

**GRINDWELL**  
**SUPRAFLEX**



EN 12413



## 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

- 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
- OSA certified products adhering to European safety standards.

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

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27 Grindwell

## GRINDING DISCS

### TYPICAL APPLICATION

- Chemical & process grinders
- Pipe manufacturing industry
- Grill manufacturing 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.***

Type	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

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



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#### Handling & Usage:

- 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 - 90° 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.