



204F

204F

Coated Abrasives



PFERD-Products



Short and long belts



Self-adhesive discs



Sanding paper



Economy rolls



Coated abrasives from PFERD have the following characteristics:

- High stock removal rate
- Long service life
- Minimal stretching (with Belts)
- Low temperature grinding
- Oil- and waterproof (not all series)
- Consistent grinding performance
- Deburring
- Removing welded seams
- Circular grinding (centreless)
- Surface finishing
- Surface cleaning
- Flat grinding
- Profile grinding
- Production machine/robot grinding

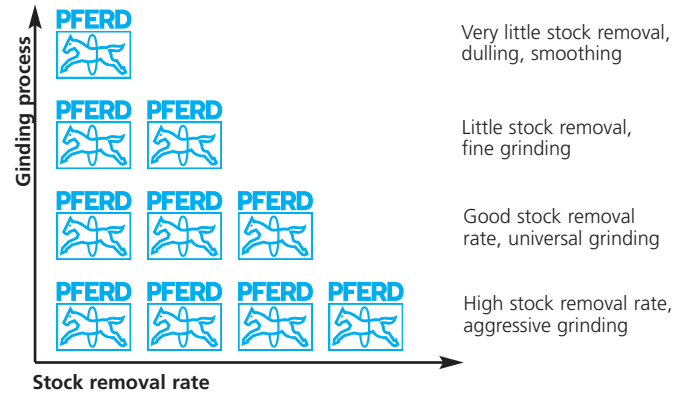
Examples of applications:

Coated Abrasives



Stock removal performance / Grinding Process

The number of PFERDS shows the relationship between stock removal and the grinding process. The stock removal rate is dependent on the grit size in each work step. Larger grit is rated with a high number of PFERDS as it has a higher stock removal rate.



Material colour code

Steel / Sheetting		Plastic	
Stainless		Wood	
Alu / Non-ferrous metals		Stone	
Casting		Rubber	
Titanium / Cast Alu		Glass	
High-grade steel casting		Paint	

Coated Abrasives



Grit scale according to FEPA

The FEPA-Standard stipulates the values for the grit classification (Association European Abrasive Material Producers)

Coarse

P	80	60	50	40	36	30	24	20	16
---	----	----	----	----	----	----	----	----	----

Medium

P	280	240	220	180	150	120	100
---	-----	-----	-----	-----	-----	-----	-----

Fine

P	600	500	400	360	320
---	-----	-----	-----	-----	-----

Super fine

P	1200	1000	999	800
---	------	------	-----	-----

Support backing

PFERD distinguishes between:

- Cloth
- Paper

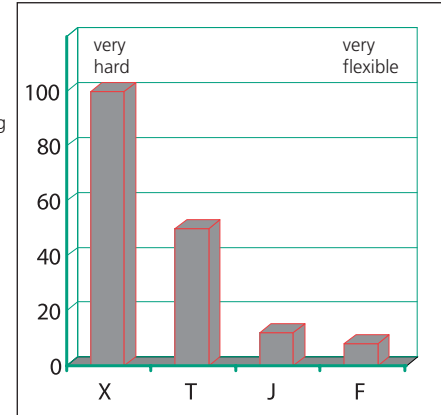
Coated Abrasives



Properties of the support backing

Cloth backed:

- F** = Very flexible
- J** = Flexible
- K** = Self-adhesive backing
- T** = Hard
- X** = Very hard



You can find further information and order specifications in the PFERD brochure "Coated Abrasives". You can find the PFERD-Fibre Discs in catalogue 206 Grinding and Cut-off Wheels (page 20).

Drives

The following pictograms have been used in this pocket guide:

Handwork

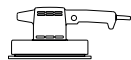


Machine application hand guided machines

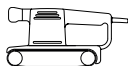
Electrical angle grinder



Eccentric grinder



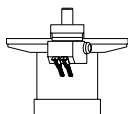
Belt grinder



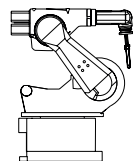
Machine application hand texturing



Machine application automatic texturing



Machine application robot texturing



General protection measures

Pictograms from the FEPA-safety recommendations are indications for the correct use of abrasive materials. Adherence to the recommendations guarantees personal safety and permits the proper performance of the abrasive material.



= Wear protective eyewear!



= Wear ear protection!



= Wear protective gloves!



= Wear dust respirator!



= Observe safety recommendations!



= Not approved for free-hand and hand-held operation!



= Not approved for wet grinding!

















= Not approved for side grinding!

Coated Abrasives

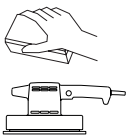



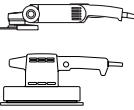





Coated Abrasives



Tool drive	Tool measurement mm x mm	Model Grit type/-series	Material	Stock removal performance	Application	Backing properties	
	Sheet 230 x 280	BG brown (Aluminium oxide) 40 - 999			Light work, deburring, cleaning, profile grinding	Cloth, very flexible (F)	
	Sheet 230 x 280	BG blue (Aluminium oxide) 40 - 400			Light work, deburring, cleaning, profile grinding	Cloth, very flexible (F)	
	Sheet 230 x 280	BP w (Silicon carbide) 100 - 1200			Light work, deburring, cleaning, profile grinding, surface grinding, wet and dry grinding	Paper 70 g/m ² , 120 g/m ² waterproof	
	Abrasive band rolls 25 x 50 m 38 x 50 m 40 x 50 m 50 x 50 m 95 x 25 m 100 x 50 m 110 x 50 m 115 x 25 m	SBR (Aluminium oxide) 36 - 800			Light work, deburring, cleaning, profile grinding	Cloth, very flexible (F)	



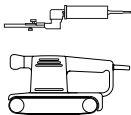






Drive	Tool measurements mm x mm	Model Grit type/-series	Material	Stock removal performance	Application	Backing properties	
	Fleece band rolls 100 x 10 m	VBR (Aluminium oxide) 100, 180, 280			Light work, deburring, cleaning, profile grinding	Fleece, flexible	
	Self-adhesive discs Ø 115 0L Ø 115 8L Ø 125 0L Ø 125 8L Ø 150 0L Ø 150 6L Ø 150 8L	KSS (Aluminium oxide) 40 - 400			Medium-sized work on surfaces and edges	Paper, adhesive layer	

Coated Abrasives



Coated Abrasives

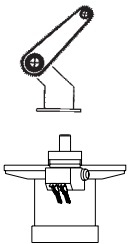





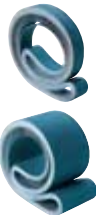







Drive	Tool measurements mm x mm	Model Grit type/-series	Material	Stock removal performance	Application	Backing properties	
	Short belts 35 x 450 50 x 450 6 x 480 10 x 480 12 x 480 16 x 480 20 x 480 25 x 480 75 x 480 40 x 505 6 x 520 12 x 520 16 x 520 75 x 533 100 x 560 6 x 610 12 x 610 100 x 610 100 x 620 110 x 620 63 x 950	BA (Aluminium oxide) 36, 40, 50, 60, 80, 100, 120, 150			Surface and edge grinding, deburring	Cloth, very flexible, flexible, hard, very hard	
	Short belts 10 x 330 12 x 330 12 x 480 20 x 480 12 x 520 20 x 520 12 x 610 12 x 620 100 x 920	BA (Zirconium aluminium oxide) 24, 36, 40, 60, 80			Surface grinding, welded seams, tanks/vessels, castings, implants, metal constructions	Cloth, flexible, hard	



Drive	Tool measurements mm x mm	Model Grit type/-series	Materials	Stock removal performance	Application	Backing properties	
	Short belts 35 x 450 50 x 450 40 x 505 63 x 950	BA - Stainless (Aluminium oxide) with special fillers assisting in the abrasive process 40, 80, 120, 180			Surface and edge grinding, welded seams, deburring, tanks/vessels, castings, surgical instruments (cool grinding)	Cloth, hard	
	Short belts 35 x 450 50 x 450 20 x 480 6 x 520 12 x 520 16 x 520 20 x 520 63 x 950	VB - A (Aluminium oxide) 100 (coarse) 180 (medium) 240 (fine)			Surface and profile grinding, instruments, rods, castings, containers, surgical instruments, metal fittings, deburring, cast and bodywork parts, implants	Cloth, flexible	



Drive	Tool measurements mm x mm	Model Grit type/-series	Materials	Stock removal performance	Application	Backing properties	
	Long belts 63 x 950 50 x 1000 100 x 1000 50 x 1600 38 x 1750 50 x 1750 50 x 2000 75 x 2000 150 x 2000 50 x 2500 75 x 2500 50 x 4000 75 x 4000	BA (Aluminium oxide) 24, 36, 40, 60, 80, 100, 120			Surface and edge grinding	Cloth, hard, very hard	
	Long belts 100 x 1000 50 x 2000 75 x 2000 150 x 2000 75 x 2250 50 x 2500 75 x 2500 150 x 2500 50 x 4000 75 x 4000	BA (Zirconium aluminium oxide) 24, 36, 40, 50, 60, 80, 120			Surface grinding, welded seams, tanks/vessels, castings, implants, metal constructions	Cloth, very hard	
	Long belts 50 x 2000 75 x 2000	BA (Zirconium aluminium oxide) Z-POWER 24, 36, 40, 50, 60, 80			Surface grinding, welded seams, tanks/vessels, castings, implants, metal constructions	Cloth, very hard	
	Long belts 50 x 1600 75 x 2000 75 x 2500 150 x 2500	BA (Zirconium aluminium oxide) Z-FORTE 36, 40, 50, 60, 80			Surface grinding, welded seams, tanks/vessels, castings, implants, metal constructions	Cloth, very hard	