	violet	<b>0 426 855</b>			
	# 120 / 110 µm	green	<b>0 426 046</b>			
	# 180 / 80 µm	gold	<b>0 426 146</b>			
	# 300 / 40 µm	light brown	<b>0 426 246</b>			
	# 400 / 30 µm	orange	<b>0 426 346</b>			
	# 600 / 25 µm	dark brown	<b>0 426 446</b>			
	# 800 / 20 µm	blue	<b>0 426 546</b>			
	# 1000 / 15 µm	white	<b>0 426 646</b>			
	# 1200 / 10 µm	red	<b>0 426 746</b>			
1.5 x 4 x 150 mm	# 80 / 150 µm	violet	<b>0 426 856</b>			
	# 120 / 110 µm	green	<b>0 426 047</b>			
	# 180 / 80 µm	gold	<b>0 426 147</b>			
	# 300 / 40 µm	light brown	<b>0 426 247</b>			
	# 400 / 30 µm	orange	<b>0 426 347</b>			
	# 600 / 25 µm	dark brown	<b>0 426 447</b>			
	# 800 / 20 µm	blue	<b>0 426 547</b>			
	# 1000 / 15 µm	white	<b>0 426 647</b>			
	# 1200 / 10 µm	red	<b>0 426 747</b>			

## Ceramic-fibre files NEW Super Stone

Total length: 150 mm

**2**

Dimensions	Grit size	Colour	Order No.	Price from		
				1 piece	5 pieces	10 pieces
1.5 x 6 x 150 mm	# 80 / 150 µm	violet	0 426 857			
	# 120 / 110 µm	green	0 426 048			
	# 180 / 80 µm	gold	0 426 148			
	# 300 / 40 µm	light brown	0 426 248			
	# 400 / 30 µm	orange	0 426 348			
	# 600 / 25 µm	dark brown	0 426 448			
	# 800 / 20 µm	blue	0 426 548			
	# 1000 / 15 µm	white	0 426 648			
1.5 x 10 x 150 mm	# 1200 / 10 µm	red	0 426 748			
	# 80 / 150 µm	violet	0 426 858			
	# 120 / 110 µm	green	0 426 049			
	# 180 / 80 µm	gold	0 426 149			
	# 300 / 40 µm	light brown	0 426 249			
	# 400 / 30 µm	orange	0 426 349			
	# 600 / 25 µm	dark brown	0 426 449			
	# 800 / 20 µm	blue	0 426 549			
2 x 4 x 150 mm	# 1000 / 15 µm	white	0 426 649			
	# 1200 / 10 µm	red	0 426 749			
	# 80 / 150 µm	violet	0 426 860			
	# 120 / 110 µm	green	0 426 051			
	# 180 / 80 µm	gold	0 426 151			
	# 300 / 40 µm	light brown	0 426 251			
	# 400 / 30 µm	orange	0 426 351			
	# 600 / 25 µm	dark brown	0 426 451			
2 x 6 x 150 mm	# 800 / 20 µm	blue	0 426 551			
	# 1000 / 15 µm	white	0 426 651			
	# 1200 / 10 µm	red	0 426 751			
	# 80 / 150 µm	violet	0 426 861			
	# 120 / 110 µm	green	0 426 052			
	# 180 / 80 µm	gold	0 426 152			
	# 300 / 40 µm	light brown	0 426 252			
	# 400 / 30 µm	orange	0 426 352			
2 x 10 x 150 mm	# 600 / 25 µm	dark brown	0 426 452			
	# 800 / 20 µm	blue	0 426 552			
	# 1000 / 15 µm	white	0 426 652			
	# 1200 / 10 µm	red	0 426 752			
	# 80 / 150 µm	violet	0 426 862			
	# 120 / 110 µm	green	0 426 053			
	# 180 / 80 µm	gold	0 426 153			
	# 300 / 40 µm	light brown	0 426 253			
3 x 1 x 150 mm	# 400 / 30 µm	orange	0 426 353			
	# 600 / 25 µm	dark brown	0 426 453			
	# 800 / 20 µm	blue	0 426 553			
	# 1000 / 15 µm	white	0 426 653			
	# 1200 / 10 µm	red	0 426 753			
	# 80 / 150 µm	violet	0 426 863			
	# 80 / 150 µm	violet	0 426 864			
	3 x 2 x 150 mm	# 80 / 150 µm	violet	0 426 864		

## 2 Ceramic-fibre files NEW Super Stone

Total length: 150 mm

Dimensions	Grit size	Colour	Order No.	Price from		
				1 piece	5 pieces	10 pieces
3 x 4 x 150 mm	# 80 / 150 µm	violet	<b>0 426 865</b>			
	# 120 / 110 µm	green	<b>0 426 056</b>			
	# 180 / 80 µm	gold	<b>0 426 156</b>			
	# 300 / 40 µm	light brown	<b>0 426 256</b>			
	# 400 / 30 µm	orange	<b>0 426 356</b>			
	# 600 / 25 µm	dark brown	<b>0 426 456</b>			
	# 800 / 20 µm	blue	<b>0 426 556</b>			
	# 1000 / 15 µm	white	<b>0 426 656</b>			
	# 1200 / 10 µm	red	<b>0 426 756</b>			
	3 x 6 x 150 mm	# 80 / 150 µm	violet	<b>0 426 866</b>		
# 120 / 110 µm		green	<b>0 426 057</b>			
# 180 / 80 µm		gold	<b>0 426 157</b>			
# 300 / 40 µm		light brown	<b>0 426 257</b>			
# 400 / 30 µm		orange	<b>0 426 357</b>			
# 600 / 25 µm		dark brown	<b>0 426 457</b>			
# 800 / 20 µm		blue	<b>0 426 557</b>			
# 1000 / 15 µm		white	<b>0 426 657</b>			
# 1200 / 10 µm		red	<b>0 426 757</b>			
3 x 10 x 150 mm		# 80 / 150 µm	violet	<b>0 426 867</b>		
	# 120 / 110 µm	green	<b>0 426 058</b>			
	# 180 / 80 µm	gold	<b>0 426 158</b>			
	# 300 / 40 µm	light brown	<b>0 426 258</b>			
	# 400 / 30 µm	orange	<b>0 426 358</b>			
	# 600 / 25 µm	dark brown	<b>0 426 458</b>			
	# 800 / 20 µm	blue	<b>0 426 558</b>			
	# 1000 / 15 µm	white	<b>0 426 658</b>			
	# 1200 / 10 µm	red	<b>0 426 758</b>			
	1 x 1 x 150 mm	# 80 / 150 µm	violet	<b>0 426 849</b>		
# 120 / 110 µm		green	<b>0 426 040</b>			
# 180 / 80 µm		gold	<b>0 426 140</b>			
# 300 / 40 µm		light brown	<b>0 426 240</b>			
# 400 / 30 µm		orange	<b>0 426 340</b>			
# 600 / 25 µm		dark brown	<b>0 426 440</b>			
# 800 / 20 µm		blue	<b>0 426 540</b>			
# 1000 / 15 µm		white	<b>0 426 640</b>			
# 1200 / 10 µm		red	<b>0 426 740</b>			
2 x 2 x 150 mm		# 80 / 150 µm	violet	<b>0 426 859</b>		
	# 120 / 110 µm	green	<b>0 426 050</b>			
	# 180 / 80 µm	gold	<b>0 426 150</b>			
	# 300 / 40 µm	light brown	<b>0 426 250</b>			
	# 400 / 30 µm	orange	<b>0 426 350</b>			
	# 600 / 25 µm	dark brown	<b>0 426 450</b>			
	# 800 / 20 µm	blue	<b>0 426 550</b>			
	# 1000 / 15 µm	white	<b>0 426 650</b>			
	# 1200 / 10 µm	red	<b>0 426 750</b>			



3 x 6 x 150 mm

3 x 10 x 150 mm

1 x 1 x 150 mm

2 x 2 x 150 mm

## Ceramic-fibre files NEW Super Stone

Shape: round

Dimensions	Grit size	Colour	Order No.	Price from			
				1 piece	5 pieces	10 pieces	
Ø 2.35 x 50 mm	# 120 / 110 µm	green	0 428 001				
	Ø 2.35 x 100 mm	# 120 / 110 µm	green	0 428 002			
		# 180 / 80 µm	gold	0 428 102			
		# 300 / 40 µm	light brown	0 428 202			
		# 400 / 30 µm	orange	0 428 302			
		# 600 / 25 µm	dark brown	0 428 402			
		# 800 / 20 µm	blue	0 428 502			
		# 1000 / 15 µm	white	0 428 602			
		# 1200 / 10 µm	red	0 428 702			
Ø 2.35 x 150 mm	# 120 / 110 µm	green	0 428 003				
	# 180 / 80 µm	gold	0 428 103				
	# 300 / 40 µm	light brown	0 428 203				
	# 400 / 30 µm	orange	0 428 303				
	# 600 / 25 µm	dark brown	0 428 403				
	# 800 / 20 µm	blue	0 428 503				
	# 1000 / 15 µm	white	0 428 603				
	# 1200 / 10 µm	red	0 428 703				
	Ø 3 x 100 mm	# 120 / 110 µm	green	0 428 005			
# 180 / 80 µm		gold	0 428 105				
# 300 / 40 µm		light brown	0 428 205				
# 400 / 30 µm		orange	0 428 305				
# 600 / 25 µm		dark brown	0 428 405				
# 800 / 20 µm		blue	0 428 505				
# 1000 / 15 µm		white	0 428 605				
# 1200 / 10 µm		red	0 428 705				
Ø 3 x 150 mm		# 120 / 110 µm	green	0 428 006			
	# 180 / 80 µm	gold	0 428 106				
	# 300 / 40 µm	light brown	0 428 206				
	# 400 / 30 µm	orange	0 428 306				
	# 600 / 25 µm	dark brown	0 428 406				
	# 800 / 20 µm	blue	0 428 506				
	# 1000 / 15 µm	white	0 428 606				
	# 1200 / 10 µm	red	0 428 706				



## 2 Diamond ceramic-fibre files



Take the long-established ceramic fibre-files and blend additional diamond grits into the binder. You then have this sensible further development. Owing to the additional diamond grits among the individual fibres and above all around the circumference of the files, the latter can be used over their entire length. The result is a fine, very uniform grinding pattern with good stock removal.

**Tip: very well suited for use with ultrasonic polishing systems.**

Dimensions	Total length	Grit size	Colour	Order No.	Price from	
					1 piece	5 pieces
<b>Diamond ceramic-fibre files</b>						
<b>flat</b>						
1 x 4 x 100 mm	100	# 200 / 70 µm	black	<b>0 406 080</b>		
	100	# 400 / 30 µm	blue/green	<b>0 406 051</b>		
	100	# 800 / 20 µm	grey	<b>0 406 052</b>		
	100	# 1200 / 15 µm	moss green	<b>0 406 053</b>		
1 x 6 x 100 mm	100	# 200 / 70 µm	black	<b>0 406 081</b>		
	100	# 400 / 30 µm	blue/green	<b>0 406 054</b>		
	100	# 800 / 20 µm	grey	<b>0 406 055</b>		
	100	# 1200 / 15 µm	moss green	<b>0 406 056</b>		
1 x 10 x 100 mm	100	# 200 / 70 µm	black	<b>0 406 082</b>		
	100	# 400 / 30 µm	blue/green	<b>0 406 057</b>		
	100	# 800 / 20 µm	grey	<b>0 406 058</b>		
	100	# 1200 / 15 µm	moss green	<b>0 406 059</b>		
<b>round</b>						
Ø 3 x 100 mm	100	# 200 / 70 µm	black	<b>0 406 089</b>		
	100	# 400 / 30 µm	grey	<b>0 406 090</b>		
	100	# 600 / 25 µm	moss green	<b>0 406 091</b>		





## Ceramic-fibre files joke mini for filigree processing!

These tiny little things are optimal for working on the smallest scale by hand. The right holders make for convenient handling.

	Dimensions	Grit size	Colour	Packing quantity	Order No.	Price from		
						1 pack	3 packs	5 packs
<b>Ceramic-fibre files joke mini</b>								
<b>flat</b>								
	0.5 x 0.5 x 50 mm	# 800 / 20 µm	blue	3 pieces	<b>0 424 952</b>			
		# 1200 / 10 µm	red	3 pieces	<b>0 424 951</b>			
	0.9 x 0.9 x 50 mm	# 800 / 20 µm	blue	3 pieces	<b>0 424 962</b>			
		# 1200 / 10 µm	red	3 pieces	<b>0 424 961</b>			

### Accessories / spare parts

	Profile	Price from
<b>Holder for ceramic-fibre file Mini</b>		
holder for ceramic-fibre file 0.5 x 0.5 mm	<b>square</b>	
holder for ceramic-fibre file 0.9 x 0.9 mm	<b>square</b>	



## Ceramic-fibre files joke soft soft and adjustable

Ideal for deburring eroded electrodes made of copper and the processing of stainless steel and aluminium. Due to the rubber bond these files are soft and adaptable. They do not cause any scratches, as a result of which for example the electrode is not damaged during processing. Error rate, costs and processing time are reduced. The files wear very evenly and produce a shiny surface. Suitable for raising a shine on tool steel from 50 HRC. Only suitable for manual use!

	Dimensions	Grit size	Colour	Order No.	Price from		
					1 piece	5 pieces	10 pieces
<b>Ceramic-fibre files joke soft</b>							
<b>flat</b>							
	2 x 6 x 100 mm	# 1200 / 10 µm	white	<b>0 424 981</b>			
<b>round</b>							
	Ø 3 x 100 mm	# 1200 / 10 µm	white	<b>0 424 982</b>			





## 2 Set of holder + ceramic-fibre files for manual use

### Set of holder + ceramic-fibre files


With this set, the suitable ceramic-fibre files are already included with the handy holder.

The ideal combination for filigree, narrow and difficult to access places in addition to very fine details on the workpiece.

The very light holder lies securely in the hand and allows you extremely comfortable work. The practical rotary lock secures the inserted files and makes changing tools child's play.

Set including holder plus three files. Other suitable files available (see table!).



	Order No.	Price from
<b>Set of holder + ceramic-fibre files</b>		1 set
	<b>0 424 600</b>	

The set consists of 1 x holder with protective cap and 1 x ceramic file 0.5 x 4 x 50 mm respectively in grit size # 120/110 µm, # 300/40 µm and # 800/20 µm

### Accessories / spare parts

	Dimensions	Grit size	Colour	Order No.	Price from		
					1 piece	5 pieces	10 pieces
<b>Spare files</b>							
	0.5 x 4 x 50 mm	# 120 / 110 µm	green	<b>0 424 571-1</b>			
		# 180 / 80 µm	gold	<b>0 424 572-1</b>			
		# 300 / 40 µm	light brown	<b>0 424 573-1</b>			
		# 400 / 30 µm	orange	<b>0 424 574-1</b>			
		# 600 / 25 µm	dark brown	<b>0 424 575-1</b>			
		# 800 / 20 µm	blue	<b>0 424 576-1</b>			
		# 1000 / 15 µm	white	<b>0 424 577-1</b>			
		# 1200 / 10 µm	red	<b>0 424 578-1</b>			



## 2 Holders for ceramic-fibre files for manual use

Practical plastic holders facilitating the manual use of ceramic-fibre files. Available in various different widths and as metal holder for round files.

	Tool support	Profile	Packing quantity	Order No.	Price from	
					1 set	1 piece
<b>Holders for ceramic-fibre files</b>						
	Holder for files of 1 mm width	0.5 - 3 x 1 mm	rectangular		<b>0 406 157</b>	
	Holder for files of 2 mm width	0.5 - 3 x 2 mm	rectangular		<b>0 406 154</b>	
	Holder for files of 4 mm width	0.5 - 3 x 4 mm	rectangular		<b>0 406 151</b>	
	Holder for files of 6 mm width	0.5 - 3 x 6 mm	rectangular		<b>0 406 152</b>	
	Holder for files of 10 mm width	0.5 - 3 x 10 mm	rectangular		<b>0 406 153</b>	
	Set (for 4, 6 and 10 mm width)	0.5 - 3 x 4, 6 & 10 mm	rectangular	3 pieces		<b>0 406 150</b>
<b>Holder for round ceramic-fibre files</b>						
	Holder for round ceramic-fibre files Ø 2.35 mm	Ø 2.35 mm	round		<b>0 406 156</b>	
	Holder for round ceramic-fibre files Ø 3 mm	Ø 3 mm	round		<b>0 406 155</b>	
<b>Holder for ceramic-fibre file Mini</b>						
	holder for ceramic-fibre file 0.5 x 0.5 mm		square		<b>0 424 950</b>	
	holder for ceramic-fibre file 0.9 x 0.9 mm		square		<b>0 424 960</b>	

## Ceramic-fibre files on a shank shank Ø 3 x 30 mm

These ceramic-fibre files offer a secure grip in the shank. They are economical and efficient to use, as there are no more left-overs. These tools can be used for a wide range of applications: They are ideal for use in ultrasonic polishing systems and short-stroke hand-filing machines. Good results are also achieved when used in rotating handpieces with up to 50,000 rpm.









	Head dimensions	Grit size	Colour	Shank dimensions	Order No.	Price from		
						1 piece	5 pieces	10 pieces
<b>Ceramic-fibre files on a shank, shank Ø 3 x 30 mm</b>								
<b>round</b>								
	Ø 1 x 9 mm	# 180 / 80 µm	gold	Ø 3 x 30 mm	<b>0 425 100</b>			
		# 300 / 40 µm	light brown	Ø 3 x 30 mm	<b>0 425 105</b>			
		# 400 / 30 µm	orange	Ø 3 x 30 mm	<b>0 425 110</b>			
		# 600 / 25 µm	dark brown	Ø 3 x 30 mm	<b>0 425 115</b>			
		# 800 / 20 µm	blue	Ø 3 x 30 mm	<b>0 425 120</b>			
		# 1000 / 15 µm	white	Ø 3 x 30 mm	<b>0 425 125</b>			
	Ø 1.5 x 9 mm	# 1200 / 10 µm	red	Ø 3 x 30 mm	<b>0 425 130</b>			
		# 180 / 80 µm	gold	Ø 3 x 30 mm	<b>0 425 101</b>			
		# 300 / 40 µm	light brown	Ø 3 x 30 mm	<b>0 425 106</b>			
		# 400 / 30 µm	orange	Ø 3 x 30 mm	<b>0 425 111</b>			
		# 600 / 25 µm	dark brown	Ø 3 x 30 mm	<b>0 425 116</b>			
		# 800 / 20 µm	blue	Ø 3 x 30 mm	<b>0 425 121</b>			
Ø 2 x 9 mm	# 1000 / 15 µm	white	Ø 3 x 30 mm	<b>0 425 126</b>				
	# 1200 / 10 µm	red	Ø 3 x 30 mm	<b>0 425 131</b>				
	# 180 / 80 µm	gold	Ø 3 x 30 mm	<b>0 425 102</b>				
	# 300 / 40 µm	light brown	Ø 3 x 30 mm	<b>0 425 107</b>				
	# 400 / 30 µm	orange	Ø 3 x 30 mm	<b>0 425 112</b>				
	# 1000 / 15 µm	white	Ø 3 x 30 mm	<b>0 425 127</b>				
		# 1200 / 10 µm	red	Ø 3 x 30 mm	<b>0 425 132</b>			

## 2 Crystal-fibre-brushes

### shank Ø 3 x 30 mm

These crystal fibre brushes on shank are made of bundled crystal fibers. Through frontal application, these tools achieve their best results and thus remove erosion structures, burrs and much more.

	Head dimensions	Grit size	Colour	Shank dimensions	Order No.	Price from		
						1 piece	5 pieces	10 pieces
<b>Crystal-fibre-brushes, shank Ø 3 x 30 mm</b>								
	Ø 5 x 20 mm	# 150	green	Ø 3 x 30 mm	<b>0 406 430</b>			
	Ø 5 x 20 mm	# 200	pink	Ø 3 x 30 mm	<b>0 406 431</b>			
	Ø 5 x 20 mm	# 400	violet	Ø 3 x 30 mm	<b>0 406 432</b>			
	Ø 5 x 20 mm	# 600	orange	Ø 3 x 30 mm	<b>0 406 433</b>			
	Ø 5 x 20 mm	# 800	blue	Ø 3 x 30 mm	<b>0 406 434</b>			
	Ø 5 x 20 mm	# 1000	white	Ø 3 x 30 mm	<b>0 406 435</b>			

## Ceramic-fibre brushes



### shank Ø 3 x 30 mm

  $n_{max}$  12,000 rpm



In these tools, individual ceramic-fibres are grouped together to form a brush. This allows effective work with the fibre tips. Excellent properties in eliminating erosion structures and for deburring aluminium, brass etc.

Tip: the additional use of diamond compound considerably improves the working result.

	Head dimensions	Grit size	Colour	Shank dimensions	Rotation speed max.	Order No.	Price from		
							1 piece	5 pieces	10 pieces
<b>Ceramic-fibre brushes, shank Ø 3 x 30 mm</b>									
	Ø 5 x 20 mm	# 1200 / 10 µm	red	Ø 3 x 30 mm	12000 rpm	<b>0 406 200</b>			
	Ø 5 x 20 mm	# 1000 / 15 µm	white	Ø 3 x 30 mm	12000 rpm	<b>0 406 240</b>			

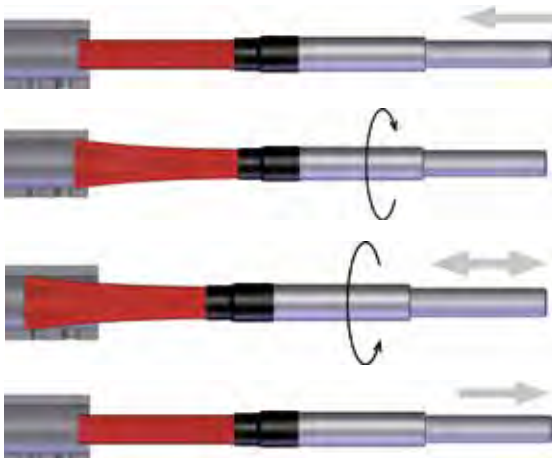


# Ceramic-fibre brushes

## Cross-Hole

- High-tech material made of special  $Al_2O_3$  ceramic
- The centrifugal force generated by rotation guides the grinding tips of the fibre rods on the crossways bores and efficiently removes fine burrs of up to 0.1 mm
- Burrs are thoroughly removed without damaging the bores
- A fibre rod consists of approx. 1,000 individual fibres, each with a diameter of approx. 10  $\mu m$  and optimum crystalline structure for the grinding process; the tip consists of approx. 1,000 high-density cutting edges
- The self-sharpening action of the cutting edges at the fibre ends ensures a high level of grinding ability. The constantly acting cutting edges ensure a stable and continuous cutting performance.
- Versatile in use, e.g. in processing centres, special machines, drilling machines and robots and many others
- High elasticity and flexibility ensure optimum adaptation to the workpiece
- Long service lives for markedly higher productivity and lower costs

for bore dimensions	Head dimensions	Shank dimensions	Total length	Rotation speed max.	Order No.	Price from		
						1 piece	3 pieces	5 pieces
<b>Ceramic-fibre brushes Cross-Hole</b>								
3,5 - 5 mm	$\varnothing 3.5 \times 50$ mm	$\varnothing 3 \times 30$ mm	120 mm	20000 rpm	<b>0 406 291</b>			
5 - 8 mm	$\varnothing 5 \times 50$ mm	$\varnothing 3 \times 30$ mm	120 mm	14000 rpm	<b>0 406 292</b>			
	$\varnothing 5 \times 50$ mm	$\varnothing 4 \times 30$ mm	170 mm	12000 rpm	<b>0 406 293</b>			
8 - 10 mm	$\varnothing 8 \times 50$ mm	$\varnothing 6 \times 30$ mm	120 mm	14000 rpm	<b>0 406 294</b>			
	$\varnothing 8 \times 50$ mm	$\varnothing 6 \times 30$ mm	170 mm	12000 rpm	<b>0 406 295</b>			
10 - 14 mm	$\varnothing 10 \times 50$ mm	$\varnothing 6 \times 30$ mm	120 mm	14000 rpm	<b>0 406 296</b>			
	$\varnothing 10 \times 50$ mm	$\varnothing 8 \times 30$ mm	170 mm	12000 rpm	<b>0 406 297</b>			
14 - 20 mm	$\varnothing 20 \times 60$ mm	$\varnothing 12 \times 30$ mm	130 mm	14000 rpm	<b>0 406 320</b>			



### Functional principle

#### 1. Approach movement

With the shaft stationary, the tool is inserted into the bore in front of the position to be deburred.

#### 2. Switch on the working shaft

Set the shaft in motion in the bore in the clockwise direction immediately in front of the crossways bore to be deburred.

#### 3. Backwards and forwards movement

Guide the fibre rods in front of and behind the crossways bores. In rearwards motion, we additionally recommend a change in the shaft rotation direction.

#### 4. Withdrawal from the bore













Shaft rotation must be stopped before the tool is removed from the bore.

#### Note:

For an optimum deburring result, repeat the four working stages from the other side of the main bore.

## 2 Crystal fibre cutting disc Cristone for hardened steel and carbide metal








Extremely stable, unbreakable, high cutting performance. These are the crystal fibre cutting discs from joke. Use dry or with diamond pastes or fluids.

	Dimensions	Drilling dimension	Grit size	Colour	Rotation speed max.	Order No.	Price from		
							1 piece	5 pieces	10 pieces
<b>Crystal fibre cutting disc Cristone</b>									
	Ø 19 x 0.8 mm	1.6 mm	150	green	50000 1/min	<b>0 425 200</b>			
	Ø 19 x 0.8 mm	1.6 mm	200	pink	50000 1/min	<b>0 425 201</b>			
	Ø 19 x 0.8 mm	1.6 mm	400	violet	50000 1/min	<b>0 425 202</b>			
	Ø 19 x 0.8 mm	1.6 mm	600	orange	50000 1/min	<b>0 425 203</b>			
	Ø 19 x 0.8 mm	1.6 mm	800	blue	50000 1/min	<b>0 425 204</b>			
	Ø 19 x 0.8 mm	1.6 mm	1000	white	50000 1/min	<b>0 425 205</b>			
	Ø 22 x 0.8 mm	1.6 mm	150	green	45000 1/min	<b>0 425 206</b>			
	Ø 22 x 0.8 mm	1.6 mm	200	pink	45000 1/min	<b>0 425 207</b>			
	Ø 22 x 0.8 mm	1.6 mm	400	violet	45000 1/min	<b>0 425 208</b>			
	Ø 22 x 0.8 mm	1.6 mm	600	orange	45000 1/min	<b>0 425 209</b>			
	Ø 22 x 0.8 mm	1.6 mm	800	blue	45000 1/min	<b>0 425 210</b>			
	Ø 22 x 0.8 mm	1.6 mm	1000	white	45000 1/min	<b>0 425 211</b>			

## Crystal fibre cutting disc Cristone for hardened steel and carbide metal




Accessories / spare parts




	for bore dimensions	Shank dimensions	Type	Max. disc size	Order No.	Price from	
						1 piece	10 pieces
<b>CRATEX® grinding wheel holder</b>							
	Ø 1.5 – 1.8 mm	Ø 2.35 x 30/15 mm	25	Ø 38 x 4.5 mm	<b>0 545 279</b>		
	Ø 1.5 – 1.8 mm	Ø 2.35 x 40/28 mm	21	Ø 38 x 4.5 mm	<b>0 545 275</b>		
	Ø 1.5 – 1.8 mm	Ø 3 x 40/30 mm	24	Ø 38 x 3 mm	<b>0 545 278</b>		
	Ø 1.5 – 1.8 mm	Ø 3 x 42 mm	22	Ø 38 x 4.5 mm	<b>0 545 276</b>		
	Ø 1.5 – 1.8 mm	Ø 3 x 40 mm	26	Ø 25 x 8.5 mm	<b>0 545 280</b>		
	Ø 1.5 – 1.8 mm	Ø 6 x 42 mm	23	Ø 38 x 4.5 mm	<b>0 545 277</b>		
	Ø 1.5 – 1.8 mm	Ø 6 x 40 mm	27	Ø 25 x 8.5 mm	<b>0 545 281</b>		

## Plastic-diamond cut-off discs joke Dia Disc

Thin, highly flexible plastic discs filled with natural diamonds. The discs can be used on both sides for polishing zirconium, glass, titanium, stone and all steels. Ideal for narrow slots. Can be used with fluid or diamond paste. Max. speed: 5,000 rpm.

Dimensions	Drilling dimension	Blade thickness	Grit size	Colour	Rotation speed max.	Order No.	Price from	
							1 piece	5 pieces
<b>Plastic-diamond cut-off discs joke Dia-Disc</b>								
	Ø 22 x 0.25 mm	1.8 mm	0.25 mm	30 µm	green	5000 1/min	<b>0 571 098</b>	
		1.8 mm	0.25 mm	9 µm	blue	5000 1/min	<b>0 571 099</b>	

Accessories / spare parts

	for bore dimensions Bohrungsmaß	Shank dimensions	Type	Max. disc size	Order No.	Price from	
						1 piece	10 pieces
<b>CRATEX® grinding wheel holder</b>							
	Ø 1.5 – 1.8 mm	Ø 2.35 x 40/28 mm	21	Ø 38 x 4.5 mm	<b>0 545 275</b>		
		Ø 3 x 42 mm	22	Ø 38 x 4.5 mm	<b>0 545 276</b>		
		Ø 3 x 40/30 mm	24	Ø 38 x 3 mm	<b>0 545 278</b>		



## 2 Crystal fibre brush insert Cristone®

Dimensions	Grit size	Colour	Rotation speed max.	Order No.	Price from	
					1 piece	3 pieces
<b>Crystal fibre brush insert Cristone®</b>						
Ø 6 x 30 mm	# 150	green	12000 1/min		<b>0 406 440</b>	
	# 200	pink	12000 1/min		<b>0 406 446</b>	
	# 400	violet	12000 1/min		<b>0 406 452</b>	
	# 600	orange	12000 1/min		<b>0 406 458</b>	
	# 800	blue	12000 1/min		<b>0 406 464</b>	
	# 1000	white	12000 1/min		<b>0 406 470</b>	
	# 1200	red	12000 1/min		<b>0 406 476</b>	
Ø 15 x 50 mm	# 150	green	7200 1/min		<b>0 406 441</b>	
	# 200	pink	7200 1/min		<b>0 406 447</b>	
	# 400	violet	7200 1/min		<b>0 406 453</b>	
	# 600	orange	7200 1/min		<b>0 406 459</b>	
	# 800	blue	7200 1/min		<b>0 406 465</b>	
	# 1000	white	7200 1/min		<b>0 406 471</b>	
	# 1200	red	7200 1/min		<b>0 406 477</b>	
Ø 25 x 75 mm	# 150	green	6000 1/min		<b>0 406 442</b>	
	# 200	pink	6000 1/min		<b>0 406 448</b>	
	# 400	violet	6000 1/min		<b>0 406 454</b>	
	# 600	orange	6000 1/min		<b>0 406 460</b>	
	# 800	blue	6000 1/min		<b>0 406 466</b>	
	# 1000	white	6000 1/min		<b>0 406 472</b>	
	# 1200	red	6000 1/min		<b>0 406 478</b>	
Ø 40 x 75 mm	# 150	green	3600 1/min		<b>0 406 443</b>	
	# 200	pink	3600 1/min		<b>0 406 449</b>	
	# 400	violet	3600 1/min		<b>0 406 455</b>	
	# 600	orange	3600 1/min		<b>0 406 461</b>	
	# 800	blue	3600 1/min		<b>0 406 467</b>	
	# 1000	white	3600 1/min		<b>0 406 473</b>	
	# 1200	red	3600 1/min		<b>0 406 479</b>	
Ø 60 x 75 mm	# 150	green	2400 1/min		<b>0 406 444</b>	
	# 200	pink	2400 1/min		<b>0 406 450</b>	
	# 400	violet	2400 1/min		<b>0 406 456</b>	
	# 600	orange	2400 1/min		<b>0 406 462</b>	
	# 800	blue	2400 1/min		<b>0 406 468</b>	
	# 1000	white	2400 1/min		<b>0 406 474</b>	
	# 1200	red	2400 1/min		<b>0 406 480</b>	
Ø 100 x 75 mm	# 150	green	1400 1/min		<b>0 406 445</b>	
	# 200	pink	1400 1/min		<b>0 406 451</b>	
	# 400	violet	1400 1/min		<b>0 406 457</b>	
	# 600	orange	1400 1/min		<b>0 406 463</b>	
	# 800	blue	1400 1/min		<b>0 406 469</b>	
	# 1000	white	1400 1/min		<b>0 406 475</b>	
	# 1200	red	1400 1/min		<b>0 406 481</b>	



# Crystal fibre brush insert Cristone®

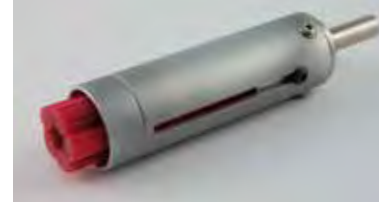
**Use:**

- Optimum tools for the surface finishing process, fine polishing of precision components and smoothing uneven edges.
- Fibre brushes wear out over time and work less flexibly, resulting in higher grinding force.
- The flexibility is adjusted by varying the bristle length in the holder.

Can be used for example in CNC processing machines, robots, etc.

**Materials:**

- Hardened and pre-hardened steels
- Alloyed steels
- Brass
- Aluminium alloys



## Accessories / spare parts

	Dimensions	Order No.	Price from	
			1 piece	3 pieces
<b>Holder for Cristone® bristle brush</b>				
	Ø 6 mm	<b>0 406 482</b>		
	Ø 15 mm	<b>0 406 483</b>		
	Ø 25 mm	<b>0 406 484</b>		
	Ø 40 mm	<b>0 406 485</b>		
	Ø 60 mm	<b>0 406 486</b>		
	Ø 100 mm	<b>0 406 487</b>		

## Recommended grit size

Material	Grit size	Colour
Hardened steel	# 150	
	# 200	
Steel	# 450	
Sainless steel	# 600	
Alloy steels	# 800	
Brass	# 1000	
Aluminium	# 1200	

1

2

3

4

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7

# Emery and fleece tools

**289 Abrasive cords and belts**

**290 Abrasive sleeves and caps**

**298 Flap wheels**

**304 Cup wheel discs**

**306 Grinding sheets**

**316 Emery sheets and strips**

Discover the entire range of abrasives and grinding tools.

Regardless of whether rotating on a shank, cap and sleeve-shaped, as belts, sheets, discs, emery papers and/or strips...we've got the right tool to match your grinding task!





## MITCHELL'S Abrasive cords and belts

### Corundum • Silicon carbide

The flexible abrasive cords from joke will open up a whole new world for you when processing hard to access areas. With these tools it is possible to grind, deburr and polish small holes, grooves, incisions and many further fiddly areas. The abrasive cords are rip-resistant, do not fray and are optionally impregnated with corundum or silicon carbide. They are therefore perfectly suited to your individual requirements. Use is possible with and without compounds and handling is child's play: with just a "cut" you can make the cord the length you want. The almost 15-metre long abrasive cords are delivered on a handy spool. They are available in diameters 0.3 mm to 2.4 mm and as belt in 2.4 mm width.

- Applicable to all materials
- Processing of areas difficult to reach

	Dimensions	Grit size	Type	Order No.	Price from		
					1 piece	3 pieces	5 pieces
<b>Abrasive cords and belts</b>							
<b>Corundum</b>							
	Ø 0.8 mm	200	54	<b>0 531 974</b>			
	Ø 1.0 mm	180	53	<b>0 531 973</b>			
	Ø 1.4 mm	120	51	<b>0 531 972</b>			
	Ø 1.8 mm	180	50	<b>0 531 971</b>			
	Ø 2.1 mm	120	49	<b>0 531 970</b>			
	Ø 2.4 mm	150	48	<b>0 531 998</b>			
	2.4 x 0.9 mm	180	56	<b>0 531 975</b>			
	3.2 x 0.9 mm	180	57	<b>0 531 976</b>			
<b>Silicon carbide</b>							
	Ø 0.3 mm	280	66	<b>0 531 983</b>			
	Ø 0.4 mm	200	60	<b>0 531 982</b>			
	Ø 0.5 mm	200	55	<b>0 531 981</b>			
	Ø 1.0 mm	180	53-S	<b>0 531 985</b>			



Processing tooth bases



Processing bore holes



## 2 Abrasive sleeves, caps and rubber holders

### jokeFlex












#### jokeFlex abrasive sleeves and caps

Thanks to their seamless and transition-free shape, jokeFlex abrasive sleeves and caps achieve top results. They are push-fitted on elastic, suitably shaped rubber holders. The special feature owing to the slotted shape of the rubber holder, the push-fit abrasive sleeves and caps are held securely by the rotational forces during processing. Once they are worn out, simply replace the sleeves/caps with new ones, re-using the same holder.

jokeFlex abrasive sleeves and caps run particularly true, are easy to guide and achieve a very soft grinding pattern.


Particularly very well suited for fine finishing of metals, particularly steels.

**Cutting speed Vmax: 40 m/s**



	Inside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from	
						1 pack	5 packs
<b>Abrasive sleeves, cylinder</b>							
<b>Corundum</b>							
	Ø 10 x 10 mm	0 544 601	80	10 pieces	0 544 622		
		0 544 601	150	10 pieces	0 544 621		
		0 544 601	240	10 pieces	0 544 620		
	Ø 10 x 20 mm	0 544 602	80	10 pieces	0 544 625		
		0 544 602	150	10 pieces	0 544 624		
	Ø 13 x 25 mm	0 544 604	80	10 pieces	0 544 631		
		0 544 604	150	10 pieces	0 544 630		
	Ø 15 x 10 mm	0 544 605	80	10 pieces	0 544 634		
		0 544 605	150	10 pieces	0 544 633		
	Ø 15 x 30 mm	0 544 606	60	10 pieces	0 544 639		
		0 544 606	80	10 pieces	0 544 638		
		0 544 606	150	10 pieces	0 544 637		
		0 544 606	240	10 pieces	0 544 636		
	Ø 22 x 20 mm	0 544 607	60	10 pieces	0 544 643		
		0 544 607	80	10 pieces	0 544 642		
		0 544 607	150	10 pieces	0 544 641		
		0 544 607	240	10 pieces	0 544 640		
	Ø 25 x 25 mm	0 544 608	60	10 pieces	0 544 647		
		0 544 608	80	10 pieces	0 544 646		
		0 544 608	150	10 pieces	0 544 645		
	Ø 30 x 20 mm	0 544 609	80	10 pieces	0 544 650		
		0 544 609	150	10 pieces	0 544 649		
	Ø 30 x 30 mm	0 544 610	40	10 pieces	0 544 657		
		0 544 610	60	10 pieces	0 544 656		
		0 544 610	80	10 pieces	0 544 655		
		0 544 610	150	10 pieces	0 544 654		
		0 544 610	240	10 pieces	0 544 653		
	Ø 45 x 30 mm	0 544 612	40	10 pieces	0 544 667		
		0 544 612	80	10 pieces	0 544 665		
<b>Zirconium corundum</b>							
	Ø 30 x 30 mm	0 544 610	36	50 pieces	0 544 870		
		0 544 610	50	50 pieces	0 544 871		
		0 544 610	60	50 pieces	0 544 872		
		0 544 610	80	50 pieces	0 544 873		

# Abrasive sleeves, caps and rubber holders

## jokeFlex

	Inside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from	
						1 pack	5 packs
<b>Abrasive sleeves, conical</b>							
<b>Corundum</b>							
	Ø 29/22 x 30 mm	0 544 617	60	10 pieces	<b>0 544 691</b>		
		0 544 617	80	10 pieces	<b>0 544 690</b>		
		0 544 617	150	10 pieces	<b>0 544 689</b>		


### Accessories / spare parts

	Head dimensions	Shank dimensions	Order No.	Price from	
				1 piece	5 pieces
<b>Rubber holder, jokeFlex</b>					
<b>cylinder</b>					
	Ø 10 x 10 mm	Ø 6 x 40 mm	<b>0 544 601</b>		
	Ø 10 x 20 mm	Ø 6 x 40 mm	<b>0 544 602</b>		
	Ø 13 x 25 mm	Ø 6 x 40 mm	<b>0 544 604</b>		
	Ø 15 x 10 mm	Ø 6 x 40 mm	<b>0 544 605</b>		
	Ø 15 x 30 mm	Ø 6 x 40 mm	<b>0 544 606</b>		
	Ø 22 x 20 mm	Ø 6 x 40 mm	<b>0 544 607</b>		
	Ø 25 x 25 mm	Ø 6 x 40 mm	<b>0 544 608</b>		
	Ø 30 x 20 mm	Ø 6 x 40 mm	<b>0 544 609</b>		
	Ø 30 x 30 mm	Ø 6 x 40 mm	<b>0 544 610</b>		
	Ø 45 x 30 mm	Ø 6 x 40 mm	<b>0 544 612</b>		
<b>conical</b>					
	Ø 29/22 x 30 mm	Ø 6 x 40 mm	<b>0 544 617</b>		




## 2 Abrasive caps and rubber holders

### jokeFlex


	Outside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from	
						1 pack	5 packs
<b>Abrasive caps, cylinder</b>							
<b>Green Corundum</b>							
	Ø 7 x 10 mm	0 544 401	80	100 pieces	<b>0 544 421-1</b>		
		0 544 401	150	100 pieces	<b>0 544 422-1</b>		
		0 544 401	320	100 pieces	<b>0 544 423-1</b>		
	Ø 9 x 12 mm	0 544 402	80	100 pieces	<b>0 544 424-1</b>		
		0 544 402	150	100 pieces	<b>0 544 425-1</b>		
		0 544 402	320	100 pieces	<b>0 544 426-1</b>		
	Ø 12 x 15 mm	0 544 403	80	100 pieces	<b>0 544 427-1</b>		
		0 544 403	150	100 pieces	<b>0 544 428-1</b>		
		0 544 403	320	100 pieces	<b>0 544 429-1</b>		
	Ø 15 x 17 mm	0 544 404	80	100 pieces	<b>0 544 430-1</b>		
		0 544 404	150	100 pieces	<b>0 544 431-1</b>		
		0 544 404	320	100 pieces	<b>0 544 432-1</b>		
Ø 18 x 26 mm	0 544 405, 0 544 406	80	100 pieces	<b>0 544 433-1</b>			
	0 544 405, 0 544 406	150	100 pieces	<b>0 544 434-1</b>			
	0 544 405, 0 544 406	320	100 pieces	<b>0 544 435-1</b>			

### Accessories / spare parts


	Head dimensions	Shank dimensions	Order No.	Price from		
				1 piece	5 pieces	10 pieces
<b>Rubber holder, jokeFlex</b>						
<b>cylinder</b>						
	Ø 5 x 10 mm	Ø 3 x 25 mm	<b>0 544 401</b>			
	Ø 7 x 12 mm	Ø 3 x 25 mm	<b>0 544 402</b>			
	Ø 10 x 15 mm	Ø 3 x 25 mm	<b>0 544 403</b>			
	Ø 13 x 17 mm	Ø 3 x 25 mm	<b>0 544 404</b>			
	Ø 16 x 26 mm	Ø 3 x 25 mm	<b>0 544 405</b>			
		Ø 6 x 40 mm	<b>0 544 406</b>			

# Abrasive caps and rubber holders

## jokeFlex


	Outside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from	
						1 pack	5 packs
<b>Abrasive caps, rounded cylinder</b>							
<b>Green Corundum</b>							
	Ø 7 x 11 mm	0 544 407	80	100 pieces	<b>0 544 436-1</b>		
		0 544 407	150	100 pieces	<b>0 544 437-1</b>		
		0 544 407	320	100 pieces	<b>0 544 438-1</b>		
	Ø 9 x 13 mm	0 544 408	80	100 pieces	<b>0 544 439-1</b>		
		0 544 408	150	100 pieces	<b>0 544 440-1</b>		
		0 544 408	320	100 pieces	<b>0 544 441-1</b>		
	Ø 12 x 15 mm	0 544 409	80	100 pieces	<b>0 544 442-1</b>		
		0 544 409	150	100 pieces	<b>0 544 443-1</b>		
		0 544 409	320	100 pieces	<b>0 544 444-1</b>		
	Ø 15 x 19 mm	0 544 410	80	100 pieces	<b>0 544 445-1</b>		
		0 544 410	150	100 pieces	<b>0 544 446-1</b>		
		0 544 410	320	100 pieces	<b>0 544 447-1</b>		
Ø 18 x 26 mm	0 544 411, 0 544 412	80	100 pieces	<b>0 544 448-1</b>			
	0 544 411, 0 544 412	150	100 pieces	<b>0 544 449-1</b>			
	0 544 411, 0 544 412	320	100 pieces	<b>0 544 450-1</b>			
Ø 12 x 15 mm	0 544 409	60	100 pieces	<b>0 544 482</b>			

### Accessories / spare parts


	Head dimensions	Shank dimensions	Order No.	Price from		
				1 piece	5 pieces	10 pieces
<b>Rubber holder</b>						
<b>rounded cylinder</b>						
	Ø 5 x 11 mm	Ø 3 x 25 mm	<b>0 544 407</b>			
	Ø 7 x 13 mm	Ø 3 x 25 mm	<b>0 544 408</b>			
	Ø 10 x 15 mm	Ø 3 x 25 mm	<b>0 544 409</b>			
	Ø 13 x 19 mm	Ø 3 x 25 mm	<b>0 544 410</b>			
	Ø 16 x 26 mm	Ø 3 x 25 mm	<b>0 544 411</b>			
		Ø 6 x 40 mm	<b>0 544 412</b>			

## 2 Abrasive caps and rubber holders

### jokeFlex

	Outside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from	
						1 pack	5 packs
<b>Abrasive caps, pointed cylinder</b>							
<b>Green Corundum</b>							
	Ø 7 x 11 mm	0 544 413	80	100 pieces	<b>0 544 451-1</b>		
		0 544 413	150	100 pieces	<b>0 544 452-1</b>		
		0 544 413	320	100 pieces	<b>0 544 453-1</b>		
	Ø 9 x 13 mm	0 544 414	80	100 pieces	<b>0 544 454-1</b>		
		0 544 414	150	100 pieces	<b>0 544 455-1</b>		
		0 544 414	320	100 pieces	<b>0 544 456-1</b>		
	Ø 12 x 15 mm	0 544 415	80	100 pieces	<b>0 544 457-1</b>		
		0 544 415	150	100 pieces	<b>0 544 458-1</b>		
		0 544 415	320	100 pieces	<b>0 544 459-1</b>		
	Ø 15 x 19 mm	0 544 416	80	100 pieces	<b>0 544 460-1</b>		
		0 544 416	150	100 pieces	<b>0 544 461-1</b>		
		0 544 416	320	100 pieces	<b>0 544 462-1</b>		
Ø 18 x 26 mm	0 544 417, 0 544 418	80	100 pieces	<b>0 544 463-1</b>			
	0 544 417, 0 544 418	150	100 pieces	<b>0 544 464-1</b>			

### Accessories / spare parts

	Head dimensions	Shank dimensions	Order No.	Price from		
				1 piece	5 pieces	10 pieces
<b>Rubber holder, jokeFlex</b>						
<b>pointed cylinder</b>						
	Ø 5 x 11 mm	Ø 3 x 25 mm	<b>0 544 413</b>			
	Ø 7 x 13 mm	Ø 3 x 25 mm	<b>0 544 414</b>			
	Ø 10 x 15 mm	Ø 3 x 25 mm	<b>0 544 415</b>			
	Ø 13 x 19 mm	Ø 3 x 25 mm	<b>0 544 416</b>			
	Ø 16 x 26 mm	Ø 3 x 25 mm	<b>0 544 417</b>			
	Ø 16 x 26 mm	Ø 6 x 40 mm	<b>0 544 418</b>			

# Abrasive caps and rubber holders

## POLICAP

	Outside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from	
						1 pack	5 packs
<b>Abrasive caps POLICAP, rounded cylinder</b>							
<b>Co-Cool</b>							
Owing to the special structure of the ceramic grit in addition to the active grinding bond components, ideal for processing stainless steels (INOX) and for the high-temperature nickel and cobalt-based alloys, e.g. Inconel®, Hastelloy® frequently used in turbine construction. The active grinding additives prevent clogging and result in a cooler cut with markedly greater stock removal.	Ø 5 x 11 mm	0 544 420	80	50 pieces	<b>0 543 005</b>		
	Ø 5 x 11 mm	0 544 420	120	50 pieces	<b>0 543 006</b>		
	Ø 7 x 13 mm	0 544 408	80	50 pieces	<b>0 543 000</b>		
	Ø 7 x 13 mm	0 544 408	120	50 pieces	<b>0 543 001</b>		
	Ø 10 x 15 mm	0 543 030	80	50 pieces	<b>0 543 015</b>		
	Ø 10 x 15 mm	0 543 030	120	50 pieces	<b>0 543 016</b>		
	Ø 13 x 17 mm	0 543 031	80	50 pieces	<b>0 543 017</b>		
	Ø 13 x 17 mm	0 543 031	120	50 pieces	<b>0 543 018</b>		
	Ø 16 x 26 mm	0 543 032	80	50 pieces	<b>0 543 021</b>		
	Ø 16 x 26 mm	0 543 032	120	50 pieces	<b>0 543 022</b>		
<b>SiC-Cool</b>							
Ideal for processing components made of titanium and aluminium, in addition to their respective alloys. Excellent for use in aircraft and turbine construction and the correspondent maintenance. The special grit selection and the active grinding additive material in the bond allow a cool cut, reduce the workpieces temperature and prevent adhesion of the chips.	Ø 5 x 11 mm	0 544 420	80	50 pieces	<b>0 543 008</b>		
	Ø 5 x 11 mm	0 544 420	150	50 pieces	<b>0 543 009</b>		
	Ø 7 x 13 mm	0 544 408	80	50 pieces	<b>0 543 010</b>		
	Ø 7 x 13 mm	0 544 408	150	50 pieces	<b>0 543 011</b>		
	Ø 13 x 17 mm	0 543 031	80	50 pieces	<b>0 543 019</b>		
	Ø 13 x 17 mm	0 543 031	150	50 pieces	<b>0 543 020</b>		
	Ø 16 x 26 mm	0 543 032	80	50 pieces	<b>0 543 023</b>		
	Ø 16 x 26 mm	0 543 032	150	50 pieces	<b>0 543 024</b>		



### Accessories / spare parts

	Head dimensions	Shank dimensions	Packing quantity	Order No.	Price from		
					1 pack	5 packs	10 pieces
<b>Rubber holder</b>							
<b>rounded cylinder</b>							
	Ø 5 x 11 mm	Ø 3 x 25 mm		<b>0 544 407</b>			
	Ø 7 x 13 mm	Ø 3 x 25 mm		<b>0 544 408</b>			
	Ø 10 x 15 mm	Ø 3 x 25 mm		<b>0 544 409</b>			
	Ø 10 x 15 mm	Ø 3 x 30 mm	5 pieces	<b>0 543 030</b>			
	Ø 13 x 19 mm	Ø 3 x 25 mm		<b>0 544 410</b>			
	Ø 13 x 17 mm	Ø 6 x 40 mm	5 pieces	<b>0 543 031</b>			
	Ø 16 x 26 mm	Ø 3 x 25 mm		<b>0 544 411</b>			
		Ø 6 x 40 mm		<b>0 544 412</b>			
	Ø 16 x 26 mm	Ø 6 x 40 mm	5 pieces	<b>0 543 032</b>			

## 2 Abrasive caps and rubber holders jokeFlex

### jokeFlex abrasive sleeves and caps

Thanks to their seamless and transition-free shape, jokeFlex abrasive sleeves and caps achieve top results. They are push-fitted on elastic, suitably shaped rubber holders. The special feature owing to the slotted shape of the rubber holder, the push-fit abrasive sleeves and caps are held securely by the rotational forces during processing. Once they are worn out, simply replace the sleeves/caps with new ones, re-using the same holder.

jokeFlex abrasive sleeves and caps run particularly true, are easy to guide and achieve a very soft grinding pattern.





Particularly very well suited for fine finishing of metals, particularly steels.

**Cutting speed Vmax: 40 m/s**

Outside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from	
					1 pack	5 packs
<b>Abrasive caps, rounded cone</b>						
<b>Green Corundum</b>						
Ø 7/6 x 15 mm	0 544 501	80	100 pieces	<b>0 544 511-1</b>		
	0 544 501	150	100 pieces	<b>0 544 512-1</b>		
Ø 13/11 x 25 mm	0 544 502	80	100 pieces	<b>0 544 513-1</b>		
	0 544 502	150	100 pieces	<b>0 544 514-1</b>		
Ø 18/16 x 32 mm	0 544 503	80	25 pieces	<b>0 544 515-1</b>		
	0 544 503	150	25 pieces	<b>0 544 516-1</b>		
Ø 23/21 x 40 mm	0 544 504	80	25 pieces	<b>0 544 517-1</b>		
	0 544 504	150	25 pieces	<b>0 544 518-1</b>		





### Accessories / spare parts



	Head dimensions	Shank dimensions	Order No.	Price from		
				1 piece	5 pieces	10 pieces
<b>Rubber holder, jokeFlex</b>						
<b>rounded cone</b>						
	Ø 5 / 4 x 15 mm	Ø 6 x 40 mm	<b>0 544 501</b>			
	Ø 11 / 9 x 25 mm	Ø 6 x 40 mm	<b>0 544 502</b>			
	Ø 16 / 14 x 32 mm	Ø 6 x 40 mm	<b>0 544 503</b>			
	Ø 21 / 19 x 40 mm	Ø 6 x 40 mm	<b>0 544 504</b>			

## Abrasive caps and rubber holders

### jokeFlex

	Outside dimensions	Suitable rubber holder	Grit size	Packing quantity	Order No.	Price from	
						1 pack	5 packs
<b>Abrasive caps, rounded cone</b>							
<b>Corundum</b>							
	Ø 6/10 x 85 mm	0 544 505	80	25 pieces	<b>0 544 521</b>		
		0 544 505	150	25 pieces	<b>0 544 522</b>		
	Ø 20/16 x 85 mm	0 544 507	80	25 pieces	<b>0 544 525</b>		

### Accessories / spare parts

	Head dimensions	Shank dimensions	Order No.	Price from		
				1 piece	5 pieces	10 pieces
<b>Rubber holder, jokeFlex</b>						
<b>rounded cone</b>						
	Ø 8 / 4 x 85 mm	Ø 6 x 40 mm	<b>0 544 505</b>			
	Ø 18 / 14 x 85 mm	Ø 6 x 40 mm	<b>0 544 507</b>			



# 2 Flap wheels

## Flap wheels

Large selection of flap wheels with 3 and 6 mm shanks, plus "special models" such as radially slotted flap wheels or those with a combination of abrasive cloths and fleece - for a particularly uniform microsection. The "fleece only" flap wheels are a further highlight in the range: a really super solution for very fine finishing. The cleaning grinding wheels are suitable for removing rust, weld splatters and other troublemakers from the workpiece.

### You'll find here:

Flap wheels shank Ø 3 mm **page 298**

Flap wheels shank Ø 6 mm **page 301**

Flap wheels with fleece lamellas **page 302**

Grinding wheels for cleaning **page 302**



**i** Max. rotational speed in relation to cutting speed  $V_{max}$  and  $\varnothing$  of the tool used

$\varnothing$	15 m/s	20 m/s	25 m/s	30 m/s	35 m/s	40 m/s	45 m/s	50 m/s	55 m/s	60 m/s
10 mm	28,500	38,200	47,700	57,300	66,800	76,400	86,000	95,500	105,000	114,600
15 mm	19,100	25,400	31,800	38,200	44,600	51,000	57,300	63,700	70,000	76,400
20 mm	14,300	19,100	23,900	28,700	33,400	38,200	43,000	47,800	52,600	57,400
25 mm	11,400	15,200	19,100	22,900	26,700	30,500	34,400	38,200	42,000	45,900
30 mm	9,500	12,700	15,900	19,000	22,300	25,400	28,500	31,800	34,800	38,000
40 mm	7,100	9,600	11,900	14,300	16,700	19,100	21,500	23,800	26,200	28,600
50 mm	5,700	7,600	9,500	11,400	13,400	15,300	17,000	19,000	20,900	22,800
60 mm	4,700	6,300	7,900	9,500	11,100	12,700	14,300	15,900	17,500	19,100
75 mm	3,800	5,100	6,400	7,700	9,000	10,100	11,600	12,800	14,100	15,400
80 mm	3,500	4,700	5,900	7,100	8,360	8,360	10,700	11,900	13,100	14,300
100 mm	2,800	3,800	4,800	5,700	6,700	7,650	8,600	9,600	10,500	11,400
125 mm	2,300	3,000	3,800	4,600	5,300	6,150	6,900	7,600	8,500	9,200
150 mm	1,900	2,500	3,200	3,800	4,500	5,100	5,700	6,400	7,000	7,600
175 mm	1,600	2,200	2,700	3,300	3,800	4,350	4,950	5,400	6,050	6,600
200 mm	1,400	1,900	2,400	2,900	3,400	3,850	4,350	4,800	5,300	5,800
250 mm	1,100	1,500	1,900	2,300	2,700	3,100	3,450	3,800	4,200	4,600
300 mm	1,000	1,300	1,600	1,900	2,200	2,550	2,850	3,200	3,500	3,800

## Flap wheels jokeFlex shank Ø 3 mm

For elastic grinding. The slit lamellas of jokeFlex flap wheels allows them to adapt better to the contour of the workpiece being processed. They cover a wide range of applications: from the metal-working and finishing to the rubber and plastics industry.

**Cutting speed Vmax: 40 m/sec.**



Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from		
					1 piece	10 pieces	20 pieces
Ø 10 x 10 mm	60	Ø 3 x 40 mm	76,400 rpm	<b>0 543 902</b>			
	80	Ø 3 x 40 mm	76,400 rpm	<b>0 543 903</b>			
	120	Ø 3 x 40 mm	76,400 rpm	<b>0 543 904</b>			
	150	Ø 3 x 40 mm	76,400 rpm	<b>0 543 906</b>			
	180	Ø 3 x 40 mm	76,400 rpm	<b>0 543 907</b>			
	240	Ø 3 x 40 mm	76,400 rpm	<b>0 543 908</b>			
	320	Ø 3 x 40 mm	76,400 rpm	<b>0 543 909</b>			
Ø 10 x 15 mm	80	Ø 3 x 40 mm	76,400 rpm	<b>0 543 913</b>			
	150	Ø 3 x 40 mm	76,400 rpm	<b>0 543 916</b>			
	240	Ø 3 x 40 mm	76,400 rpm	<b>0 543 918</b>			
	320	Ø 3 x 40 mm	76,400 rpm	<b>0 543 919</b>			
Ø 15 x 10 mm	80	Ø 3 x 40 mm	51,000 rpm	<b>0 543 923</b>			
	150	Ø 3 x 40 mm	51,000 rpm	<b>0 543 926</b>			
	240	Ø 3 x 40 mm	51,000 rpm	<b>0 543 928</b>			
	320	Ø 3 x 40 mm	51,000 rpm	<b>0 543 929</b>			
Ø 15 x 15 mm	80	Ø 3 x 40 mm	51,000 rpm	<b>0 543 933</b>			
	150	Ø 3 x 40 mm	51,000 rpm	<b>0 543 936</b>			
	240	Ø 3 x 40 mm	51,000 rpm	<b>0 543 938</b>			
	320	Ø 3 x 40 mm	51,000 rpm	<b>0 543 939</b>			
Ø 20 x 5 mm	80	Ø 3 x 40 mm	38,200 rpm	<b>0 543 943</b>			
	150	Ø 3 x 40 mm	38,200 rpm	<b>0 543 946</b>			
	240	Ø 3 x 40 mm	38,200 rpm	<b>0 543 948</b>			
	320	Ø 3 x 40 mm	38,200 rpm	<b>0 543 949</b>			
Ø 20 x 10 mm	80	Ø 3 x 40 mm	38,200 rpm	<b>0 543 953</b>			
	150	Ø 3 x 40 mm	38,200 rpm	<b>0 543 956</b>			
	240	Ø 3 x 40 mm	38,200 rpm	<b>0 543 958</b>			
	320	Ø 3 x 40 mm	38,200 rpm	<b>0 543 959</b>			
Ø 20 x 15 mm	80	Ø 3 x 40 mm	38,200 rpm	<b>0 543 963</b>			
	150	Ø 3 x 40 mm	38,200 rpm	<b>0 543 966</b>			
	240	Ø 3 x 40 mm	38,200 rpm	<b>0 543 968</b>			
	320	Ø 3 x 40 mm	38,200 rpm	<b>0 543 969</b>			
Ø 20 x 20 mm	80	Ø 3 x 40 mm	38,200 rpm	<b>0 543 973</b>			
	150	Ø 3 x 40 mm	38,200 rpm	<b>0 543 976</b>			
	240	Ø 3 x 40 mm	38,200 rpm	<b>0 543 978</b>			
	320	Ø 3 x 40 mm	38,200 rpm	<b>0 543 979</b>			
Ø 25 x 5 mm	80	Ø 3 x 40 mm	30,500 rpm	<b>0 543 983</b>			
	150	Ø 3 x 40 mm	30,500 rpm	<b>0 543 986</b>			
	240	Ø 3 x 40 mm	30,500 rpm	<b>0 543 988</b>			
	320	Ø 3 x 40 mm	30,500 rpm	<b>0 543 989</b>			

## 2 Flap wheels jokeFlex shank Ø 3 mm

	Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from		
						1 piece	10 pieces	20 pieces
	Ø 25 x 10 mm	80	Ø 3 x 40 mm	30,500 rpm	<b>0 543 993</b>			
		150	Ø 3 x 40 mm	30,500 rpm	<b>0 543 996</b>			
		240	Ø 3 x 40 mm	30,500 rpm	<b>0 543 998</b>			
		320	Ø 3 x 40 mm	30,500 rpm	<b>0 543 999</b>			
	Ø 30 x 5 mm	60	Ø 3 x 40 mm	25,400 rpm	<b>0 544 222</b>			
		80	Ø 3 x 40 mm	25,400 rpm	<b>0 544 223</b>			
		150	Ø 3 x 40 mm	25,400 rpm	<b>0 544 226</b>			
		240	Ø 3 x 40 mm	25,400 rpm	<b>0 544 228</b>			
	Ø 30 x 10 mm	320	Ø 3 x 40 mm	25,400 rpm	<b>0 544 229</b>			
		60	Ø 3 x 40 mm	25,400 rpm	<b>0 544 232</b>			
		80	Ø 3 x 40 mm	25,400 rpm	<b>0 544 233</b>			
		150	Ø 3 x 40 mm	25,400 rpm	<b>0 544 236</b>			
240		Ø 3 x 40 mm	25,400 rpm	<b>0 544 238</b>				
Ø 40 x 5 mm	320	Ø 3 x 40 mm	25,400 rpm	<b>0 544 239</b>				
	60	Ø 3 x 40 mm	19,100 rpm	<b>0 544 532</b>				
	80	Ø 3 x 40 mm	19,100 rpm	<b>0 544 533</b>				
	150	Ø 3 x 40 mm	19,100 rpm	<b>0 544 536</b>				
Ø 40 x 10 mm	320	Ø 3 x 40 mm	19,100 rpm	<b>0 544 539</b>				
	80	Ø 3 x 40 mm	19,100 rpm	<b>0 544 243</b>				
	150	Ø 3 x 40 mm	19,100 rpm	<b>0 544 246</b>				
Ø 40 x 15 mm	80	Ø 3 x 40 mm	19,100 rpm	<b>0 544 253</b>				
	240	Ø 3 x 40 mm	19,100 rpm	<b>0 544 258</b>				



### Two short working stages are better than a single long one!

Even if it seems tempting to complete the "job" in one single stage: at the final count you will work more efficiently with two harmonised working stages using different grit sizes (from coarse to fine)!

Consult **Markus Abstoß**:  
+49 2204 839-0  
m.abstoss@joke.de



### Even more choice

Apart from the large choice of flap wheels shown here, we also offer further dimensions on request. Please contact





**Markus Abstoß**:  
Tel. +49 2204 839-0  
m.abstoss@joke.de

## Flap wheels jokeFlex shank Ø 6 mm

2

For elastic grinding. The slit lamellas of jokeFlex flap wheels allows them to adapt better to the contour of the workpiece being processed. They cover a wide range of applications: from the metal-working and finishing to the rubber and plastics industry.

Cutting speed Vmax: 40 m/sec.

	Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from		
						1 piece	10 pieces	20 pieces
<b>Flap wheels with lamellas, corundum, shank Ø 6 mm</b>								
	Ø 40 x 10 mm	60	Ø 6 x 40 mm	19,100 rpm	<b>0 544 362</b>			
		80	Ø 6 x 40 mm	19,100 rpm	<b>0 544 363</b>			
		150	Ø 6 x 40 mm	19,100 rpm	<b>0 544 366</b>			
		240	Ø 6 x 40 mm	19,100 rpm	<b>0 544 368</b>			
		320	Ø 6 x 40 mm	19,100 rpm	<b>0 544 369</b>			
	Ø 40 x 15 mm	60	Ø 6 x 40 mm	19,100 rpm	<b>0 544 372</b>			
		80	Ø 6 x 40 mm	19,100 rpm	<b>0 544 373</b>			
		120	Ø 6 x 40 mm	19,100 rpm	<b>0 544 374</b>			
		150	Ø 6 x 40 mm	19,100 rpm	<b>0 544 376</b>			
		180	Ø 6 x 40 mm	19,100 rpm	<b>0 544 377</b>			
		240	Ø 6 x 40 mm	19,100 rpm	<b>0 544 378</b>			
		320	Ø 6 x 40 mm	19,100 rpm	<b>0 544 379</b>			
	Ø 50 x 5 mm	60	Ø 6 x 40 mm	15,300 rpm	<b>0 544 542</b>			
		80	Ø 6 x 40 mm	15,300 rpm	<b>0 544 543</b>			
		150	Ø 6 x 40 mm	15,300 rpm	<b>0 544 546</b>			
	Ø 50 x 10 mm	60	Ø 6 x 38 mm	15,300 rpm	<b>0 544 262</b>			
		80	Ø 6 x 40 mm	15,300 rpm	<b>0 544 263</b>			
		150	Ø 6 x 40 mm	15,300 rpm	<b>0 544 266</b>			
		240	Ø 6 x 40 mm	15,300 rpm	<b>0 544 268</b>			
	Ø 60 x 5 mm	60	Ø 6 x 40 mm	12,700 rpm	<b>0 544 552</b>			
		80	Ø 6 x 40 mm	12,700 rpm	<b>0 544 553</b>			
		150	Ø 6 x 40 mm	12,700 rpm	<b>0 544 556</b>			
		320	Ø 6 x 40 mm	12,700 rpm	<b>0 544 559</b>			
	Ø 80 x 5 mm	80	Ø 6 x 40 mm	8,360 rpm	<b>0 544 563</b>			
		150	Ø 6 x 40 mm	8,360 rpm	<b>0 544 566</b>			
	Ø 60 x 40 mm	60	Ø 6 x 40 mm	12,700 rpm	<b>0 544 322</b>			
		80	Ø 6 x 40 mm	12,700 rpm	<b>0 544 323</b>			
		150	Ø 6 x 40 mm	12,700 rpm	<b>0 544 326</b>			
		320	Ø 6 x 40 mm	12,700 rpm	<b>0 544 329</b>			

## 2 Flap wheels, SiC shank Ø 6 mm

It is harder and more brittle than corundum. Applications include non-ferrous metals, stainless steels, ceramic and mineral materials, high-carbon steels, plastics and glass, etc.


Cutting speed  $V_{max}$ : 40 m/sec.

	Head dimensions	Grit size	Shank dimensions	Packing quantity	Order No.	Price from		
						1 pack	5 packs	10 packs
<b>Flap wheels, SiC, shank Ø 6 mm</b>								
	Ø 60 x 30 mm	60	Ø 6 x 40 mm	10 pieces	<b>0 543 686</b>			
		80	Ø 6 x 40 mm	10 pieces	<b>0 543 687</b>			
		120	Ø 6 x 40 mm	10 pieces	<b>0 543 688</b>			

## Flap wheels with fleece lamellas shank Ø 6 mm

Flap wheels made of combined grinding fleece/cloth, sulphur-free. The combination of grinding fleece/cloth achieves a more uniform grinding pattern with high stock removal.

Cutting speed  $V_{max}$ : 40 m/sec.

	Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from	
						1 piece	10 pieces
<b>Flap wheels made of combined fleece / cloth lamellas, corundum, shank Ø 6 mm</b>							
	Ø 40 x 20 mm	medium / K 80	Ø 6 x 40 mm	19,100 rpm	<b>0 543 450</b>		
		fine / K 150	Ø 6 x 40 mm	19,100 rpm	<b>0 543 451</b>		
		very fine / K 240	Ø 6 x 40 mm	19,100 rpm	<b>0 543 452</b>		
	Ø 50 x 20 mm	medium / K 80	Ø 6 x 40 mm	15,300 rpm	<b>0 543 456</b>		
		fine / K 150	Ø 6 x 40 mm	15,300 rpm	<b>0 543 457</b>		
		very fine / K 240	Ø 6 x 40 mm	15,300 rpm	<b>0 543 458</b>		
	Ø 60 x 30 mm	medium / K 80	Ø 6 x 40 mm	12,700 rpm	<b>0 543 462</b>		
		fine / K 150	Ø 6 x 40 mm	12,700 rpm	<b>0 543 463</b>		
		very fine / K 240	Ø 6 x 40 mm	12,700 rpm	<b>0 543 464</b>		

## Cleaning flap wheels shank Ø 6 mm

The ideal solution for cleaning with simultaneous surface preparation. For aggressive removal of rust, weld splatters, coating and paint. Also very suitable for deburring.

Cutting speed  $V_{max}$ : 35 m/sec.

	Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from		
						1 piece	5 pieces	10 pieces
<b>Cleaning flap wheels, type "coarse"</b>								
	Ø 55 x 15 mm	coarse	Ø 6 x 40 mm	14,000 rpm	<b>0 544 588</b>			




Grit size fleece	Comparable to FEPA
coarse	K 40 – 80
medium	K 100 – 180
fine	K 220 – 240
very fine	K 280 – 360

## Flap wheels with fleece lamellas shank Ø 3 mm

These fan-shaped grinders have radially arranged abrasive fleece lamellas and are ideal for very fine work in awkward areas. They achieve highest surface qualities.


**Cutting speed Vmax: 10 m/sec.**

Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from		
					1 piece	10 pieces	20 pieces
<b>Flap wheels made of fleece lamellas, corundum, shank Ø 3 mm</b>							
	coarse	Ø 3 x 40 mm	13,000 rpm	<b>0 547 001</b>			
	medium	Ø 3 x 40 mm	13,000 rpm	<b>0 547 002</b>			
	fine	Ø 3 x 40 mm	13,000 rpm	<b>0 547 003</b>			
	very fine	Ø 3 x 40 mm	13,000 rpm	<b>0 547 004</b>			
Ø 30 x 10 mm	coarse	Ø 3 x 40 mm	11,000 rpm	<b>0 547 009</b>			
	medium	Ø 3 x 40 mm	11,000 rpm	<b>0 547 010</b>			
	fine	Ø 3 x 40 mm	11,000 rpm	<b>0 547 011</b>			
	very fine	Ø 3 x 40 mm	11,000 rpm	<b>0 547 012</b>			
Ø 30 x 20 mm	coarse	Ø 3 x 40 mm	11,000 rpm	<b>0 547 017</b>			
	medium	Ø 3 x 40 mm	11,000 rpm	<b>0 547 018</b>			
	fine	Ø 3 x 40 mm	11,000 rpm	<b>0 547 019</b>			
	very fine	Ø 3 x 40 mm	11,000 rpm	<b>0 547 020</b>			
Ø 30 x 30 mm	coarse	Ø 3 x 40 mm	11,000 rpm	<b>0 547 025</b>			
	medium	Ø 3 x 40 mm	11,000 rpm	<b>0 547 026</b>			
	very fine	Ø 3 x 40 mm	11,000 rpm	<b>0 547 028</b>			

## Flap wheels with fleece lamellas shank Ø 6 mm

These fan-shaped grinders have radially arranged abrasive fleece lamellas and are ideal for very fine work in awkward areas. They achieve highest surface qualities.

**Cutting speed Vmax: 10 m/sec.**

Head dimensions	Grit size	Shank dimensions	Rotation speed max.	Order No.	Price from		
					1 piece	10 pieces	20 pieces
<b>Flap wheels made of fleece lamellas, corundum, shank Ø 6 mm</b>							
	coarse	Ø 6 x 40 mm	8,000 rpm	<b>0 547 033</b>			
	medium	Ø 6 x 40 mm	8,000 rpm	<b>0 547 034</b>			
	fine	Ø 6 x 40 mm	8,000 rpm	<b>0 547 035</b>			
	very fine	Ø 6 x 40 mm	8,000 rpm	<b>0 547 036</b>			
Ø 40 x 40 mm	medium	Ø 6 x 40 mm	8,000 rpm	<b>0 547 042</b>			
	fine	Ø 6 x 40 mm	8,000 rpm	<b>0 547 043</b>			
	very fine	Ø 6 x 40 mm	8,000 rpm	<b>0 547 044</b>			
Ø 50 x 20 mm	medium	Ø 6 x 40 mm	6,500 rpm	<b>0 547 046</b>			
	fine	Ø 6 x 40 mm	6,500 rpm	<b>0 547 047</b>			
	very fine	Ø 6 x 40 mm	6,500 rpm	<b>0 547 048</b>			



### Even more choice on request!

These flap wheels are available in many more sizes. Please contact **Markus Abstoß**:  
Tel. +49 22 04 839-0 • [m.abstoss@joke.de](mailto:m.abstoss@joke.de)




## 2 Cup wheel discs




These cup wheel discs are screwed onto the mandrel (Order No. 0 750 512) of the TURBO hand grinder. Thanks to the separate cup wheel disc receptacle, these tools can also be used with all commercially available rotating handpieces.

**Rotation speed max.: 25000 rpm**



Cup wheel disc with TURBO hand air grinder

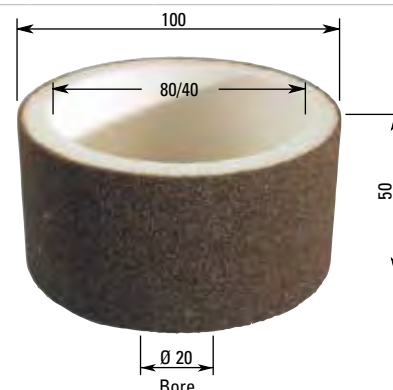
	Dimensions	Grit size	Colour	Rotation speed max.	Order No.	Price from	
						1 piece	10 pieces
<b>Cup wheel discs, high-grade corundum</b>							
	Ø 30	60	brown	25,000 rpm	<b>0 530 721</b>		
		100	brown	25,000 rpm	<b>0 530 722</b>		
		150	brown	25,000 rpm	<b>0 530 723</b>		

### Accessories / spare parts

	Order No.	Price from
		1 piece
<b>Clamping shank</b>		
		
For receiving the cup wheel discs and rubber holders on TURBO hand grinders.	<b>0 750 512</b>	

## EKW cup wheel discs

	Dimensions	Grit size	Order No.	Price from	
				1 piece	5 pieces
<b>EKW cup wheel discs</b>					
					
Hardness JOT, resin-hardened edge for grinding HSS <b>max. speed 7,500 rpm</b>	Ø 100 x 50 x 20 mm	80	<b>0 542 751</b>		
<b>EKW cup wheel disc – Top quality</b>					
					
Hardness JOT, resin-hardened edge for grinding HSS, hardened steel and hard metal <b>max. speed 7,500 rpm</b>	Ø 100 x 50 x 20 mm	80	<b>0 542 753</b>		



## Nylon cut-off discs, fibre-reinforced

### Nylon cut-off discs, fibre-reinforced

Much more breakproof for a high level of working safety. Thinner discs can be selected.

#### This results in the following advantages:

- very small contact area
- little heat generation in the cut
- narrower cut
- less expenditure of effort
- fast separation time
- less burr formation



Use with and without coolant/lubricant!

		Dimensions	Drilling dimension	Matching-receptacles	Rotation speed max.	Packing quantity	Order No.	Price from		
								1 pack	5 packs	10 packs
<b>Nylon cut-off discs, fibre-reinforced</b>										
<b>high-grade corundum</b>										
	for hardened and unhardened steels	Ø 22 x 0.2 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	10 pieces	<b>0 544 901</b>			
		Ø 22 x 0.3 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	10 pieces	<b>0 544 902</b>			
		Ø 22 x 0.5 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	10 pieces	<b>0 544 903</b>			
		Ø 25 x 0.2 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	10 pieces	<b>0 544 904</b>			
		Ø 25 x 0.3 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	10 pieces	<b>0 544 905</b>			
		Ø 25 x 0.5 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	10 pieces	<b>0 544 906</b>			
		Ø 40 x 0.5 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	10 pieces	<b>0 544 907</b>			
		Ø 40 x 0.7 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	10 pieces	<b>0 544 908</b>			
		Ø 40 x 1.0 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	10 pieces	<b>0 544 909</b>			
<b>silicon carbide</b>										
	for stainless steels and non-ferrous metals	Ø 22 x 0.2 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	10 pieces	<b>0 544 910</b>			
		Ø 22 x 0.3 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	10 pieces	<b>0 544 911</b>			
		Ø 25 x 0.2 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	10 pieces	<b>0 544 913</b>			
		Ø 25 x 0.3 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	10 pieces	<b>0 544 914</b>			

		Dimensions	Drilling dimension	Matchingreceptacles	Rotation speed max.	Order No.	Price from	
							1 piece	
<b>Nylon cut-off discs, fibre-reinforced</b>								
<b>diamond</b>								
	for ceramic and all difficult steels in aircraft, engine and power plant construction and for implant processing	Ø 20 x 0.2 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	<b>0 544 920</b>		
		Ø 20 x 0.3 mm	1.8 mm	21, 22, 23, 25	20,000 rpm	<b>0 544 921</b>		

### ⚙️ Accessories / spare parts

		for bore dimensions	Shank dimensions	Type	Max. disc size	Order No.	Price from	
							1 piece	10 pieces
<b>CRATEX® grinding wheel holder</b>								
		Ø 1.5 – 1.8 mm	Ø 2.35 x 40/28 mm	21	Ø 38 x 4.5 mm	<b>0 545 275</b>		
		Ø 1.5 – 1.8 mm	Ø 3 x 42 mm	22	Ø 38 x 4.5 mm	<b>0 545 276</b>		
		Ø 1.5 – 1.8 mm	Ø 6 x 42 mm	23	Ø 38 x 4.5 mm	<b>0 545 277</b>		
		Ø 1.5 – 1.8 mm	Ø 2.35 x 30/15 mm	25	Ø 38 x 4.5 mm	<b>0 545 279</b>		

# Abrasive discs

Abrasive discs need a firm hold, since only then do they develop their full performance. In order to provide them this hold, you can select from among three different types of fastenings for the abrasive discs on the holder:

The largest selection of grit sizes and diameters can be found among our **self-adhesive abrasive discs**. These disposable articles provide the most economical solution at the same time. In addition to the large selection in the catalogue, we also offer you many special solutions here, for example in the "soft" or SiC paper versions. Consult Markus Abstoß about the possibilities.

Very rapid abrasive disc changes are possible with our discs with Velcro fastening. In contrast to the self-adhesive version, the rubber holders can be reused in this case.

The **COMBIDISC®** system offers the best hold and a very large selection of discs. Simply screw the abrasive disc on to the rubber holder and set to work. Flying discs are finally a thing of the past with this solution. These abrasive discs are thermally more resilient and always sit centrally owing to the innovative fastener. The rubber holder can also be reused in this case too.

### Self-adhesive



### Velcro fastening



### COMBIDISC®



**309** Abrasive discs, self-adhesive

**309** Abrasive discs with Velcro fastening

**314** Abrasive discs with rapid clamping fastener COMBIDISC®



## Grinding stars Polistar Corundum

### Grinding stars Polistar

Highly versatile deburring tools for processing the internal surfaces of drilling holes and pipes. Optimally suitable for small diameters (Ø 7 to 40 mm).

Polistar can be clamped in multiple layers (offset in relation to one another) in the tool holders.

#### Applications:

- cleaning and fine grinding of drilling holes
- removal of annealing colours
- rounding of inlet and outlet sides for drilling holes
- removal of slight burrs

**Cutting speed Vmax: 20 m/sec.**



perfect for deburring of drill holes etc.

Dimensions	Grit size	Drilling dimension	Rotation speed max.	Packing quantity	Order No.	Price from 1 pack
<b>Grinding stars Polistar, corundum</b>						
Ø 20 mm	60	1.6 mm	20,000 rpm	25 pieces	<b>0 570 910-0</b>	
Ø 20 mm	80	1.6 mm	20,000 rpm	25 pieces	<b>0 570 911-0</b>	
Ø 20 mm	120	1.6 mm	20,000 rpm	25 pieces	<b>0 570 912-0</b>	
Ø 30 mm	60	1.6 mm	13,000 rpm	25 pieces	<b>0 570 913-0</b>	
Ø 30 mm	80	1.6 mm	13,000 rpm	25 pieces	<b>0 570 914-0</b>	
Ø 30 mm	120	1.6 mm	13,000 rpm	25 pieces	<b>0 570 915-0</b>	
Ø 40 mm	60	3 mm	10,000 rpm	10 pieces	<b>0 570 904-0</b>	
Ø 40 mm	80	3 mm	10,000 rpm	10 pieces	<b>0 570 905-0</b>	
Ø 40 mm	120	3 mm	10,000 rpm	10 pieces	<b>0 570 906-0</b>	
Ø 50 mm	60	3 mm	8,000 rpm	10 pieces	<b>0 570 907-0</b>	
Ø 50 mm	80	3 mm	8,000 rpm	10 pieces	<b>0 570 908-0</b>	
Ø 50 mm	120	3 mm	8,000 rpm	10 pieces	<b>0 570 909-0</b>	



### ⚙️ Accessories / spare parts

	for bore dimensions	Shank dimensions	Type	Max. disc size	Order No.	Price from 1 piece	10 pieces
<b>CRATEX® grinding wheel holder</b>							
	Ø 1.5 – 1.8 mm	Ø 2.35 x 40/28 mm	21	Ø 38 x 4.5 mm	<b>0 545 275</b>		
	Ø 1.5 – 1.8 mm	Ø 3 x 42 mm	22	Ø 38 x 4.5 mm	<b>0 545 276</b>		
	Ø 3 mm	Ø 6 x 40 mm	33	Ø 45 x 6 mm	<b>0 545 269</b>		

## 2 Grinding stars POLINOX Fleece


### Grinding stars POLINOX

The new fleece alternative to the Polistar corundum grindings stars. Owing to the fleece trimming the POLINOX stars are particularly adaptable and therefore predestined for tight working areas: drilling holes, recesses and places which are difficult to reach. Available in packs containing 5 pieces respectively in three dimensions and three grit sizes.


#### Applications:

- deburring of in components made of nonferrous metals and non-ferrous heavy metals
- fine grinding on internal surfaces of stainless steel pipes
- cleaning of thread turns

Cutting speed  $V_{max}$ : 20 m/sec.

	Dimensions	Grit size	Rotation speed max.	Packing quantity	Order No.	Price from	
						1 pack	4 packs
<b>Grinding stars POLINOX, corundum</b>							
	Ø 19 mm	P 80	20,000 rpm	5 pieces	<b>0 570 991</b>		
		very fine	20,000 rpm	5 pieces	<b>0 570 992</b>		
	Ø 25 mm	coarse	15,000 rpm	5 pieces	<b>0 570 993</b>		
		medium	15,000 rpm	5 pieces	<b>0 570 994</b>		
		very fine	15,000 rpm	5 pieces	<b>0 570 995</b>		
	Ø 38 mm	coarse	10,000 rpm	5 pieces	<b>0 570 996</b>		
		medium	10,000 rpm	5 pieces	<b>0 570 997</b>		
		very fine	10,000 rpm	5 pieces	<b>0 570 998</b>		

### Accessories / spare parts

	Shank dimensions	Type	Thread	Order No.	Price from
					1 piece
<b>suitable tool holders</b>					
	Ø 6 x 125 mm	XL	8/32-UNC	<b>0 570 960</b>	
	Ø 6 x 75 mm	L	8/32-UNC	<b>0 570 965</b>	

## Grinding wheels POLINOX Fleece

POLINOX rounds are suitable for flexible machining of complicated tool contours and are used in peripheral grinding.

#### Advantages:

Optimum adaptation to the contour due to high flexibility with a very long service life.

Reach points that are difficult to access such as deep slots or recesses.


No clogging of the tool due to open structure and high flexibility of the fleece material.

#### Recommendations for use:


to increase the application width, clamp up to three rounds next to each other.

For best performance, use at a recommended cutting speed of 10-25 m/sec.



	Dimensions	Drilling dimension	Grit size	Rotation speed max.	Packing quantity	Order No.	Price from	
							1 pack	4 packs
<b>Grinding wheels - POLINOX, corundum</b>								
	Ø 50 x 10 mm	6 mm	100	12,250 rpm	10 pieces	<b>0 570 860</b>		
	Ø 50 x 10 mm	6 mm	280	12,250 rpm	10 pieces	<b>0 570 861</b>		
	Ø 75 x 10 mm	6 mm	100	8,150 rpm	10 pieces	<b>0 570 862</b>		
	Ø 75 x 10 mm	6 mm	280	8,150 rpm	10 pieces	<b>0 570 863</b>		
	Ø 100 x 10 mm	13 mm	100	6,150 rpm	10 pieces	<b>0 570 864</b>		
			280	6,150 rpm	10 pieces	<b>0 570 865</b>		
	Ø 125 x 10 mm	13 mm	100	4,900 rpm	10 pieces	<b>0 570 866</b>		
			280	4,900 rpm	10 pieces	<b>0 570 867</b>		
	Ø 150 x 10 mm	13 mm	100	4,100 rpm	10 pieces	<b>0 570 868</b>		
	Ø 150 x 10 mm	13 mm	280	4,100 rpm	10 pieces	<b>0 570 869</b>		

## Accessories / spare parts

	for bore dimensions	Shank dimensions	Order No.	Price from	
				1 piece	5 pieces
<b>suitable tool holders</b>					
	Ø 6 mm	Ø 6 mm	<b>0 545 702</b>		
	Ø 13 mm	Ø 6 mm	<b>0 545 703</b>		



## Abrasive discs ROTAFLEX


### Silicon carbide, self-adhesive



Use with or without coolant/lubricant!

The silicon carbide abrasive discs are ideal for processing aluminium, copper, bronze, titanium, high-alloyed steels and fibre-reinforced plastics. Optimally suited for the aeronautical industry and in areas where only SiC is allowed.

**Cutting speed Vmax: 13 m/sec.**



	Dimensions	Grit size	Type	Rotation speed max.	Packing quantity	Order No.	Price from	
							1 pack	3 packs
<b>ROTAFLX abrasive discs</b>								
	Ø 30 mm	80	CPC 871	8,500 rpm	250 pieces	<b>0 530 660</b>		
		120	CPC 871	8,500 rpm	250 pieces	<b>0 530 662</b>		
		220	CPA 871	8,500 rpm	250 pieces	<b>0 530 665</b>		
		240	CPA 871	8,500 rpm	250 pieces	<b>0 530 666</b>		
		320	CPA 871	8,500 rpm	250 pieces	<b>0 530 668</b>		
		500	CPA 871	8,500 rpm	250 pieces	<b>0 530 671</b>		
		800	CPA 871	8,500 rpm	250 pieces	<b>0 530 673</b>		
		1000	CPA 871	8,500 rpm	250 pieces	<b>0 530 674</b>		
		1200	CPA 871	8,500 rpm	250 pieces	<b>0 530 675</b>		

## Abrasive discs ROTAFLEX-Trizact

### Corundum

The ROTAFLEX Trizact grinding sheets – a guarantee of particularly even surfaces and a perfect finish. Owing to the pyramid-shaped, uniform arrangement of identical abrasive particles on a foam-like carrier, the abrasive particles are continuously exposed during grinding. The result is reproducible and smooth surfaces with a longer service life.

**Cutting speed Vmax: 13 m/sec.**

	Dimensions	Grit size	Packing quantity	Order No.	Price from
					1 pack
<b>Abrasive discs ROTAFLEX-Trizact with velcro fastening</b>					
	Ø 30 mm	160	10 pieces	<b>0 572 001</b>	
<b>Abrasive discs ROTAFLEX-Trizact, self-adhesive</b>					
	Ø 30 mm	160	10 pieces	<b>0 572 101</b>	

## Accessories / spare parts




	Dimensions	Shank dimensions	Type	Suitable abrasive discs	Order No.	Price from		
						1 piece	5 pieces	10 pieces
<b>Rubber holder ROTAFLEX</b>								
	Ø 30 mm	Ø 3 x 26 mm	RK 2	R 2	<b>0 544 104</b>			



## 2 Abrasive discs ROTAFLEX

### Corundum, with velcro fastening


Owing to the velour Velcro fastening, these abrasive discs adhere particularly well to the corresponding rubber holders. Ideal for multiple use!  
**Cutting speed Vmax: 20 m/sec.**

	Dimensions	Grit size	Rotation speed max.	Packing quantity	Order No.	Price from		
						1 pack	3 packs	5 packs
<b>ROTAFLX abrasive discs with Velcro fastening</b>								
	Ø 20 mm	60	19,000 rpm	100 pieces	<b>0 544 012</b>			
		80	19,000 rpm	100 pieces	<b>0 544 013</b>			
		120	19,000 rpm	100 pieces	<b>0 544 014</b>			
		150	19,000 rpm	100 pieces	<b>0 544 015</b>			
		180	19,000 rpm	100 pieces	<b>0 544 016</b>			
		240	19,000 rpm	100 pieces	<b>0 544 017</b>			
	Ø 30 mm	320	19,000 rpm	100 pieces	<b>0 544 018</b>			
		60	13,000 rpm	100 pieces	<b>0 544 032</b>			
		80	13,000 rpm	100 pieces	<b>0 544 033</b>			
		120	13,000 rpm	100 pieces	<b>0 544 034</b>			
		180	13,000 rpm	100 pieces	<b>0 544 036</b>			
		240	13,000 rpm	100 pieces	<b>0 544 037</b>			
		320	13,000 rpm	100 pieces	<b>0 544 038</b>			

## Abrasive discs ROTAFLEX

### Corundum, with Velcro fastening

The matching rubber holders for abrasive discs with Velcro fastening. Unlike conventional stick-on discs, the rubber holder can be reused once the disc is worn out. **Cutting speed Vmax: 20 m/sec.**

	Dimensions	Shank dimensions	Order No.	Price from	
				1 piece	5 pieces
<b>Rubber holders with Velcro fastening</b>					
	Ø 18 mm	Ø 3 x 30 mm	<b>0 544 010</b>		
	Ø 30 mm	Ø 3 x 30 mm	<b>0 544 020</b>		
		Ø 6 x 40 mm	<b>0 544 030</b>		

## Abrasive discs ROTAFLEX

### Corundum, self-adhesive

For elastic grinding in combination with the suitable rubber holders.  
**Cutting speed Vmax: 13 m/sec.**

	Dimensions	Grit size	Type	Rotation speed max.	Packing quantity	Order No.	Price from		
							1 pack	5 packs	10 packs
<b>ROTAFLX abrasive discs</b>									
	Ø 12 mm	50	R 0	20,000 rpm	50 pieces	<b>0 544 111</b>			
		60	R 0	20,000 rpm	50 pieces	<b>0 544 112</b>			
		80	R 0	20,000 rpm	50 pieces	<b>0 544 113</b>			
		120	R 0	20,000 rpm	50 pieces	<b>0 544 114</b>			
		150	R 0	20,000 rpm	50 pieces	<b>0 544 115</b>			
		180	R 0	20,000 rpm	50 pieces	<b>0 544 116</b>			
		240	R 0	20,000 rpm	50 pieces	<b>0 544 117</b>			
		320	R 0	20,000 rpm	50 pieces	<b>0 544 118</b>			
		400	R 0	20,000 rpm	50 pieces	<b>0 544 119</b>			
		600	R 0	20,000 rpm	50 pieces	<b>0 544 174</b>			

# Abrasive discs ROTAFLEX

## Corundum, self-adhesive

	Dimensions	Grit size	Type	Rotation speed max.	Packing quantity	Order No.	Price from		
							1 pack	5 packs	10 packs
	Ø 20 mm	50	R 1	12,000 rpm	50 pieces	<b>0 544 121</b>			
		60	R 1	12,000 rpm	50 pieces	<b>0 544 122</b>			
		80	R 1	12,000 rpm	50 pieces	<b>0 544 123</b>			
		120	R 1	12,000 rpm	50 pieces	<b>0 544 124</b>			
		150	R 1	12,000 rpm	50 pieces	<b>0 544 125</b>			
		180	R 1	1,2000 rpm	50 pieces	<b>0 544 126</b>			
		240	R 1	12,000 rpm	50 pieces	<b>0 544 127</b>			
		320	R 1	12,000 rpm	50 pieces	<b>0 544 128</b>			
		400	R 1	12,000 rpm	50 pieces	<b>0 544 129</b>			
		600	R 1	12,000 rpm	50 pieces	<b>0 544 175</b>			
	Ø 33 mm	50	R 2	7,500 rpm	50 pieces	<b>0 544 131</b>			
		60	R 2	7,500 rpm	50 pieces	<b>0 544 132</b>			
		80	R 2	7,500 rpm	50 pieces	<b>0 544 133</b>			
		120	R 2	7,500 rpm	50 pieces	<b>0 544 134</b>			
		150	R 2	7,500 rpm	50 pieces	<b>0 544 135</b>			
		180	R 2	7,500 rpm	50 pieces	<b>0 544 136</b>			
		240	R 2	7,500 rpm	50 pieces	<b>0 544 137</b>			
		320	R 2	7,500 rpm	50 pieces	<b>0 544 138</b>			
		400	R 2	7,500 rpm	50 pieces	<b>0 544 139</b>			
		600	R 2	7,500 rpm	50 pieces	<b>0 544 176</b>			
	Ø 50 mm	50	R 3	5,000 rpm	50 pieces	<b>0 544 141</b>			
		60	R 3	5,000 rpm	50 pieces	<b>0 544 142</b>			
		80	R 3	5,000 rpm	50 pieces	<b>0 544 143</b>			
		120	R 3	5,000 rpm	50 pieces	<b>0 544 144</b>			
		150	R 3	5,000 rpm	50 pieces	<b>0 544 145</b>			
		180	R 3	5,000 rpm	50 pieces	<b>0 544 146</b>			
		240	R 3	5,000 rpm	50 pieces	<b>0 544 147</b>			
		320	R 3	5,000 rpm	50 pieces	<b>0 544 148</b>			
		400	R 3	5,000 rpm	50 pieces	<b>0 544 149</b>			
		600	R 3	5,000 rpm	50 pieces	<b>0 544 177</b>			

### Accessories / spare parts

	Dimensions	Shank dimensions	Type	Suitable abrasive discs	Order No.	Price from		
						1 piece	5 pieces	10 pieces
<b>Rubber holder ROTAFLEX</b>								
	Ø 10 mm	Ø 3 x 26 mm	RK 0	R 0	<b>0 544 101</b>			
	Ø 18 mm	Ø 2.35 x 26 mm	RK 1	R 1	<b>0 544 102</b>			
		Ø 3 x 26 mm	RK 1	R 1	<b>0 544 103</b>			
	Ø 30 mm	Ø 3 x 26 mm	RK 2	R 2	<b>0 544 104</b>			
	Ø 45 mm	Ø 6 x 32 mm	RK 3	R 3	<b>0 544 105</b>			

# 2 Abrasive discs ROTAFLEX

## Silicon carbide, self-adhesive

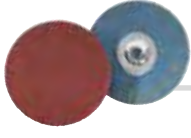








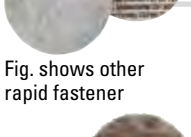









	Steel, cast steel	Coarse grinding of steel and cast steel	Stainless steel (INOX)	Materials with high thermal stability (Ni-Co alloy)	Hard non-ferrous metals, titanium, bronze, hardened aluminium alloys	Soft non-ferrous metals, titanium, copper, aluminium alloys	Carbide metal, hard material coatings, hard facings, glass, GRP, CRP	Cleaning, structuring, deburring	Polishing
 <p><b>Corundum A</b> universally for all metals <i>page 314</i></p>	◆					◆			
 <p><b>Corundum A-Forte</b> universally, long service life, cool cut <i>on request!</i></p>	◆					◆			
 <p><b>Silicon carbide</b> non-ferrous metals, titanium, aeronautical industry, SiC authorisation <i>on request!</i></p>			◆	◆					
 <p><b>Fleece rounds, hard</b> universally for surface processing of many materials <i>page 314</i></p>							◆		
 <p><b>Fleece rounds, soft</b> universally for surface processing of many materials <i>page 314</i></p>							◆		
 <p><b>Felt rounds</b> polishing of larger surfaces <i>on request!</i></p>								◆	
 <p><b>Corundum A-FLEX</b> universally for all metals, flexibly for uneven surfaces <i>on request!</i></p>	◆					◆			
 <p><b>Ceramic grit CO-COOL</b> extremely hard materials, high stock removal, long service life <i>on request!</i></p>			◆	◆	◆				
 <p><b>TX rounds</b> surface processing, deburring, particularly on INOX and aluminium <i>on request!</i></p>			◆		◆	◆			
 <p><b>Cleaning rounds POLICLEAN®</b> cleaning, removal, surface processing <i>on request!</i></p>								◆	

Fig. shows other rapid fastener


# Abrasive discs ROTAFLEX

## Silicon carbide, self-adhesive

	Steel, cast steel	Coarse grinding of steel and cast steel	Stainless steel (INOX)	Materials with high thermal stability (Ni-Co alloy)	Hard non-ferrous metals, titanium, bronze, hardened aluminium alloys	Soft non-ferrous metals, brass, copper, aluminium alloys	Carbide metal, hard material coatings, hard facings, glass, GRP, CRP	Cleaning, structuring, deburring	Polishing
 <p><b>Corundum A-PLUS</b> universally for metals, long service lives, stable carrier material</p> <p>on request!</p>	◆					◆			
 <p><b>Small fibre grinders corundum A</b> surface and edge grinding, very long service lives, reinforced fibre backing</p> <p>on request!</p>		◆							
 <p><b>Corundum A-COOL</b> materials difficult to cut, such as INOX, Hastelloy, Inconel, Ni-Co</p> <p>on request!</p>			◆	◆	◆				
 <p><b>Zirconium corundum Z</b> for all carbide metals during coarse grinding up to grit size 36 and grit size 80</p> <p>on request!</p>	◆	◆	◆						
 <p><b>Small fibre grinders ceramic grit CO-COOL</b> extremely hard materials, high stock removal, reinforced fibre backing</p> <p>on request!</p>			◆	◆	◆				
 <p><b>Diamond grinding discs</b> Hastelloy, Inconel, chrome, tungsten, titanium carbide, carbide metal, CRP/GRP</p> <p>on request!</p>						◆			
 <p><b>Brush</b> remove adhesive etc., cleaning of contours and edges</p> <p>on request!</p> <p>Fig. shows other rapid fastener</p>							◆		
 <p><b>mini-POLIFAN Corundum A</b> universal coarse grinding tasks, high cutting performance</p> <p>Fig. shows other rapid fastener</p>		◆							
 <p><b>mini-POLIFAN Zirconium corundum ZA</b> groarse grinding tasks, high cutting performance</p> <p>on request!</p>		◆	◆	◆					



## 2 Grinding and polishing discs COMBIDISC® Corundum A

The corundum A version is suitable for universal use on metals and other materials. "Medium" version abrasive discs are recommended.

	Dimensions	Grit size	Recommended speed	Rotation speed max.	Packing quantity	Order No.	Price from	
							1 pack	4 packs
<b>Abrasive discs COMBIDISC® corundum A</b>								
	Ø 20 mm	60	20,000 rpm	35,000 rpm	50 pieces	<b>0 541 020</b>		
		80	20,000 rpm	35,000 rpm	50 pieces	<b>0 541 021</b>		
		120	20,000 rpm	35,000 rpm	50 pieces	<b>0 541 022</b>		
		180	20,000 rpm	35,000 rpm	50 pieces	<b>0 541 023</b>		
		320	20,000 rpm	35,000 rpm	50 pieces	<b>0 541 024</b>		
	Ø 25 mm	60	15,000 rpm	26,000 rpm	50 pieces	<b>0 541 025</b>		
		80	15,000 rpm	26,000 rpm	50 pieces	<b>0 541 026</b>		
		120	15,000 rpm	26,000 rpm	50 pieces	<b>0 541 027</b>		
		180	15,000 rpm	26,000 rpm	50 pieces	<b>0 541 028</b>		
		320	15,000 rpm	26,000 rpm	50 pieces	<b>0 541 029</b>		
	Ø 38 mm	60	10,000 rpm	16,000 rpm	50 pieces	<b>0 541 031</b>		
		80	10,000 rpm	16,000 rpm	50 pieces	<b>0 541 032</b>		
		120	10,000 rpm	16,000 rpm	50 pieces	<b>0 541 033</b>		
		180	10,000 rpm	16,000 rpm	50 pieces	<b>0 541 034</b>		
		320	10,000 rpm	16,000 rpm	50 pieces	<b>0 541 035</b>		
Ø 50 mm	60	8,000 rpm	13,000 rpm	50 pieces	<b>0 541 037</b>			
	80	8,000 rpm	13,000 rpm	50 pieces	<b>0 541 038</b>			
	120	8,000 rpm	13,000 rpm	50 pieces	<b>0 541 039</b>			
	180	8,000 rpm	13,000 rpm	50 pieces	<b>0 541 040</b>			
	320	8,000 rpm	13,000 rpm	50 pieces	<b>0 541 041</b>			

## Grinding and polishing discs COMBIDISC® Fleece rounds

The fleece rounds are universally suitable for surface processing on metals. For eliminating grinding marks, removing oxidation and for light deburring work for example. The flexibility of the fleece rounds is determined by the choice of holder hardness.

	Dimensions	Grit size	Recommended speed	Rotation speed max.	Packing quantity	Order No.	Price from	
							1 pack	4 packs
<b>Fleece rounds COMBIDISC® – hard version, corundum A</b>								
	Ø 20 mm	very fine	14,000 rpm	19,000 rpm	25 pieces	<b>0 541 110</b>		
	Ø 25 mm	coarse	11,000 rpm	15,000 rpm	25 pieces	<b>0 541 111</b>		
	Ø 25 mm	medium	11,000 rpm	15,000 rpm	25 pieces	<b>0 541 112</b>		
	Ø 25 mm	very fine	11,000 rpm	15,000 rpm	25 pieces	<b>0 541 113</b>		
	Ø 38 mm	coarse	7,000 rpm	10,000 rpm	25 pieces	<b>0 541 114</b>		
	Ø 38 mm	medium	7,000 rpm	10,000 rpm	25 pieces	<b>0 541 115</b>		
	Ø 38 mm	very fine	7,000 rpm	10,000 rpm	25 pieces	<b>0 541 116</b>		
	Ø 50 mm	coarse	5,500 rpm	7,500 rpm	25 pieces	<b>0 541 117</b>		
	Ø 50 mm	medium	5,500 rpm	7,500 rpm	25 pieces	<b>0 541 118</b>		
	Ø 50 mm	very fine	5,500 rpm	7,500 rpm	25 pieces	<b>0 541 119</b>		
	<b>Fleece rounds COMBIDISC® – soft version, corundum A</b>							
	Ø 50 mm	medium	5,500 rpm	7,500 rpm	25 pieces	<b>0 541 130</b>		
	Ø 50 mm	fine	5,500 rpm	7,500 rpm	25 pieces	<b>0 541 131</b>		
	Ø 50 mm	very fine	5,500 rpm	7,500 rpm	25 pieces	<b>0 541 132</b>		

## Grinding and polishing discs COMBIDISC® Ceramic grit CO-COOL

Ceramic grit CO-COOL is suitable for processing unalloyed and alloyed steels, cast iron, stainless steel (INOX), titanium, nickel alloys and extra-hard materials. Consistent high performance self-sharpening ceramic grits. Fillers with an active grinding effect in the coating result in an outstanding improvement in stock removal and long stock removal periods and service lives. Furthermore, the fillers prevent clogging of the discs and ensure a cool cut. The "medium" and "hard" abrasive disc holders are particularly well suited.

	Dimensions	Grit size	Rotation speed max.	Packing quantity	Order No.	Price from	
						1 pack	4 packs
<b>Abrasive discs COMBIDISC® ceramic grit CO-COOL</b>							
	Ø 38 mm	36	16,000 rpm	25 pieces	<b>0 541 091</b>		
		60	16,000 rpm	25 pieces	<b>0 541 092</b>		
		80	16,000 rpm	25 pieces	<b>0 541 093</b>		
		120	16,000 rpm	25 pieces	<b>0 541 094</b>		
	Ø 50 mm	36	13,000 rpm	25 pieces	<b>0 541 096</b>		
		60	13,000 rpm	25 pieces	<b>0 541 097</b>		
		80	13,000 rpm	25 pieces	<b>0 541 098</b>		
		120	13,000 rpm	25 pieces	<b>0 541 099</b>		

## Grinding and polishing discs COMBIDISC® Felt rounds

For frontal polishing with diamond, grinding and polishing pastes on larger surfaces. Optionally, the holders can be used "soft" or "medium".

	Dimensions	Recommended speed	Rotation speed max.	Packing quantity	Order No.	Price from	
						1 pack	4 packs
<b>Felt rounds COMBIDISC®</b>							
	Ø 50 mm	4,000 rpm	4,000 rpm	5 pieces	<b>0 541 150</b>		
	Ø 75 mm	2,500 rpm	2,500 rpm	10 pieces	<b>0 541 151</b>		-


## Grinding and polishing discs COMBIDISC® Holders

	Dimensions	Design	Shank dimensions	Rotation speed max.	Order No.	Price from
						1 piece
<b>Grinding and polishing disc holders COMBIDISC®</b>						
	Ø 20 mm	medium	Ø 3 x 27 mm	12,000 rpm	<b>0 541 012</b>	
		medium	Ø 6 x 40 mm	47,500 rpm	<b>0 541 001</b>	
	Soft abrasive disc holder	Ø 25 mm	medium	Ø 3 x 27 mm	12,000 rpm	<b>0 541 013</b>
	Ø 25 mm	medium	Ø 6 x 40 mm	38,000 rpm	<b>0 541 002</b>	
		Ø 38 mm	hard	Ø 6 x 40 mm	25,000 rpm	<b>0 541 003</b>
	Medium abrasive disc holder	Ø 38 mm	medium	Ø 6 x 40 mm	25,000 rpm	<b>0 541 004</b>
	Ø 50 mm	soft	Ø 6 x 40 mm	25,000 rpm	<b>0 541 005</b>	
		Ø 50 mm	hard	Ø 6 x 40 mm	19,000 rpm	<b>0 541 006</b>
	Hard abrasive disc holder	Ø 50 mm	medium	Ø 6 x 40 mm	19,000 rpm	<b>0 541 007</b>
		soft	Ø 6 x 40 mm	19,000 rpm	<b>0 541 008</b>	



## 2 Abrasive paper Silicon carbide

The well-known wet abrasive paper. Owing to the very fine grit size, suitable up to the polishing stage. Use wet and dry on all steels and nonferrous metals. An insider's tip for aluminium!

	Dimensions	Grit size	Type	Packing quantity	Order No.	Price from	
						1 pack	5 packs
<b>Silicon carbide abrasive paper</b>							
	230 x 280 mm	150	991 C	50 pieces	<b>0 401 379</b>		
		180	991 C	50 pieces	<b>0 401 380</b>		
		220	991 C	50 pieces	<b>0 401 381</b>		
		240	991 C	50 pieces	<b>0 401 382</b>		
		320	991 C	50 pieces	<b>0 401 384</b>		
		400	991 C	50 pieces	<b>0 401 386</b>		
		500	991 C	50 pieces	<b>0 401 387</b>		
		600	991 C	50 pieces	<b>0 401 388</b>		
		800	991 C	50 pieces	<b>0 401 389</b>		
		1000	991 C	50 pieces	<b>0 401 390</b>		
		1200	991 C	50 pieces	<b>0 401 391</b>		
		1200	991 A	50 pieces	<b>0 401 373</b>		
		2000	991 A	50 pieces	<b>0 401 392</b>		
		2500	991 A	50 pieces	<b>0 401 393</b>		
		3000	991 A	50 pieces	<b>0 401 394</b>		
		5000	991 A	50 pieces	<b>0 401 395</b>		
		1500	991 A	50 pieces	<b>0 401 397</b>		
7000	991 A	50 pieces	<b>0 401 399</b>				



Use with or without coolant/lubricant!



### Difference between A and C grades?








The A and C grade wet abrasive papers differ in the specific weight of the base:

- A ≤ 115 g/m<sup>2</sup>
- C > 115 g/m<sup>2</sup>



# Mikro-Finishing-Abrasive Paper 3M® Corundum


This microfinishing 3M® emery paper, consisting of a polyester film backing, is characterised by densely dispersed, closely calibrated corundum grit in a synthetic resin bond. This results in very fine surfaces on all metals and even on plastics.

	Dimensions	Grit size	Colour	Packing quantity	Order No.	Price from		
						1 piece	10 pieces	50 pieces
<b>Mikro-Finishing-Abrasive Paper 3M®</b>								
	216 x 280 mm	180 / 80 µm	brown	5 pieces	<b>0 530 708</b>			
		220 / 60 µm	black	5 pieces	<b>0 530 709</b>			
		320 / 40 µm	blue	5 pieces	<b>0 530 710</b>			
		400 / 30 µm	green	5 pieces	<b>0 530 711</b>			
		500 / 20 µm	red	5 pieces	<b>0 530 712</b>			
		800 / 15 µm	orange	5 pieces	<b>0 530 713</b>			
		1200 / 9 µm	light blue	5 pieces	<b>0 530 714</b>			



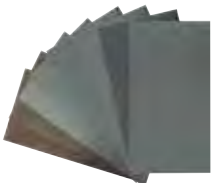
## 2 Padded abrasive cloth MX

The somewhat different kind of abrasive. The grinding crystals are accommodated in an elastic latex layer on a fabric base. The crystals move flexibly during grinding and always optimally align themselves in relation to the surface; the stock removal level constantly remains even. The result is a completely smooth surface on almost all materials: metal, plastics, glass, wood, lacquer or stone. Practically all smooth surfaces can be superfine ground. In doing so, it is possible to work with a considerably coarser grit size than usual and markedly finer surfaces result all the same. Comparatively large grinding crystals and the flexible carrier material prevent scratches on the workpiece, since no adherence of the grinding crystals occurs as a result of dust particle accumulation.

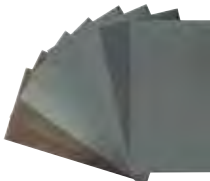
 Grit size MX	Comparable to FEPA
180	> P 360
240	P 800
320	> P 1500
360	P 2000
400	P 2500
600	> P 3000
800	P 5000
1200	> P 5000



Use with or without  
coolant/lubricant!


Dimensions	Grit size	Order No.	Price from 1 piece
<b>Padded abrasive cloth MX</b>			
 150 x 305 mm	180	<b>0 401 651</b>	
	240	<b>0 401 652</b>	
	320	<b>0 401 653</b>	
	360	<b>0 401 654</b>	
	400	<b>0 401 655</b>	
	600	<b>0 401 656</b>	
	800	<b>0 401 657</b>	
	1200	<b>0 401 658</b>	

### matching set


Set of padded abrasive cloth MX	Order No.	Price from 1 set
 One sheet per grit size respectively.	<b>0 401 650</b>	

#### What advantages does the "padded abrasive cloth" offer?

- up to 15 x service life
- a markedly finer polished section than with conventional abrasives
- grit size 400 corresponds to the surface roughness of grit size P 2500 in spite of the high stock removal
- delayed friction and consequently less heat generation
- large crystals
- no built-up edges

 Do you need MX on the roll, as rounds or in different sheet dimensions, then please contact Markus Abstoss:  
Tel. +49 22 04 839-0 • [m.abstoss@joke.de](mailto:m.abstoss@joke.de)


## Abrasive strips ROTAFLEX Corundum, self-adhesive

Dimensions	Grit size	Packing quantity	Order No.	Price from	
				1 pack	10 packs
<b>Abrasive strips ROTAFLEX, corundum, self-adhesive</b>					
 7 x 580 mm	60	10 pieces	0 401 302		
	80	10 pieces	0 401 303		
	120	10 pieces	0 401 304		
	150	10 pieces	0 401 305		
	180	10 pieces	0 401 306		
	240	10 pieces	0 401 307		
	320	10 pieces	0 401 308		
	400	10 pieces	0 401 309		
	600	10 pieces	0 401 310		
	 10 x 580 mm	80	10 pieces	0 401 333	
120		10 pieces	0 401 334		
150		10 pieces	0 401 335		
180		10 pieces	0 401 336		
240		10 pieces	0 401 337		
320		10 pieces	0 401 338		
400		10 pieces	0 401 339		
600		10 pieces	0 401 340		



Use with or without coolant/lubricant!

## Abrasive sheets Corundum, self-adhesive

Dimensions	Grit size	Order No.	Price from	
			1 piece	10 pieces
<b>Abrasive sheets ROTAFLEX, corundum, self-adhesive</b>				
 210 x 580 mm	60	0 401 312		
	150	0 401 315		
	180	0 401 316		
	240	0 401 317		
	600	0 401 320		
	 250 x 580 mm	60	0 401 322	
80		0 401 323		
120		0 401 324		
150		0 401 325		
180		0 401 326		
240		0 401 327		
320		0 401 328		
400		0 401 329		
600		0 401 330		



Use with or without coolant/lubricant!

## 2 Felt pads ROTAFLEX

Why should this idea of the small self-adhesive pads be restricted to grinding! We also offer a self-adhesive polishing felt in the same shape:

Dimensions	Packing quantity	Order No.	Price from		
			1 pack	5 packs	10 packs
<b>Felt tips ROTAFLEX, self-adhesive</b>					
20 x 10 mm	50 pieces	<b>0 530 604</b>			






Great idea, excellent product: These small abrasive pads are simply attached to one of the available holders to create a universal precision tool, which can be used manually or with hand-filing machines. There is a choice of three holders: Two with a fixed and one with a 180° swivel shank.

Dimensions	Grit size	Packing quantity	Order No.	Price from		
				1 pack	5 packs	10 packs
<b>Abrasive Pads, self-adhesive</b>						
<b>Corundum</b>						
20 x 10 mm	180	100 pieces	<b>0 530 605</b>			
20 x 10 mm	240	100 pieces	<b>0 530 606</b>			
20 x 10 mm	280	100 pieces	<b>0 530 607</b>			
20 x 10 mm	320	100 pieces	<b>0 530 608</b>			
20 x 10 mm	400	100 pieces	<b>0 530 609</b>			
20 x 10 mm	600	100 pieces	<b>0 530 610</b>			
20 x 10 mm	800	100 pieces	<b>0 530 611</b>			
20 x 10 mm	1000	100 pieces	<b>0 530 612</b>			
20 x 10 mm	1200	100 pieces	<b>0 530 613</b>			



### Accessories / spare parts

	Order No.	Price from		
		1 piece	5 pieces	10 pieces
<b>Abrasive pad holder, 180° pivotable</b>				
 shank diameter x total length 3 x 85 mm	<b>0 530 601</b>			
<b>Abrasive pad holder</b>				
 shank diameter x total length 3 x 65 mm	<b>0 530 602</b>			
 shank diameter x total length 3 x 40 mm	<b>0 530 603</b>			



Grit size	comparable to
<b>Fleece</b>	<b>FEPA</b>
coarse	K 40 - 80
medium	K 100 - 180
fine	K 220 - 240
very fine	K 280 - 360
super-fine	K 400 - 600
ultra-fine	K 800 - 1500






Use with or without coolant/lubricant!

## Grinding fleece pads and rolls


2

Elastic material made from unwoven nylon fibres, within which the abrasive grain is uniformly distributed. The joke grinding fleece adapts to any surface and therefore allows consistent working results throughout its entire service life. This grinding fleece is ideal for fine grinding, cleaning, and elimination of corrosion and for very fine deburring. Can be used dry or with water, fluid or oil.

Dimensions	Grit size	Design	Order No.	Price from		
				1 piece	3 pieces	5 pieces
<b>Grinding fleece – rolls and pads</b>						
 115 mm x 10 m	100 - 180 / medium	Roll – corundum	<b>0 401 430-0</b>			
	220 - 240 / fine	Roll – corundum	<b>0 401 431-0</b>			
	280 - 360 / very fine	Roll – corundum	<b>0 401 432-0</b>			
	280 - 360 / very fine	Roll – silicon carbide	<b>0 401 433-0</b>			
	400 - 600 / superfine	Roll – silicon carbide	<b>0 401 434-0</b>			
	800 - 1500 / ultrafine	Roll – silicon carbide	<b>0 401 435-0</b>			
229 x 152 mm	320 - 360 / very fine	Pad – corundum	<b>0 401 436</b>			-
	500 - 600 / superfine	Pad – silicon carbide	<b>0 401 437</b>			-

## pads and rolls

**NEW!**

Dimensions	Grit size	Packing quantity	Order No.	Price from		
				1 pack	5 packs	10 packs
<b>Grinding fleece – rolls and pads</b>						
<b>Pad – corundum</b>						
 229 x 152 mm	without grit	10 pieces	<b>0 401 477</b>			
	100 - 180 / medium	10 pieces	<b>0 543 898</b>			


## Abrasive cloth sheets Premium Corundum

One of the best abrasive cloths in the world – now available in sheet and roll form! The material can be torn to the desired length very easily and cleanly and is highly flexible, yet still has high edge stability.



### What is elutriated grit application?

With the elutriated material, the abrasive is „painted“ on to the base in a „sludge“ consisting of binder and grinding grit. This results in a very fine and uniform emery surface, which is ideally suited for prepolishing.


Dimensions	Grit size	Packing quantity	Order No.	Price from		
				1 pack	3 packs	5 packs
<b>Abrasive cloth sheets Premium VSM, KK 114 F, corundum</b>						
 230 x 280 mm	999 rouge	50 pieces	<b>0 530 630</b>			
	444 silver	50 pieces	<b>0 530 629</b>			
	400	50 pieces	<b>0 530 628</b>			
	360	50 pieces	<b>0 530 627</b>			
	320	50 pieces	<b>0 530 626</b>			
	280	50 pieces	<b>0 530 625</b>			
	240	50 pieces	<b>0 530 624</b>			
	220	50 pieces	<b>0 530 623</b>			
	180	50 pieces	<b>0 530 622</b>			
	150	50 pieces	<b>0 530 621</b>			
	120	50 pieces	<b>0 530 620</b>			
	100	50 pieces	<b>0 530 619</b>			
	80	50 pieces	<b>0 530 618</b>			





## 2 Economy abrasive cloth rolls Premium Corundum

Premium abrasive cloth delivered – on 50 m rolls. Likewise very flexible, yet with high edge stability and easy to tear to the desired size.

Width	Grit size	Design	Order No.	Price from		
				1 piece	3 pieces	5 pieces
<b>Premium economy abrasive cloth roll, 50 m, VSM, KK 114 F and KK 511 F</b>						
 25 mm	80	KK 114 F	<b>0 543 851</b>			
	120	KK 114 F	<b>0 543 847</b>			
	150	KK 114 F	<b>0 543 852</b>			
	180	KK 114 F	<b>0 543 853</b>			
	240	KK 114 F	<b>0 543 854</b>			
	320	KK 114 F	<b>0 543 855</b>			
	400	KK 114 F	<b>0 543 856</b>			
	600	KK 511 F	<b>0 543 858</b>			
	800	KK 511 F	<b>0 543 859</b>			
40 mm	80	KK 114 F	<b>0 543 861</b>			
	120	KK 114 F	<b>0 543 848</b>			
	150	KK 114 F	<b>0 543 862</b>			
	180	KK 114 F	<b>0 543 863</b>			
	240	KK 114 F	<b>0 543 864</b>			
	320	KK 114 F	<b>0 543 865</b>			
	400	KK 114 F	<b>0 543 866</b>			
	600	KK 511 F	<b>0 543 868</b>			
	800	KK 511 F	<b>0 543 869</b>			
50 mm	60	KK 114 F	<b>0 543 870</b>			
	80	KK 114 F	<b>0 543 871</b>			
	120	KK 114 F	<b>0 543 849</b>			
	150	KK 114 F	<b>0 543 872</b>			
	180	KK 114 F	<b>0 543 873</b>			
	240	KK 114 F	<b>0 543 874</b>			
	320	KK 114 F	<b>0 543 875</b>			
	400	KK 114 F	<b>0 543 876</b>			
	500	KK 511 F	<b>0 543 877</b>			
	600	KK 511 F	<b>0 543 878</b>			
800	KK 511 F	<b>0 543 879</b>				




Use with or without coolant/lubricant!



**Practical:**  
The grit sizes 60 to 400 are supplied in a cardboard dispenser with a cutting edge.







## Economy abrasive cloth rolls Standard Corundum

Suitable for removing milling, turning and erosion structures. Good as preparation before processing with grinding stones and diamond compound.

	Width	Grit size	Order No.	Price from	
				1 piece	3 pieces
<b>Standard economy abrasive cloth rolls, Starcke 641 PF, corundum, 50 m</b>					
	25 mm	80	0 401 403-1		
		150	0 401 405-1		
		180	0 401 406-1		
		240	0 401 407-1		
		320	0 401 408-1		
		400	0 401 409-1		
	50 mm	80	0 401 413		
		120	0 401 414		
		150	0 401 415		
		180	0 401 416		
		240	0 401 417		
		320	0 401 418		
		400	0 401 419		

## Abrasive band holder for Microgrinding strips and Poly-Strip

For processing narrow edges and tight slots with the Poly-Strip grinding strips. Use by hand and also in hand-filing machines.

	Dimensions	Shank dimensions	Order No.	Price from
				1 piece
<b>Holder for Poly-Strip abrasive strips</b>				
	6 x 1 x 26 mm	Ø 3.5 x 50 mm	0 401 551	
	10 x 1 x 26 mm	Ø 3.5 x 50 mm	0 401 552	
	15 x 1 x 26 mm	Ø 3.5 x 50 mm	0 401 553	
	6 x 1 x 50 mm	Ø 3.5 x 50 mm	0 401 556	
	10 x 1 x 50 mm	Ø 3.5 x 50 mm	0 401 557	
	15 x 1 x 50 mm	Ø 3.5 x 50 mm	0 401 558	

 *matching set*

	Order No.	Price from
		1 set
<b>Poly-Strip abrasive strip holder set 2</b>		
contains one Poly-Strip abrasive strip holder in 50 mm length each	0 401 555	



## 2 Abrasive bands Poly-Strip


### Poly-Strip abrasive strips

This tried and trusted system always provides the right abrasive strip in the desired width and grit size. Simply pull out the required length and tear – hey presto! A tear-off edge dispenses with tedious cutting with scissors. As soon as the end of a strip is reached, the new abrasive strip can be easily inserted in the cartridge.

	Order No.	Price from 1 piece
<b>Poly-Strip abrasive strips, cassette of 6</b>		
containing 1 abrasive strip roll each 15 mm, roll length 25 m in grit size 150, 180, 240, 320, 400, 600	<b>0 401 501</b>	



### Accessories / spare parts

	Width	Grit size	Order No.	Price from 1 piece
<b>Spare Poly-Strip abrasive strip roll, 25 m</b>				
	6 mm	150	<b>0 401 511</b>	
	6 mm	180	<b>0 401 512</b>	
	6 mm	240	<b>0 401 513</b>	
	6 mm	320	<b>0 401 514</b>	
	6 mm	400	<b>0 401 515</b>	
	6 mm	600	<b>0 401 516</b>	
	6 mm	800	<b>0 401 517</b>	
	6 mm	1000	<b>0 401 518</b>	
	6 mm	1200	<b>0 401 519</b>	
	10 mm	150	<b>0 401 521</b>	
	10 mm	180	<b>0 401 522</b>	
	10 mm	240	<b>0 401 523</b>	
	10 mm	320	<b>0 401 524</b>	
	10 mm	400	<b>0 401 525</b>	
	10 mm	600	<b>0 401 526</b>	
	10 mm	800	<b>0 401 527</b>	
	10 mm	1000	<b>0 401 528</b>	
	10 mm	1200	<b>0 401 529</b>	
15 mm	150	<b>0 401 531</b>		
15 mm	180	<b>0 401 532</b>		
15 mm	240	<b>0 401 533</b>		
15 mm	320	<b>0 401 534</b>		
15 mm	400	<b>0 401 535</b>		
15 mm	600	<b>0 401 536</b>		

# Abrasive bands and Gesswein®-Holder

These abrasive bands and their holders are a must for every professional workplace. They are tightened by means of the built-in spring and offer absolutely secure adhesion to the holder. The holder itself is made from impact-proof polypropylene and is therefore suitable even for the toughest of applications.

Dimensions	Grit size	Packing quantity	Order No.	Price from 1 pack
<b>Abrasive bands for Gesswein®-Holder</b>				
7 x 330 mm	120	10 pieces	<b>0 401 460</b>	
	240	10 pieces	<b>0 401 461</b>	
	320	10 pieces	<b>0 401 462</b>	
	400	10 pieces	<b>0 401 463</b>	
	600	10 pieces	<b>0 401 464</b>	
13 x 420 mm	120	10 pieces	<b>0 401 465</b>	
	240	10 pieces	<b>0 401 466</b>	
	320	10 pieces	<b>0 401 467</b>	
	400	10 pieces	<b>0 401 426</b>	
	600	10 pieces	<b>0 401 428</b>	
19 x 508 mm	120	10 pieces	<b>0 401 468</b>	
	240	10 pieces	<b>0 401 469</b>	
	320	10 pieces	<b>0 401 470</b>	
	400	10 pieces	<b>0 401 427</b>	
	600	10 pieces	<b>0 401 429</b>	



**i No mix-ups possible**  
 In order to avoid mix-ups, we recommend a separate holder colour for each grit size.

For example:

<b>K 120</b>	<b>Red</b>
<b>K 240</b>	<b>Blue</b>
<b>K 320</b>	<b>Green</b>
<b>K 400</b>	<b>Yellow</b>
<b>K 600</b>	<b>Black</b>

**Accessories / spare parts**









Dimensions	Colour	Order No.	Price from 1 piece
<b>Abrasive band holder</b>			
7 mm	red	<b>0 401 439</b>	
	blue	<b>0 401 440</b>	
	green	<b>0 401 441</b>	
	yellow	<b>0 401 442</b>	
	black	<b>0 401 443</b>	
13 mm	red	<b>0 401 444</b>	
	blue	<b>0 401 445</b>	
	green	<b>0 401 446</b>	
	yellow	<b>0 401 422</b>	
	black	<b>0 401 423</b>	
19 mm	red	<b>0 401 447</b>	
	blue	<b>0 401 448</b>	
	green	<b>0 401 449</b>	
	yellow	<b>0 401 424</b>	
	black	<b>0 401 425</b>	




## 2 Micro grinding strip holders and strips

The microfinishing grinding strip holders and strips are the ideal tool for use in the metal, wood and jewellery industries as well as in all areas of very fine finishing. The holder has 3 geometrically different working areas (surface, tip, radius), which make it the ideal tool for finishing.

The integrated spring ensures good pretensioning and easy changing of the strips. The individual holders are supplied with a microgrinding strip; spare strips in 8 different grit sizes in packs of 10 pieces each; 3 different sets are also available.




	Dimensions	Grit size	Colour	Order No.	Price from 1 piece
<b>Micro grinding strip holders and grinding strips, 160 x 6 mm</b>					
	160 x 6 mm	220 / 60 µm	black	<b>0 415 000</b>	
		270 / 50 µm	grey	<b>0 415 001</b>	
		320 / 40 µm	red	<b>0 415 002</b>	
		400 / 30 µm	green	<b>0 415 003</b>	
		600 / 15 µm	orange	<b>0 415 004</b>	
		800 / 14 µm	yellow	<b>0 415 005</b>	
		1000 / 12 µm	white	<b>0 415 006</b>	
		1200 / 9 µm	blue	<b>0 415 007</b>	

### Accessories / spare parts

	Grit size	Packing quantity	Order No.	Price from		
				1 pack	3 packs	5 packs
<b>Micro replacement grinding strips</b>						
	220 / 60 µm	10 pieces	<b>0 415 010</b>			
	270 / 50 µm	10 pieces	<b>0 415 011</b>			
	320 / 40 µm	10 pieces	<b>0 415 012</b>			
	400 / 30 µm	10 pieces	<b>0 415 013</b>			
	600 / 15 µm	10 pieces	<b>0 415 014</b>			
	800 / 14 µm	10 pieces	<b>0 415 015</b>			
	1000 / 12 µm	10 pieces	<b>0 415 016</b>			
	1200 / 9 µm	10 pieces	<b>0 415 017</b>			

## Micro grinding strip holders and strips

↓ matching set

	Order No.	Price from		
		1 set	3 set	5 set
<b>Micro grinding strip holders and strips</b>				
	Content: 24-piece, 4 holders incl. grinding strip (grit size 220, 270, 320, 400), 16 replacement strips (4 x grit size 220, 270.320, 400 each)	<b>0 415 020</b>		
	Content: 24-piece, 4 holders incl. grinding strip (grit size 600, 800, 1000, 1200), 16 replacement strips (4 x grit size 600, 800, 1000, 1200 each)	<b>0 415 021</b>		
	Content: 8 holders incl. grinding strip (grit size 220, 270, 320, 400, 600, 800, 1000, 1200)	<b>0 415 022</b>		





## 2 Diamond tools for ultrasonic processing galvanic bonding

### Diamond tools, galvanic bonding

These tools are particularly suitable for removing the hard layers caused by erosion machines, for deburring, polishing and lapping and optimally for finishing hard-to-reach corners, slits and joints. By adapting toolholders suitable for all commercial ultrasonic, lapping and polishing systems.

	Coating dimensions	Length	Grit size	Thread	Order No.	Price from 1 piece
<b>Diamond tools for ultrasonic processing, galvanic bonding</b>						
<b>flat</b>						
	4 x 1 x 15 mm	44 mm	200	M6/fine	<b>0 006 450</b>	
		44 mm	320	M6/fine	<b>0 006 451</b>	
	44 mm	600	M6/fine	<b>0 006 452</b>		
	37 mm	200	M4	<b>0 405 782</b>		
	37 mm	320	M4	<b>0 405 794</b>		
	37 mm	600	M4	<b>0 405 795</b>		
	5 x 1 x 40 mm	137 mm	320	M6/fine	<b>0 006 454</b>	
<b>flat / conical</b>						
	4 x 0.4/0.8 x 15 mm	44 mm	200	M4	<b>0 405 783</b>	
		44 mm	320	M4	<b>0 405 815</b>	
		50 mm	200	M6/fine	<b>0 006 456</b>	
		50 mm	320	M6/fine	<b>0 006 457</b>	
		50 mm	600	M6/fine	<b>0 006 458</b>	
<b>round/pointed</b>						
	∅ 3 x 15 mm	34 mm	200	M4	<b>0 405 786</b>	
		34 mm	320	M4	<b>0 405 787</b>	

## Diamond tools for ultrasonic processing Metal bonding – sintered

	Coating dimensions	Length	Grit size	Thread	Order No.	Price from 1 piece
<b>Diamond tools for ultrasonic processing, metal bonding – sintered</b>						
<b>flat</b>						
	3 x 1 x 10 mm	41 mm	200	M4	<b>0 405 839</b>	
		41 mm	320	M4	<b>0 405 840</b>	
	5 x 1 x 10 mm	41 mm	200	M4	<b>0 405 847</b>	
		41 mm	320	M4	<b>0 405 848</b>	
	6 x 1.5 x 25 mm	34 mm	200	M4	<b>0 405 796</b>	
		34 mm	320	M4	<b>0 405 797</b>	

# Rubinsteine 2

### Ruby stones

Using our tried and trusted joke FD ruby stones on page 237, you can easily build yourself an ultrasonic tool for very fine deburring work.

In order to do this, simply cut the stones to your desired dimensions and clamp them in the appropriate tool holder (see page 14).



Ruby stones allow you very "soft" work, but nevertheless create sharp edges. Shaping is very readily possible using diamond tools.



**i** You can find the components here:

- Ruby stones joke FD page 237
- Tool holder page 14

## Wooden and brass polishing sticks

	Material	Shape	Dimensions	Packing quantity	Order No.	Price from 1 pack
<b>Wooden and brass polishing sticks</b>						
	hard beech wood	round / cylinder	Ø 3 x 40 mm	10 pieces	<b>0 006 611</b>	
	brass	round / cylinder	Ø 3 x 40 mm	5 pieces	<b>0 006 614</b>	