





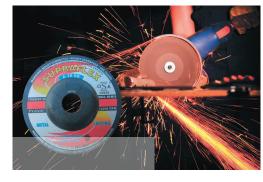
### **CUTTING DISCS**

### **TYPICAL APPLICATION**

- Notching
- Sheet metal cutting
- Pipe cutting
- Foundry Gate / Riser removal
- Metal plate dimensioning
- Bar cutting
- Sample cutting
- Rail cutting

#### **FEATURES**

- Reinforced cut-off wheels
- Non reinforced cut-off wheels
- OSA Certification.



#### **BENEFITS**

 Designed to resist breakage caused by severe cross-bending. A reinforced wheel is required on any operation where the work is not securely clamped

SIZES - 4", 4.5", 5", 7", 9", 12", 14", 16"

- Designed for use on "fixed base" types of machines where the work is securely clamped, guarded and where the wheel operates on a controlled cutting plane

### **GRINDING DISCS**

## TYPICAL APPLICATION

- Chemical & process grinders
- Pipe manufacturing industry
- Grill manufaturing industry
- Dairy industry
- Storage tank fabrication
- Plate/angle iron fabrication
- Petrochemical maintenance
- All weld grinding
- Ship building

- Foundry gates and risers
- Pipeline notching and bevelling
- Removal of irregularities on steel rolled flats.

#### **FEATURES**

- Unique product segmentation
- Tested against stringent safety
- OSA certification



#### **BENEFITS**

- Products available to suit every imaginable customer segment
- The safest product in an application where a faulty wheel can be fatal
- OSA certified products adhering to European safety standards.

**SIZES -** 4", 4.5", 5",,7", 9", 12", 14", 16"



# **Technical Data Sheet**

SUPRAFLEX Cutting Discs and Grinding discs are pre-engineered to produce the most versatile wheel performance. They are engineered to give you optimum to premium performance in all cutting and grinding applications ranging from production to maintenance in various types of steels.

Туре	Product	Product Specification	Grain	Grit	Bond	Grade	Product Validity	Standards Adhered to
27	SUPRAFLEX Grinding Disc	A24SB	ALO	24	B ( Generic)	S	3Yrs from the date of manufacturing	OSA (10556), EN12413
27	SUPRAFLEX Cutting Disc	A30SB	ALO	30	B(Generic)	S	3Yrs from the date of manufacturing	OSA (10556), EN12413
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Standard	Type of machine	T R A	DING L. Diameter	L . C . Mos	Burst speed factor
EN12413	Stationary	Cutting of wheels	All diameter	<=80	1.87
EN12413	Mobile machines	All types	All diameter	<=100	1.87
EN12413	Hand held machines	Grinding wheels	>125	<=50	1.73
EN12413	Hand held machines	Grinding wheels	>125	50< MOS <=80	1.87
EN12413	Hand held machines	Cutting of wheels	>125	<=100	1.87
EN12413	Hand held machines	All types	<=125	<=80	1.73
EN12413	Hand held machines	All types	<=125	>80	1.87



### Standard Adhere to:

EN12413 -: Recommendations for thin wheels usage, inspection, safety tests.

- Defines: Max operating Speed, Burst Speed Factor of wheel according to size and type, Side load capacity of Wheel.

OSA -: Defines product safety standards according to EN12413 for Grinding and Cutting Disc.

Manufacturer must comply with these standards to be eligible to use OSA mark.

# **Product Availability:**

Cutting Disc (3mm Thickness) - Diameter 100, 115, 125, 180,230 - in type 01 and Type 27

Large Diameter cutting disc (3mm thickness) – type 01 – diameter 300, 355 & 400mm.

Grinding Disc (6mm Thickness) – Diameter 100, 115, 125, 180, 230

Ultrathin Wheels (type 01) – diameter 100, 115, 125, 180 & 230 in 1, 1.2, 1.6 & 2 mm thickness.

**Product Specification available**: For Metal and Stainless steel.

Typical applications				
GRINDING	CUTTING			
Notching TRA	Chemical & Process Grinders			
Sheet metal cutting	Pipe Manufacturing Industry			
Pipe cutting (Cast Iron / Stainless Steel / Mild Steel)	Grill Manufacturing Industry			
Mild Steel)	Dairy Industry			
Foundry Gate / Riser removal	Storage tank fabrication			
Metal plate dimensioning	Plate / Angle iron fabrication			
Bar cutting	Petrochemical maintenance			
Sample cutting	All weld grinding			
Rail cutting	Ship building			
	Foundry gates and risers			
	Pipeline notching and beveling			
	Removal of irregularities on steel rolled flats			



TROUBLESHOOTING GUIDE					
Problem Possible Causes		Suggested Correction			
Poor cutting rate	Insufficient power used	Increase feed or pressure to full power			
	Wheel thickness may be more	Use thinner oil			
	Contact are too large	Reduce contact area			
Poor quality of cut	Wheel side out of truth	Check spindle runout			
	Non-square cuts	See "non-square cuts"			
	Workplace burn	See "non-square cuts"			
	Wheel too coarse	Use finer wheel			
Non-square cuts	Work not clamped well	Check clamp			
	Misaligned spindle bearing	Check bearing truth and alignment			
Work piece burn	Insufficient feed rate	Work machine to maximum power			
	Wheel too hard	Use softer wheel			
	Wheel too coarse	Use finer wheel			
	Wheel running out	Check spindle			
	Wheel speed too slow	Ensure no wheel slippage			





- Match RPM of wheel with Machine RPM before mounting the wheel.
- ➤ Use Grinding Discs at an angle of at least 30 degrees to the work piece.
- Do not use grinding disc for flat grinding.
- ➤ Right work position 90º regarding to the piece for wheel Thickness from 0.8 up to 4.0mm
- Use the disc in an appropriate machine
- > Do not exceed the maximum operation speed marked on the wheel label
- > Depressed center discs of diameter of 100-230 mm should be mounted with flanges of a diameter of 39-42 mm
- > Do not alter the bore of the disc; do not force it into the spindle and ensure that there is not excessive play between the two.
- ➤ Wheels should be exposed at max angle of 180° on portable machine and max angle of 180° on fixed machine.
- Use only machines with Safety Guards
- Always use personal Safety Equipments.