

CUTTING

- 5.1 Cutting discs
- 5.2 Diamond cutting discs

244–259
260–267



TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS cutting discs

SHELF LIFE

Resin-bonded cutting discs for handheld use may only be used for up to three years after the manufacture date. The expiry date (month and year) is stamped on the metal ring, e.g. V07/2022.



LABELLING SYSTEM FOR RESIN-BONDED CUTTING DISCS

All of the important information about your LUKAS cutting disc is stated on the label: abrasive material, grit size, hardness and type of bond.

The following overview provides all the information concerning the abbreviations and markings.



A
Semi-friable
aluminium oxide



Z
Zirconia alumina



A
Ceramic-coated
annealed aluminium
oxide



CER
Ceramic grain



C
Silicon carbide

ABRASIVE

LUKAS offers you the abrasive you need for every application – tailored to your requirements and the materials you are working with.

Abrasive	
A	Aluminium oxide
C	Silicon carbide
Z	Zirconia alumina
CER	Ceramic grain

GRIT

From coarse to medium to fine, the grit size is indicated directly on the label.

coarse	medium	fine
12 to 24	36 to 54	60 to 120

HARDNESS

The hardness indicates the strength holding the abrasive grain bonded to the grinding disc. Letters are used to indicate the hardness grade.

soft	medium	hard
M	R	U
P	S	V
Q	T	Z

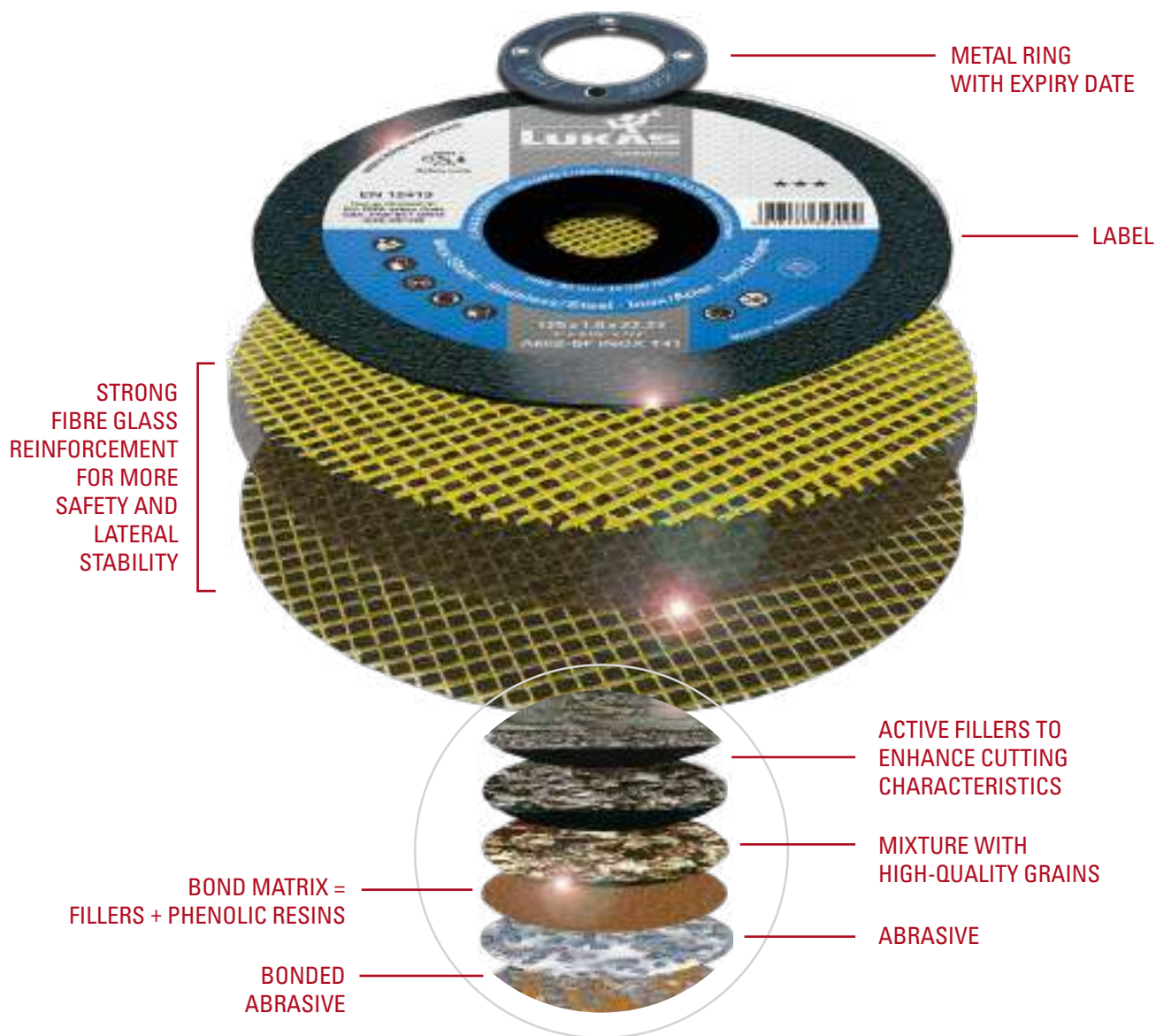
BOND

The bond is to hold the abrasive grain in the disc. LUKAS cutting discs are available with the following two types of bond:

- **BA** = resin bond
- **BF** = fibre-reinforced resin bond

TECHNICAL INFORMATION

Construction and components of LUKAS cutting discs



OPERATING SPEED

LUKAS cutting discs are developed and tested for specified maximum operating speeds and grinding processes. Before attaching the grinding tool to the machine, always check that

the nominal speed of the machine (nameplate) is not higher than the maximum speed specified on the cutting disc.

Maximum operating speed	Cutting disc diameter (mm)										
	50	76	100	115	125	150	180	230	300	350	400
80 m/s	30,500	20,100	15,300	13,300	12,200	10,200	8,500	6,600	5,100	4,400	3,800
100 m/s	38,200	25,100	19,100	16,650	16,600	12,700	10,600	8,300	6,400	5,400	4,700
rpm											

WORK SAFETY

Safe cutting with LUKAS tools

LUKAS makes a serious commitment to customers with respect to work safety and ergonomics. Our products are designed and manufactured according to the strictest quality standards to provide maximum customer value at minimum risk. We are a member of both the German Abrasives Association (VDS) and the Organisation for the Safety of Abrasives (oSa) and thus actively contribute to users' health and safety.

APPLIED STANDARDS

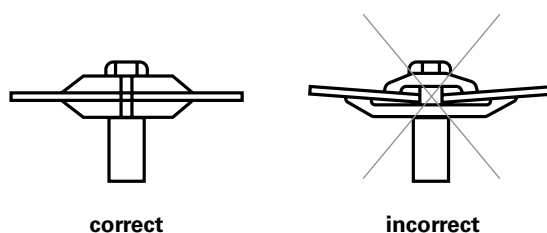
- Safety requirements for bonded abrasive products: EN 12413
- Safety requirements for superabrasive products: EN 13236

SAFETY INFORMATION

- **Avoid improper handling of the discs.** Use only fibre-reinforced cutting discs on power tools.
- Store discs **in a dry place at room temperature.**
- Do not **use damaged discs.**
- Never exceed the maximum permitted speed specified **on the disc.**
- Use only discs that can be mounted on the machine without requiring force.
- Never use **damaged, dirty or uneven mounting flanges.**
- Don't overtighten the mounting nut or locking flange, as this may lead to deformations.
- All tools may only be used with the appropriate **grinding disc protective cover.**
- Make sure that the **workplace is sufficiently ventilated** and wear appropriate **respiratory protection.**
- Do not apply lateral pressure **to cutting discs.** Avoid bending the disc.
- Do not press the disc on the edge or contact area in order to stop it from rotating. Always switch off the machine and allow the disc to spin freely until it stops.
- **Do not cant and seize** the disc **when** cutting.
- **Avoid applying excessive pressure** on the disc. It will cause the motor to slow down.
- **Do not drop handheld machines** or lower them to the floor by the cable or airline. The weight of the machine can cause the grinding disc to easily crack if it is put down with too much force. This is a common cause of disc breakage.
- Do only use the machine only in a position where you have full control and are well balanced.

CLAMPING SYSTEM

The use of flanges with different diameters is not permitted. Both flanges between which the bonded abrasive is mounted must have the same outer diameter and similar contact areas (according to EN 60745-2-3:2007 and ANSI B.7.1).



LABELLING

All important markings on the label

SAFETY STANDARD

MANUFACTURED
ACCORDING TO
EN 12413

SAFETY INFORMATION

MAXIMUM
OPERATING SPEED

A = ALUMINIUM OXIDE
C = SILICON CARBIDE
AC = ALUMINIUM OXIDE/
SILICON CARBIDE
ZA = ZIRCONIA ALUMINA/
ALUMINIUM OXIDE
CER = CERAMIC

60 = GRIT SIZE
(16/VERY COARSE, 36/MEDIUM, 60/FINE)

BF = FIBRE-REINFORCED
RESIN BOND

PRODUCT LINE
★★★ HIGH PERFORMANCE
★★☆ INDUSTRY
☆☆☆ BASE

EAN CODE

APPLICATIONS

MAXIMUM
PERMITTED SPEED

APPLICATION
INSTRUCTIONS

125 x 1.0 x 22.23
5" x 0.04" x 7/8"
DIAMETER x DISC THICKNESS x BORE

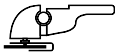





















TYPE
T41 FLAT CUTTING DISC
T42 DEPRESSED CENTRE CUTTING DISC

TYPES OF RESIN-BONDED CUTTING DISCS

T41 Flat cutting discs	T42 Depressed centre cutting disc
<p>Cutting discs T = (0.8 mm–4.5 mm) (USA: Type 1)</p>	<p>Cutting discs T = (0.8 mm–4.5 mm) (USA: Type 27)</p>
<ul style="list-style-type: none">Available in diameters from 50 mm (2") to 230 mm (9"), for handheld useFrom 300 mm (12") to 500 mm (20") for stationary machines	<ul style="list-style-type: none">Available in diameters from 76 mm (3") to 230 mm (9"), approved for handheld use

AREA OF USE

Overview of types of LUKAS cutting discs

Type	Product line	Material				
		Inox/Steel	Steel	Aluminium	Stone/ Construction material	Cast metal/ Construction material
Handheld cutting discs for angle grinders Diameter 100–230 mm 	★★★	 Pages 249 – 251	 Page 255		 Pages 263 and 266	 Page 262
	★★☆	 Page 252	 Page 255	 Page 256	 Pages 263, 265 and 266	
	★☆☆	 Pages 254 and 259	 Page 256		 Pages 257, 265 and 267	
Handheld cutting discs with X-LOCK system for angle grinders Diameter 115–125 mm 	★★☆	 Page 253			 Pages 264 and 267	
Stationary cutting discs Diameter Larger than 230 mm  	★★★				 Page 263	 Page 262
	★★☆				 Pages 263–264 and 266	
	★☆☆	 Page 258	 Pages 258 / 259			

MAXIMUM PERFORMANCE AND COOL CUTTING

EXTREMELY DURABLE FOR CUTTING STAINLESS STEEL

LUKAS cutting discs with ceramic grain are perfectly suited for high performance steel cutting. Thanks to the fast but cool cutting, they can machine inox without any blue discolouration whatsoever and have an exceptional tool life due to the self-sharpening effect. In addition, this tool requires little force to be applied.

EXTREME TOOL LIFE DUE TO SELF-SHARPENING EFFECT

The high performance cutting discs contain ceramic grit that constantly releases extremely fine particles in use. When the particles break off due to wear, new, sharp abrasive particles are immediately exposed. This self-sharpening effect allows

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

FASTER CUTS WITH HIGHER EFFICIENCY

The ceramic grain allows hard materials, such as hardened surfaces, wear-resistant steels, scale and hardened coatings, titanium alloys and reinforced weld seams, to be cut easily and quickly.

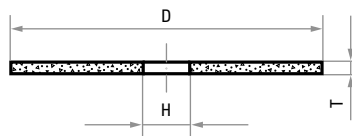


Ceramic cutting disc **NEW**



★★★

- extremely long tool life
- energy optimised for the highest performance angle grinders
- maximum cutting performance
- little force required
- cool cutting



Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT008310V9802	T41 115x1.0	CER 46U-BF Inox	115	1.0	22.23	13,300	25
AT008312V9802	T41 125x1.0	CER 46U-BF Inox	125	1.0	22.23	12,200	25
AT008320V9802	T41 230x2.0	CER 46U-BF Inox	230	2.0	22.23	6,600	25

Recommended for: ● Inox/Steel ● Steel ● Titanium

LUKAS CUTTING DISCS IN 3-STAR QUALITY

TOP PERFORMANCE FOR THE TOUGHEST JOBS

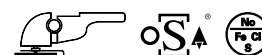
Thanks to innovative press technology and the highest quality raw materials, 3-star LUKAS cutting discs achieve the ultimate results.

The minimum wear of 3-star quality noticeably reduces odours and dust, thus improving working conditions. Energy and ergonomically optimised for powerful machines, 3-star cutting discs make work quicker and easier. A high-strength fibreglass fabric guarantees high lateral stability and safety.

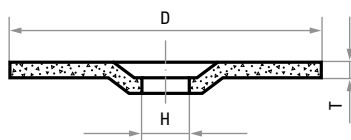
Eco-friendly production combined with first-class raw materials, optimised formulas and state-of-the-art production processes provide for high quality and a maximum storage time.

- maximum tool life and cutting performance with innovative bonding technology
- high cutting speed at a cool cutting temperature
- low odour and dust levels in daily use
- ergonomic work position and maximum tool life without use of excessive force
- maximum shelf life with high levels of stability in to quality thanks to top quality raw materials
- energy optimised for your high-performance angle grinders
- environmentally friendly production using up-to-date manufacturing processes and optimised formulas
- perfect for a wide variety of inox and steel materials
- precise cutting

COOL JOBBER – cutting and grinding disc for stainless steel



★★★



- for cutting and grinding with one tool
- carry out two work steps without changing tools
- practical, precise and safe

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AS015675V9802	T27 115x2.0	A36V-BF Inox COOL JOBBER	115	2.0	22.23	13,300	25
AS015676V9802	T27 125x2.0	A36V-BF Inox COOL JOBBER	125	2.0	22.23	12,200	25

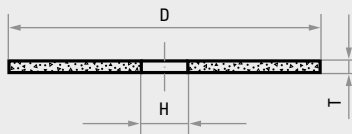
Recommended for: ● Inox/Steel ● Steel ● Aluminium



Cutting disc for stainless steel



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



★★★

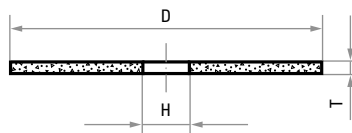
Product number	Description	Quality	Shape	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT007231V9802	T41 115x1.0	A60Z-BF Inox		115	1.0	22.23	13,300	50
AT007235V9802	T41 115x1.6	A46Z-BF Inox		115	1.6	22.23	13,300	50
AT007211V9802	T41 115x2.5	A30Z-BF Inox		115	2.5	22.23	13,300	25
AT007233V9802	T41 125x1.0	A60Z-BF Inox		125	1.0	22.23	12,200	50
AT007237V9802	T41 125x1.6	A46Z-BF Inox		125	1.6	22.23	12,200	50
AT007213V9802	T41 125x2.5	A30Z-BF Inox		125	2.5	22.23	12,200	25
AT007239V9802	T41 150x1.2	A60Z-BF Inox		150	1.2	22.23	10,200	50
AT007241V9802	T41 150x1.6	A46Z-BF Inox		150	1.6	22.23	10,200	25
AT007243V9802	T41 180x1.6	A46Z-BF Inox		180	1.6	22.23	8,500	25
AT007245V9802	T41 230x2.0	A46Z-BF Inox		230	2.0	22.23	6,600	25
AT007219V9802	T41 230x2.5	A30Z-BF Inox		230	2.5	22.23	6,600	25
AT005301V9802	T42 115x0.8	A60Z-BF Inox		115	0.8	22.23	13,300	50
AT007212V9802	T42 115x2.5	A30Z-BF Inox		115	2.5	22.23	13,300	25
AT005302V9802	T42 125x0.8	A60Z-BF Inox		125	0.8	22.23	12,200	50
AT007214V9802	T42 125x2.5	A30Z-BF Inox		125	2.5	22.23	12,200	25
AT007244V9802	T42 180x1.6	A46Z-BF Inox		180	1.6	22.23	8,500	25
AT007246V9802	T42 230x1.9	A46Z-BF Inox		230	1.9	22.23	6,600	25
AT007220V9802	T42 230x2.5	A30Z-BF Inox		230	2.5	22.23	6,600	25

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material

CUTTING



Cutting disc set



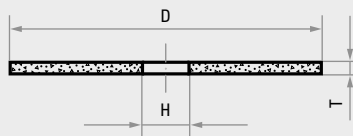
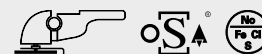
- The handy choice, e.g.
for the construction site
- cutting discs in a metal can
 - safely packed
 - moisture-proof

★★★

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT007231V9807010	T41 115x1.0	A60Z-BF Inox	115	1.0	22.23	13,300	10
AT007233V9807010	T41 125x1.0	A60Z-BF Inox	125	1.0	22.23	12,200	10

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material

Cutting disc for stainless steel



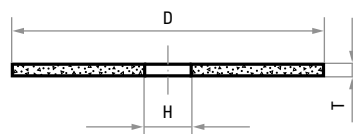
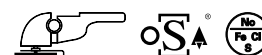
- free of iron, chlorine and sulphur
- cuts precisely at a high cutting speed and low cutting temperature
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing

★★☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT005841V9802	T41 115x1.0	A60X-BF Inox		115	1.0	22.23	13,300	50
AT003346V9802	T41 115x1.6	A46X-BF Inox		115	1.6	22.23	13,300	50
AT001657V9802	T41 115x2.0	A36U-BF Inox		115	2.0	22.23	13,300	25
AT005842V9802	T41 125x1.0	A60X-BF Inox		125	1.0	22.23	12,200	50
AT003348V9802	T41 125x1.6	A46X-BF Inox		125	1.6	22.23	12,200	50
AT001687V9802	T41 125x2.0	A36U-BF Inox		125	2.0	22.23	12,200	25
AT003327V9802	T41 150x1.6	A46X-BF Inox		150	1.6	22.23	10,200	25
AT001743V9802	T41 180x2.0	A36U-BF Inox		180	2.0	22.23	8,500	25
AT005864V9802	T41 230x1.9	A46X-BF Inox		230	1.9	22.23	6,600	25
AT001782V9802	T41 230x2.0	A36U-BF Inox		230	2.0	22.23	6,600	25
AT001696V9802	T42 125x2.5	A30U-BF Inox		125	2.5	22.23	12,200	25
AT005571V9802	T42 180x1.6	A46X-BF Inox		180	1.6	22.23	8,500	25
AT005877V9802	T42 230x1.9	A46X-BF Inox		230	1.9	22.23	6,600	25
AT004464V9802	T42 230x3.0	A30U-BF Inox		230	3.0	22.23	6,600	25

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material

Cutting disc set



The handy choice, e.g.

for the construction site

- cutting discs in a metal can
- safely packed
- moisture-proof

★★☆

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT005841V9807010	T41 115x1.0	A60X-BF Inox	115	1.0	22.23	13,300	10
AT005842V9807010	T41 125x1.0	A60X-BF Inox	125	1.0	22.23	12,200	10

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material

Photo: Bosch

TOOL CHANGE WITH JUST A CLICK

CHANGING CUTTING DISCS IS FASTER AND SIMPLER THAN EVER

With the new X-LOCK system, simply position the LUKAS cutting disc on the angle grinder's mounting fixture, allow it to engage and you're done. The click sound tells you the disc is securely and safely in place and ready for use. The tool change now only takes a few seconds. There are also no parts like clamping nuts and keys that can get lost easily. That means tool changing is fast and easy, making lengthy tool-change times a thing of the past.

TOOL CHANGE IN NO TIME AT ALL

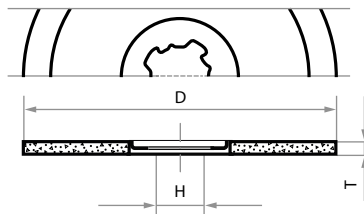
The X-LOCK allows you to change LUKAS cutting discs in seconds, as well as other LUKAS tool products such as the mounted flap discs found on **pages 144 and 154**.

CUTTING



X-LOCK cutting disc **NEW**

- faster and simpler tool changes thanks to the latest X-LOCK system
- free of iron, chlorine and sulphur
- cuts precisely at a high cutting speed and low cutting temperature
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing

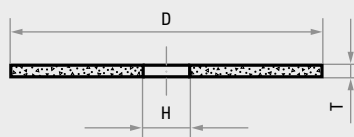
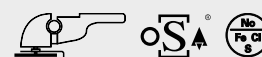


★★☆

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT115010V980201	T41 115x1.0x22.23 X-LOCK	A46U-BF Inox	115	1.0	22.23	13,300	50
AT125010V980202	T41 125x1.0x22.23 X-LOCK	A46U-BF Inox	125	1.0	22.23	12,200	50

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material

Cutting disc for stainless steel



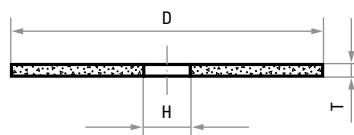
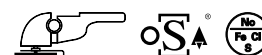
★☆☆

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

Product number	Description	Quality	Shape	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT003108V9802	T41 100x1.0	A60S-BF Inox		100	1.0	16.00	15,300	50
AT004643V9802	T41 115x1.0	A60S-BF Inox		115	1.0	22.23	13,300	50
AT000647V9802	T41 115x1.6	A46T-BF Inox		115	1.6	22.23	13,300	50
AT002672V9802	T41 125x1.0	A60S-BF Inox		125	1.0	22.23	12,200	50
AT000674V9802	T41 125x1.6	A46T-BF Inox		125	1.6	22.23	12,200	50
AT000700V9802	T41 150x1.6	A46T-BF Inox		150	1.6	22.23	10,200	25
AT000716V9802	T41 180x1.6	A46T-BF Inox		180	1.6	22.23	8,500	25
AT000742V9802	T41 230x1.9	A46T-BF Inox		230	1.9	22.23	6,600	25
AT003568V9802	T41 230x3.0	A24/30S-BF Inox		230	3.0	22.23	6,600	25
AT001442V9802	T42 115x2.5	A24/30S-BF Inox		115	2.5	22.23	13,300	25
AT004157V9802	T42 125x2.5	A24/30S-BF Inox		125	2.5	22.23	12,200	25
AT000718V9802	T42 180x1.6	A46T-BF Inox		180	1.6	22.23	8,500	25
AT000744V9802	T42 230x1.9	A46T-BF Inox		230	1.9	22.23	6,600	25
AT005451V9802	T42 230x2.5	A24/30S-BF Inox		230	2.5	22.23	6,600	25
AT004168V9802	T42 230x3.0	A24/30S-BF Inox		230	3.0	22.23	6,600	25

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium

Cutting disc set



★☆☆

The handy choice, e.g.

for the construction site

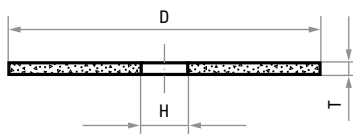
- cutting discs in a metal can
- safely packed
- moisture-proof

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT004643V9807010	T41 115x1.0	A60S-BF Inox	115	1.0	22.23	13,300	10
AT002672V9807010	T41 125x1.0	A60S-BF Inox	125	1.0	22.23	12,200	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Titanium



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



Cutting disc for machining steel



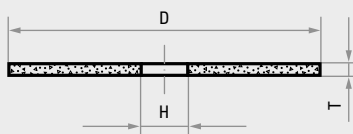
★★★

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT007276V9802	T41 115x1.0	A60Z-BF Steel	115	1.0	22.23	13,300	50
AT007271V9802	T41 115x1.6	A46Z-BF Steel	115	1.6	22.23	13,300	50
AT007278V9802	T41 125x1.0	A60Z-BF Steel	125	1.0	22.23	12,200	50
AT007273V9802	T41 125x1.6	A46Z-BF Steel	125	1.6	22.23	12,200	50
AT007284V9802	T41 230x1.9	A46Z-BF Steel	230	1.9	22.23	6,600	25

Recommended for: ● Steel ● Cast material



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



Cutting disc for steel

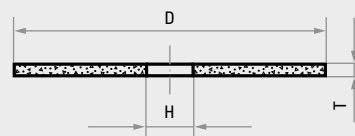


★★★

Product number	Description	Quality	Shape	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT005840V9802	T41 115x1.0	A60X-BF Steel		115	1.0	22.23	13,300	50
AT013301V9802	T41 115x1.6	A46X-BF Steel		115	1.6	22.23	13,300	50
AT001656V9802	T41 115x2.0	A36U-BF Steel		115	2.0	22.23	13,300	25
AT005835V9802	T41 125x1.0	A60X-BF Steel		125	1.0	22.23	12,200	50
AT013302V9802	T41 125x1.6	A46X-BF Steel		125	1.6	22.23	12,200	50
AT001686V9802	T41 125x2.0	A36U-BF Steel		125	2.0	22.23	12,200	25
AT011086V9802	T41 125x2.5	A30X-BF Steel		125	2.5	22.23	12,200	25
AT013303V9802	T41 150x1.6	A46X-BF Steel		150	1.6	22.23	10,200	25
AT013305V9802	T41 180x1.6	A46X-BF Steel		180	1.6	22.23	8,500	25
AT001742V9802	T41 180x2.0	A36U-BF Steel		180	2.0	22.23	8,500	25
AT005867V9802	T41 230x1.9	A46X-BF Steel		230	1.9	22.23	6,600	25
AT001781V9802	T41 230x2.0	A36U-BF Steel		230	2.0	22.23	6,600	25
AT001785V9802	T41 230x3.0	A30U-BF Steel		230	3.0	22.23	6,600	25
AT001665V9802	T42 115x2.5	A30U-BF Steel		115	2.5	22.23	13,300	25
AT001695V9802	T42 125x2.5	A30U-BF Steel		125	2.5	22.23	12,200	25
AT001724V9802	T42 150x2.5	A30U-BF Steel		150	2.5	22.23	10,200	25
AT001750V9802	T42 180x3.0	A30U-BF Steel		180	3.0	22.23	8,500	25
AT001790V9802	T42 230x2.5	A30U-BF Steel		230	2.5	22.23	6,600	25

Recommended for: ● Steel ● Cast material

Cutting disc for steel



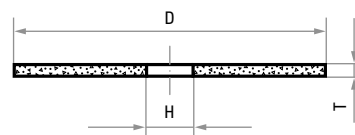
- cuts precisely
- long tool life and cutting performance with innovative bonding technology
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing

☆☆☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT006440V9802	T41 115x1.0	A60S-BF Steel		115	1.0	22.23	13,300	50
AT000648V9802	T41 115x1.6	A46T-BF Steel		115	1.6	22.23	13,300	50
AT000656V9802	T41 115x2.5	A24R-BF Steel		115	2.5	22.23	13,300	25
AT006710V9802	T41 125x1.0	A60S-BF Steel		125	1.0	22.23	12,200	50
AT000675V9802	T41 125x1.6	A46T-BF Steel		125	1.6	22.23	12,200	50
AT000679V9802	T41 125x2.5	A24R-BF Steel		125	2.5	22.23	12,200	25
AT000707V9802	T41 150x2.5	A24R-BF Steel		150	2.5	22.23	10,200	25
AT000717V9802	T41 180x1.6	A46T-BF Steel		180	1.6	22.23	8,500	25
AT000728V9802	T41 180x3.0	A24R-BF Steel		180	3.0	22.23	8,500	25
AT000743V9802	T41 230x1.9	A46T-BF Steel		230	1.9	22.23	6,600	25
AT000967V9802	T41 230x2.0	A36T-BF Steel		230	2.0	22.23	6,600	25
AT000750V9802	T41 230x3.0	A24R-BF Steel		230	3.0	22.23	6,600	25
AT000662V9802	T42 115x2.5	A24R-BF Steel		115	2.5	22.23	13,300	25
AT000688V9802	T42 125x2.5	A24R-BF Steel		125	2.5	22.23	12,200	25
AT000732V9802	T42 180x3.0	A24R-BF Steel		180	3.0	22.23	8,500	25
AT000745V9802	T42 230x1.9	A46T-BF Steel		230	1.9	22.23	6,600	25
AT000754V9802	T42 230x3.0	A24R-BF Steel		230	3.0	22.23	6,600	25

Recommended for: Steel Cast material

NEW Cutting disc for machining non-ferrous metals



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

☆☆☆

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT000920V9802	T41 115x1.0	A60N-BF Alu	115	1.0	22.23	13,300	50
AT000950V9802	T41 125x1.0	A60N-BF Alu	125	1.0	22.23	12,200	50
AT001694V9802	T41 125x2.5	A36N-BF Alu	125	2.5	22.23	12,200	25
AT001789V9802	T41 230x2.5	A36N-BF Alu	230	2.5	22.23	6,600	25

Recommended for: Aluminium

THE DISC FOR UNIVERSAL USE

EFFICIENTLY CUT CONCRETE, STONE OR CAST MATERIAL

FLEXIBLE, FAST WORKING

Especially in structural and civil engineering, for new buildings or structural alterations on existing ones and in road construction, tools are required that allow flexible machining of a broad range of building materials. Regardless of whether you are working with brickwork, cast pipes or concrete supports – LUKAS cutting discs for stone, concrete and cast material cut reliably and quickly. They are the perfect alternative for tradespeople who do not regularly use diamond cutting discs.

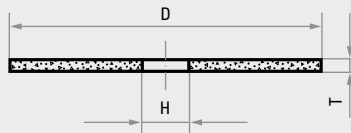
BROAD RANGE OF APPLICATIONS

This disc is also used for fettling in many foundries and fettling shop, where they come into their own thanks to their high silicon carbide content. As a result, cast parts with inclusions and defects in the surface can be machined quickly and reliably. Risers and sprues can easily be cut off.



Cutting disc for stone and cast material **NEW**

- for universal use
- for use on construction sites
- preferable to diamond cutting discs thanks to its excellent value for money and high speed

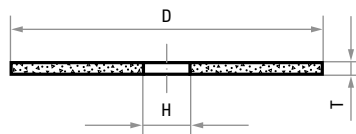


★☆☆

Product number	Description	Quality	Shape	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT115025V980201	T41 115x2.5	C24S-BF Stone		115	2.5	22.23	13,300	25
AT125025V980201	T41 125x2.5	C24S-BF Stone		125	2.5	22.23	12,200	25
AT180030V980201	T41 180x3.0	C24S-BF Stone		180	3.0	22.23	8,500	25
AT230030V980201	T41 230x3.0	C24S-BF Stone		230	3.0	22.23	6,600	25
AT115025V980202	T42 115x2.5	C24S-BF Stone		115	2.5	22.23	13,300	25
AT125025V980202	T42 125x2.5	C24S-BF Stone		125	2.5	22.23	12,200	25
AT230030V980202	T42 230x3.0	C24S-BF Stone		230	3.0	22.23	6,600	25
AT230030V980203	T42 230x3.0	C24R-BF Stone		230	3.0	22.23	6,600	25

Recommended for: ● Stone ● Cast material

Stationary cutting disc for machining stainless steel



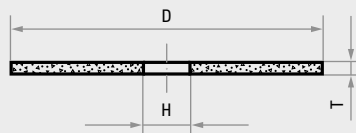
- free of iron, chlorine and sulphur
- optimised for stationary use
- cuts precisely
- long tool life and cutting performance with innovative bonding technology

★☆☆

Product number	Description	Quality	D mm	T mm	H mm	n_{max} rpm	Pack contains
AT010003	T41 300x3.5	A30S-BF Inox	300	3.5	32.00	5,100	10
AT020208	T41 350x2.6	A30S-BF Inox	350	2.6	25.40	4,400	10

Recommended for: ● Inox/Steel ● Steel ● Titanium ● Aluminium ● Cast material

Cutting disc for machining steel



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

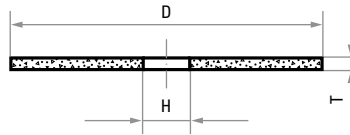
★☆☆

Product number	Description	Quality	D mm	T mm	H mm	n_{max} rpm	Pack contains
AT010052	T41 300x4.0	A24R-BF	300	4.0	20.00	6,400	10
AT010055	T41 350x4.0	A24R-BF	350	4.0	20.00	5,400	10
AT010057	T41 350x4.0	A24R-BF	350	4.0	25.40	5,400	10

Recommended for: ● Steel ● Cast material



Stationary cutting disc for machining steel

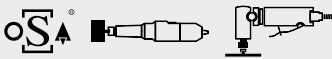


- optimised for stationary use
- cuts precisely
- long tool life and cutting performance with innovative bonding technology

★☆☆

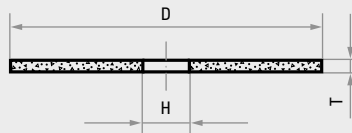
Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT010028	T41 300x2.6	A36S-BF Steel	300	2.6	25.40	6,400/80 m/s	10
AT001774	T41 300x3.5	A30T-BF Steel	300	3.5	22.23	6,400/100 m/s	10
AT001776	T41 300x3.5	A30T-BF Steel	300	3.5	25.40	6,400/100 m/s	10
AT010020	T41 300x3.5	A30T-BF Steel	300	3.5	32.00	6,400/100 m/s	10
AT010029	T41 350x2.6	A36S-BF Steel	350	2.6	25.40	5,400/80 m/s	10
AT010022	T41 350x3.5	A30T-BF Steel	350	3.5	25.40	5,400/100 m/s	10
AT010023	T41 350x3.5	A30T-BF Steel	350	3.5	32.00	5,400/100 m/s	10
AT010030	T41 400x3.2	A36S-BF Steel	400	3.2	25.40	4,700/80 m/s	5
AT010026	T41 400x4.0	A30T-BF Steel	400	4.0	32.00	4,700/100 m/s	5

Recommended for: ● Steel ● Cast material



Small cutting disc for machining stainless steel **NEW**

- The thin width of less than a millimetre allows you to get to hard-to-reach places.
- delicately machine small parts
- free of iron, chlorine and sulphur
- high level of safety and lateral stability thanks to strong fibreglass fabric and regular testing



★☆☆

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AT501006V9802	T41 50x1.0	A46S-BF Inox	50	1.0	6.0	30,500	50
AT501010V9802	T41 50x1.0	A46S-BF Inox	50	1.0	10.0	30,500	50
AT761006V9802	T41 76x1.0	A46S-BF Inox	76	1.0	6.0	20,100	50
AT761010V9802	T41 76x1.0	A46S-BF Inox	76	1.0	10.0	20,100	50
AT763010V9802	T41 76x3.0	A46S-BF Inox	76	3.0	10.0	20,100	50

Recommended for: ● Inox/Steel ● Steel

TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS diamond cutting discs

DIAMOND

Diamond is the hardest material in the world. The type of diamond chosen depends on what it is used for. Only synthetic diamonds are used for the diamond cutting discs. Unlike natural diamonds, their properties can be reproduced and controlled.

The following characteristics are significant when selecting diamonds:

- degree of purity
- defined fracture strength
- sharp edges
- consistent geometry

Diamonds are classified by quality levels and grit sizes.



SEGMENT

The segments consist of a diamond-embedded metal powder. The metal bond must be suited to the material to be cut. The metal powder consists of bronze, cobalt, iron, carbide, or tungsten carbide, for example. The various characteristics of the metal powder give the segment sharpness and the all-important wear resistance. The segment coating is produced by a sintering process. A hard bond is selected for abrasive construction materials, while a soft bond is needed for hard structural materials.



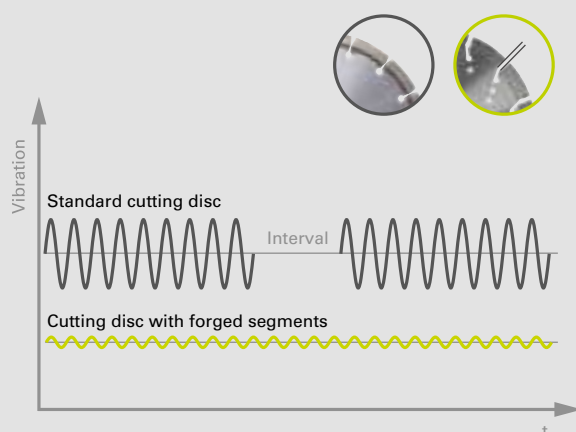
SEGMENT GEOMETRY

The patented forged segment geometry allows even tall segments to be arranged very close to each other. This significantly reduces vibration for the user. Another crucial advantage is safety. The dense, porelessly forged segments have welds that provide much more safety against fracturing compared to the usual sintered segments.

- universal and fast due to new types of alloys in the segments
- less vibration through trapezium segment geometry
- more safety due to segment feet that are poreless and provide the utmost safety against fracturing
- long tool life thanks to taller segments and slower rate of diamond shedding

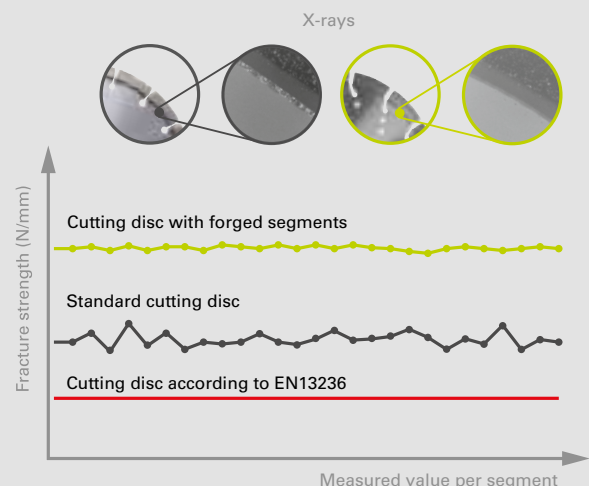
COMPARISON OF CUTTING PROPERTIES

Low-vibration, narrow-gap cutting discs compared to cutting discs with forged segment



WELDING PROPERTIES OF FORGED SEGMENTS

Highest level of safety against fracturing



USAGE INSTRUCTIONS

The right disc for your application

LUKAS has diamond cutting discs for a variety of materials. Whether you are working with concrete, tile or asphalt, you'll

find the perfect tool for every application. Select the material that you want to cut from the table below.

<div><div></div> best suitable<div></div> suitable</div>				Tile			Granite, hard materials			Concrete			Building material				Asphalt, abrasive materials				
Page	Product	Product line	Segment height mm	Tile	Fine stoneware	Granite tile	Granite	Porphyry	Clinker brick	Reinforced concrete	Exposed aggregate concrete	Concrete products	Brick, masonry	Roof tiles	Gas concrete, pumice	Sand-lime brick	Refractory bricks	Screed	Fresh concrete	Asphalt	Grey iron
Diamond cutting discs																					
262	VDC	★★★★	7																		
263	LD Multi S13		13																		
263/264	LD3 S10/ LD3 S10 X-LOCK	★★★☆☆	10																		
264	LD7 S10		10																		
265	Turbo S10		10																		
265	Blue Cut S10	★★☆☆☆	10																		
265	TC7		7																		
Tile cutting discs																					
266	FAST CUT S10	★★★★	10																		
266/267	FLIESE S7/ FLIESE S7 X-LOCK	★★★☆☆	7																		
267	FC7	★★☆☆☆	7																		

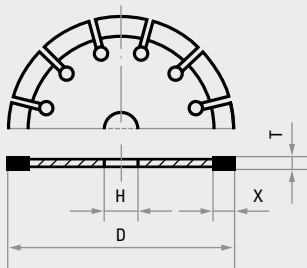
VDC – AGGRESSIVE APPLICATION
WITH EXTREME TOOL LIFE

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



CUTTING

VDC diamond cutting disc



★★★

- the diamond cutting disc that revolutionised cutting cast iron
- ideal for cutting cast iron (GG, GGG), fibreglass reinforced plastics (GFRP) and mineralisation
- not suitable for high-alloy materials containing nickel!

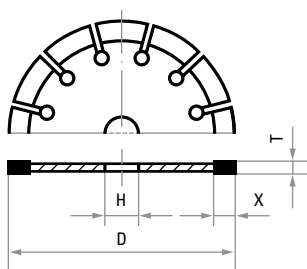
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n _{max} rpm	Pack contains
A34901152222	VDC 115022	115	7.0	2.2	22.23	13,300	1
A34901252222	VDC 125022	125	7.0	2.2	22.23	12,200	1
A34901802622	VDC 180026	180	7.0	2.2	22.23	8,500	1
A34902303022	VDC 230030	230	7.0	3.0	22.23	6,600	1
A34903503632	VDC 350036	350	7.0	3.6	32.00	4,400	1

Recommended for: ● Stone/Construction material ● Cast material ● Plastic



LD Multi S13 diamond cutting disc

- professional disc for concrete and construction materials
- extremely versatile with optimum cutting speed
- long tool life
- Trapezium-shaped segments ensure low vibration.
- segment produced using forge technology



★★★

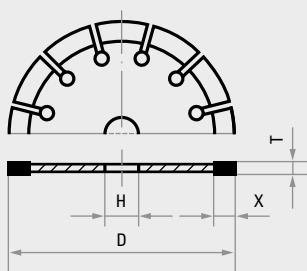
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n _{max} rpm	Pack contains
A344031151213083	LD Multi S13	115	13	2.4	22.23	13,300	1
A344031251213093	LD Multi S13	125	13	2.4	22.23	12,200	1
A344031501213113	LD Multi S13	150	13	2.4	22.23	10,200	1
A344031801213133	LD Multi S13	180	13	2.4	22.23	8,500	1
A344032301213153	LD Multi S13	230	13	2.6	22.23	6,600	1
A344033002213183	LD Multi S13	300	13	2.8	25.4	6,400	1
A344033502213213	LD Multi S13	350	13	3.0	25.4	5,500	1
A344034002213243	LD Multi S13	400	13	3.2	25.4	4,800	1

Recommended for: ● Stone/Construction material



LD3 S10 diamond cutting disc

- For universal applications but highly versatile with a high cutting rate in reinforced concrete and construction material
- excellent price-performance ratio
- laser-welded joints



★★☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n _{max} rpm	Pack contains
A344131151210083	LD3 S10	115	11	2.4	22.23	13,300	1
A344131251210093	LD3 S10	125	11	2.4	22.23	12,200	1
A344131801210143	LD3 S10	180	11	2.4	22.23	8,500	1
A344132301210163	LD3 S10	230	11	2.6	22.23	6,600	1
A344133002210163	LD3 S10	300	11	2.8	25.4	6,400	1
A344133502210163	LD3 S10	350	11	3.0	25.4	5,500	1
A344134002210163	LD3 S10	400	11	3.2	25.4	4,800	1

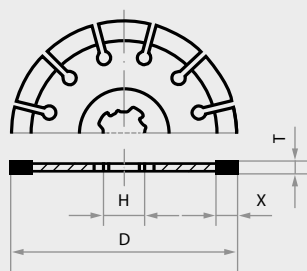
Recommended for: ● Stone/Construction material



HIGH CUTTING RATE – QUICK CHANGE

NO ACCESSORIES NEEDED FOR TOOL CHANGE DUE TO THE X-LOCK SYSTEM

NEW LD3 S10 X-LOCK diamond cutting disc



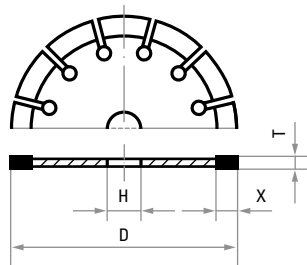
- For universal applications but highly versatile with a high cutting rate in reinforced concrete and construction material
- Tool change is as easy as a click. No accessories needed due to the innovative X-LOCK system.
- excellent price-performance ratio
- laser-welded joints

★★☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n _{max} rpm	Pack contains
A344131259210083	LD3 S10 X-LOCK	125	10	2.3	22.23	12,200	10

Recommended for: ● Stone/Construction material

LD 7 S10 diamond cutting disc



- perfect for cutting asphalt
- specially formed segments for high running smoothness and core protection
- laser-welded joints

★★☆

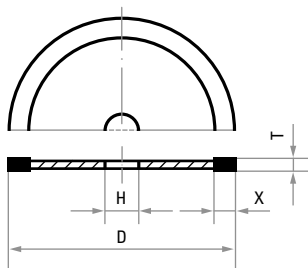
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n _{max} rpm	Pack contains
A344173002210183	LD7 S10	300	11	3.2	25.4	6,400	1
A344173502210213	LD7 S10	350	11	3.2	25.4	5,500	1
A344174002210243	LD7 S10	400	11	3.5	25.4	4,800	1
A344174502210283	LD7 S10	450	11	4.0	25.4	2,700	1

Recommended for: ● Stone/Construction material



TURBO S10 diamond cutting disc

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



★★☆

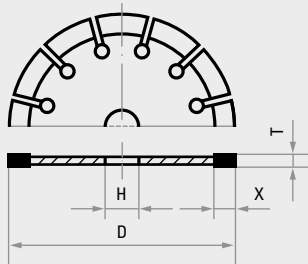
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n _{max} rpm	Pack contains
A344141151110013	TURBO S10	115	10	1.8	22.23	13,300	1
A344141251110013	TURBO S10	125	10	1.8	22.23	12,200	1
A344141801110013	TURBO S10	180	10	2.2	22.23	8,500	1
A344142301110013	TURBO S10	230	10	2.4	22.23	6,600	1

Recommended for: ● Stone/Construction material



Blue Cut S10 diamond cutting disc

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



★☆☆

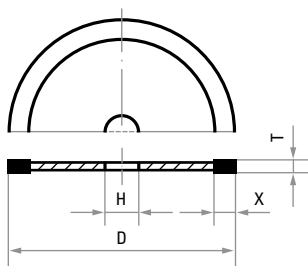
Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n _{max} rpm	Pack contains
A345241151110085	Blue Cut S10	115	10	2.0	22.23	13,300	1
A345241251110095	Blue Cut S10	125	10	2.0	22.23	12,200	1
A345241501110125	Blue Cut S10	150	10	2.2	22.23	10,200	1
A345241801110145	Blue Cut S10	180	10	2.4	22.23	8,500	1
A345242301110165	Blue Cut S10	230	10	2.5	22.23	6,600	1

Recommended for: ● Stone/Construction material



TC7 diamond cutting disc

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

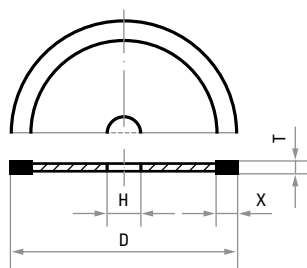


★★☆☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n _{max} rpm	Pack contains
A3452411511107775	TC7	115	7	2.4	22.23	13,300	1
A3452412511107775	TC7	125	7	2.6	22.23	12,200	1
A3452423011107775	TC7	230	7	3.2	22.23	6,600	1

Recommended for: ● Stone/Construction material

FAST CUT diamond cutting disc



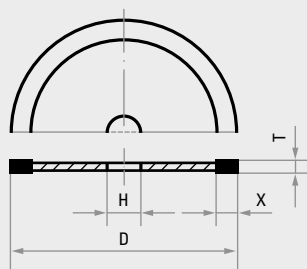
★★★

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

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n _{max} rpm	Pack contains
A344091151110013	FAST CUT S10	115	10	1.4	22.23	13,300	1
A344091251110013	FAST CUT S10	125	10	1.4	22.23	12,200	1

Recommended for: ● Stone/Construction material

FLIESE S7 diamond cutting disc



★★☆

- the popular choice cutting discs for tile and ceramic
- also cuts exactly through glazed ceramic

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n _{max} rpm	Pack contains
A344111151107013	FLIESE S7	115	7	1.6	22.23	13,300	1
A344111251107013	FLIESE S7	125	7	1.6	22.23	12,200	1
A344112301107013	FLIESE S7	230	7	2.0	22.23	6,600	1

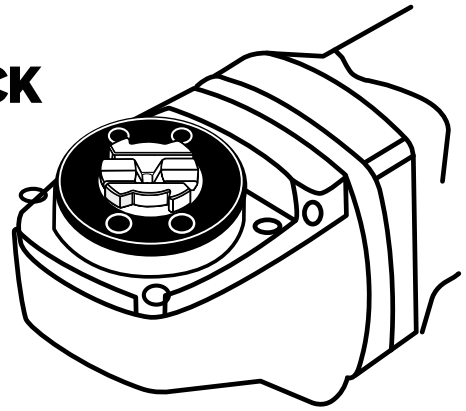
Recommended for: ● Stone/Construction material

TOOL CHANGE WITH JUST A CLICK

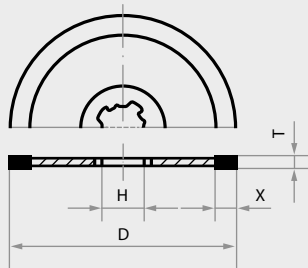
CHANGE TOOL QUICKLY AND EASILY WITH NO NEEDED ACCESSORIES

With the new X-LOCK system, simply position the LUKAS diamond cutting disc on the angle grinder's mounting fixture, allow it to engage and you are done. The click sound lets you know that the disc is securely and safely in place and ready for use. The tool change now only takes a few seconds. There are also no parts like clamping nuts and keys that can get lost easily. That means tool changing is fast and easy, making lengthy tool-change times a thing of the past.

XLOCK



FLIESE S7 X-LOCK diamond cutting disc **NEW**

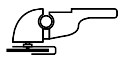


- cutting disc for tile and ceramic, with practical X-LOCK system
- tool change without accessories; turn in your hand
- also cuts exactly through glazed ceramic

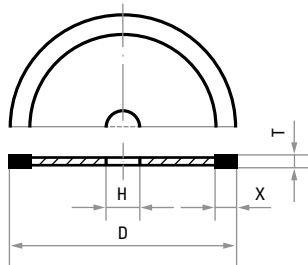
★★☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n _{max} rpm	Pack contains
A344111259107013	FLIESE S7 X-LOCK	125	7	1.5	22.23	12,200	10
Recommended for: ● Stone/Construction material							

CUTTING



FC7 diamond cutting disc



- cuts through tiles with ease
- excellent price-performance ratio

★★☆

Product number	Description	D mm	Segment height X mm	Segment width T mm	H mm	n _{max} rpm	Pack contains
A345211151107015	FC7	115	7	1.8	22.23	13,300	1
A345211251107015	FC7	125	7	2.0	22.23	12,200	1
A345212301107015	FC7	230	7	2.5	22.23	6,600	1
Recommended for: ● Stone/Construction material							

ROUGH GRINDING



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

TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS grinding discs

SHELF LIFE

Resin-bonded grinding discs for handheld use may only be used up to three years after the manufacture date. The expiry date (month and year) is stamped on the metal ring, e.g. V07/2022.



LABELLING SYSTEM FOR RESIN-BONDED GRINDING DISCS

All of the important quality information about your LUKAS grinding disc is stated on the label: abrasive material, grit size, hardness and type of bond.

The following overview provides all the information concerning the abbreviations and markings.



A
Semi-friable
aluminium oxide



Z
Zirconia alumina



A
Ceramic-coated
annealed aluminium
oxide



CER
Ceramic grain



C
Silicon carbide

ABRASIVE

LUKAS offers you the abrasive you need for every application – tailored to your requirements and the materials you are working with.

Abrasive	
A	Aluminium oxide
C	Silicon carbide
Z	Zirconia alumina
CER	Ceramic grain

GRIT

From coarse to medium to fine, the grit size is indicated directly on the label.

coarse	medium	fine
12 to 24	36 to 54	60 to 120

HARDNESS

The hardness indicates the strength holding the abrasive grain bonded to the grinding disc. Letters are used to indicate the hardness grade.

soft	medium	hard
M	R	U
P	S	V
Q	T	Z

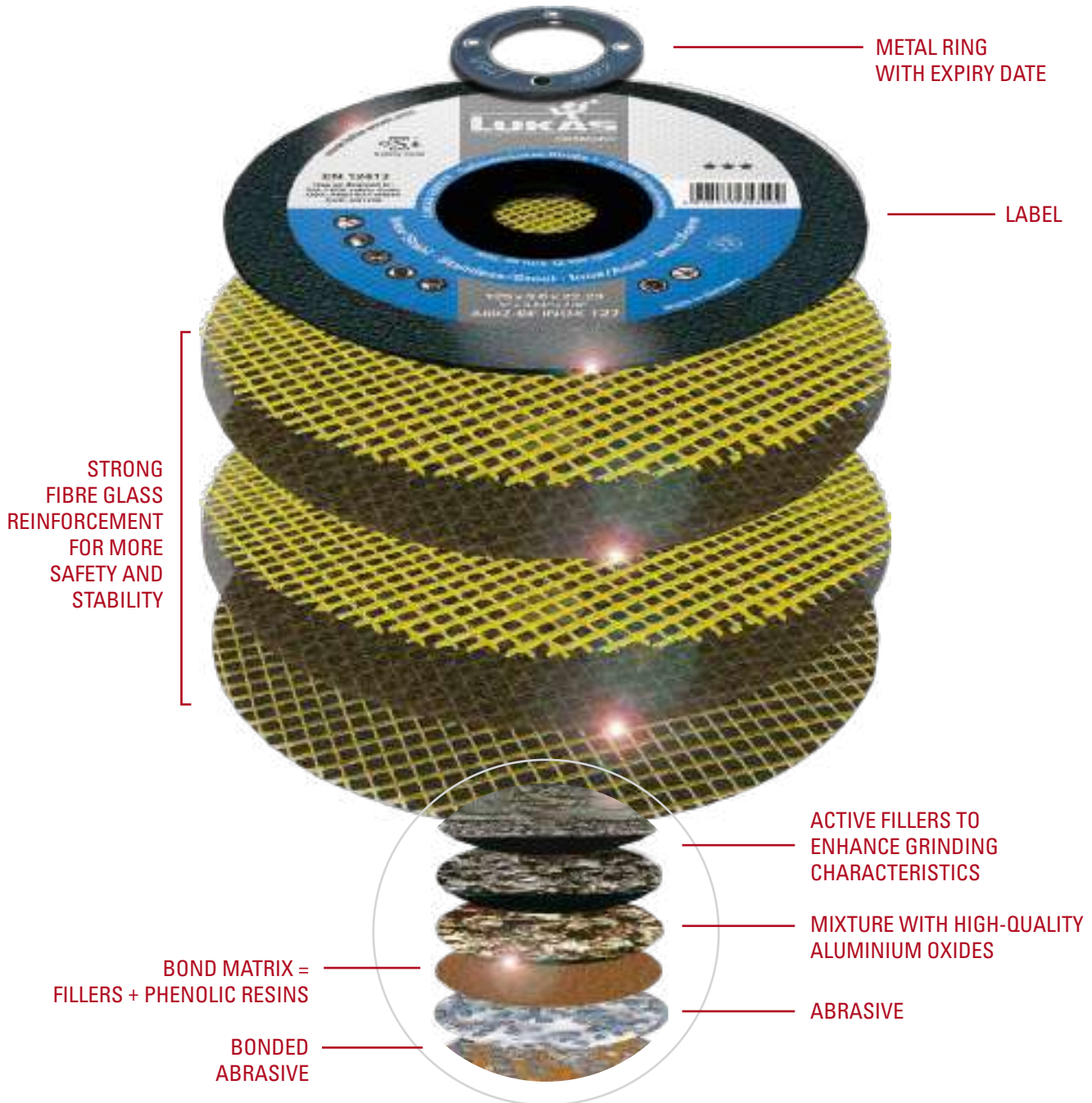
BOND

The bond holds the abrasive grain to the grinding disc. LUKAS grinding discs are available with the following bonds:

- **BA** = resin bond
- **BF** = fibre-reinforced resin bond

TECHNICAL INFORMATION

Construction and components of LUKAS grinding discs



OPERATING SPEED

LUKAS grinding discs are developed and tested for specified maximum operating speeds and grinding processes. Before fixing the grinding tool to the machine, always check that

the nominal speed of the machine (nameplate) is not higher than the maximum speed specified on the grinding disc.

Maximum operating speed	Grinding disc diameter (mm)										
	50	76	100	115	125	150	180	230	300	350	400
80 m/s	30,500	20,100	15,300	13,300	12,200	10,200	8,500	6,600	5,100	4,400	3,800
100 m/s	38,200	25,100	19,100	16,650	16,600	12,700	10,600	8,300	6,400	5,400	4,700
rpm											

WORK SAFETY

Safely grinding with LUKAS tools

LUKAS makes a serious commitment to customers with respect to work safety and ergonomics. Our products are designed and manufactured according to the strictest quality standards to provide maximum customer value at minimum risk. We are a member of both the German Abrasives Association (VDS) and the Organisation for the Safety of Abrasives (oSa) and thus actively contribute to users' health and safety.

APPLIED STANDARDS

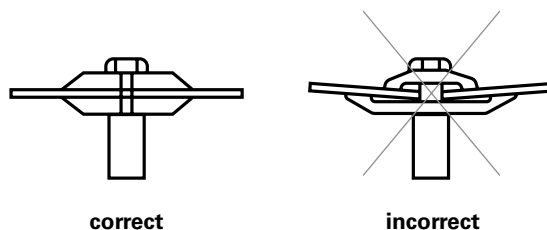
- Safety requirements for bonded abrasive products: EN 12413
- Safety requirements for superabrasive products: EN 13236

SAFETY INFORMATION

- **Avoid improper handling of the discs.** Use only fibre-reinforced grinding discs on power tools.
- Store discs **in a dry place at room temperature.**
- Don't **use damaged discs.**
- Never exceed the maximum permitted speed specified **on the disc.**
- Only use discs that can be mounted on the machine without requiring force.
- Never use **damaged, dirty or uneven mounting flanges.**
- Don't overtighten the mounting nut or locking flange, as this may lead to deformations.
- All tools may only be used with the appropriate **grinding disc protective cover.**
- Make sure that the **workplace is sufficiently ventilated** and wear appropriate **respiratory protection.**
- Avoid bending the disc.
- Don't press the disc on the edge or contact area in order to stop it from rotating. Always switch off the machine and allow the disc to spin freely until it stops.
- **Don't cant and seize** the disc **when grinding.**
- **Avoid applying excessive pressure** on the disc. It will cause the motor to slow down.
- **Don't drop handheld machines** or lower them to the floor by the cable or airline. The weight of the machine can cause the grinding disc to easily crack if it is put down with too much force. This is a common cause of disc breakage. When grinding with a depressed centre grinding disc, maintain an angle of more than 20° to the workpiece.
- Use the machine only in a position where you have full control and are well balanced.

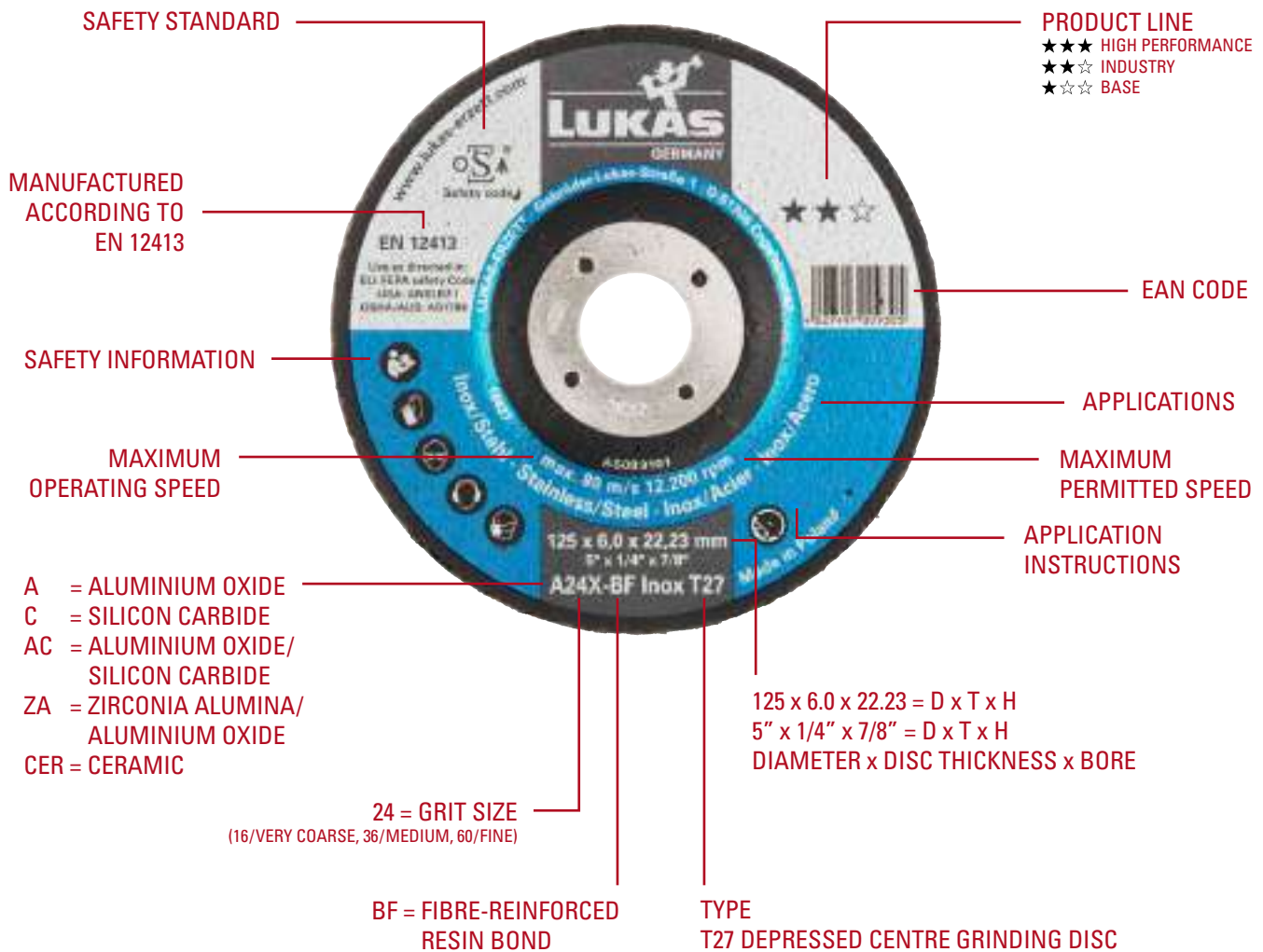
CLAMPING SYSTEM

The use of flanges with different diameters is not permitted. Both flanges between which the bonded abrasive is mounted must have the same outer diameter and similar contact areas (according to EN 60745-2-3:2007 and ANSI B.7.1).

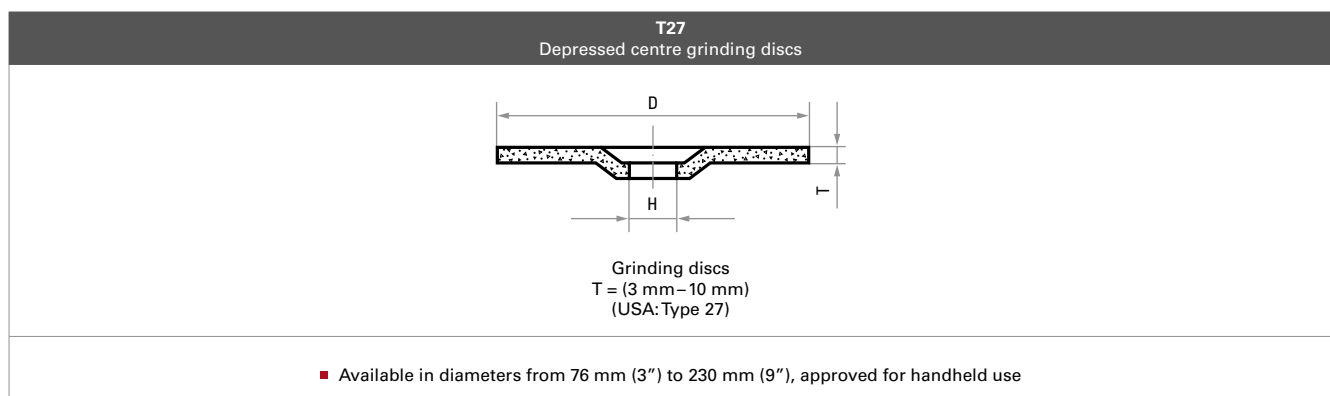


LABELLING

All important markings on the label



TYPES OF RESIN-BONDED GRINDING DISCS



AREA OF USE

Overview of types of LUKAS grinding discs

Type	Product line	Material				
		Inox/Steel	Steel	Aluminium	Stone/ Construction material	Cast material
Handheld grinding discs for angle grinders 	★★★	 Pages 275 and 276	 Page 278			
	★★☆	 Page 277	 Page 278	 Page 280	 Page 281	 Page 281
	★☆☆		 Page 279			
Diamond cup wheels for angle grinders 	★★☆				 Page 282	
Tungsten carbide granulate-tipped disc for angle grinders 	★★☆				 Page 283	

THE PERFECT ALTERNATIVE TO THE GRINDING DISC: THE **iQ-SERIES FLAP DISK** FROM LUKAS! GO TO **PAGES 134–151** AND TEST THEM NOW!

MAXIMUM PERFORMANCE AND COOL REMOVAL

EFFICIENTLY MACHINE EVEN THE HARDEST MATERIALS

The LUKAS grinding discs with ceramic grain are perfectly suited for highly productive machining of steels. Thanks to the fast but cool cutting, they can machine inox without any blue discolouration and have an exceptional tool life due to the self-sharpening effect. In addition, these require only little effort during use. The low applied grinding pressure also contributes to low operating temperatures.

EXTREME TOOL LIFE DUE TO SELF-SHARPENING EFFECT

The high-performance grinding discs consist of ceramic grain that constantly releases extremely fine particles in use. When

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

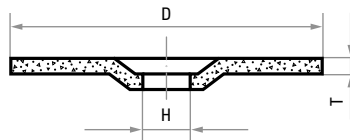
AGGRESSIVE REMOVAL WITH LITTLE FINISHING WORK

Hard materials like Inox and steel can be machined with high productivity with the ceramic grain. In the process, the tool achieves an impressive surface quality for grinding discs – allowing you to get the desired finish quickly. Thanks to its long tool life based on the self-sharpening effect, the LUKAS ceramic grinding disc is also economical.

ROUGH GRINDING



- extremely hard and sharp for an impressively long tool life
- energy optimised for the highest performance angle grinders
- little force required
- cool removal



Ceramic grinding disc **NEW**



★★★

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AS008321V9802	T27 115x7.0	CER 30Q-BF Inox	115	7.0	22.23	13,300	25
AS008322V9802	T27 125x7.0	CER 30Q-BF Inox	125	7.0	22.23	12,200	25
AS008324V9802	T27 180x7.0	CER 30Q-BF Inox	180	7.0	22.23	8,500	25
AS008325V9802	T27 230x7.0	CER 30Q-BF Inox	230	7.0	22.23	6,600	25

Recommended for: ● Inox/Steel ● Steel ● Titanium



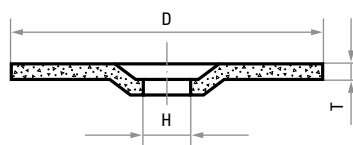
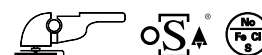
LUKAS GRINDING DISCS IN 3-STAR QUALITY

EXCELLENT QUALITY FOR TOP GRINDING PERFORMANCE

Thanks to innovative press technology and the highest quality raw materials, 3-star LUKAS grinding discs achieve the ultimate results. The minimum wear of 3-star quality noticeably reduces odours and dust, thus improving working conditions. Energy and ergonomically optimised for powerful machines, 3-star grinding discs make work quicker and easier. A high-strength fibreglass fabric guarantees high lateral stability and safety. Eco-friendly production combined with first-class raw materials, optimised formulas and the state-of-the-art production processes provide for high quality and a maximum storage time.

- maximum tool life and grinding performance with innovative bonding technology
- high maximum speed at a cool grinding temperature
- low odour and dust levels in daily use
- ergonomic work position and maximum tool life without use of excessive force
- maximum shelf life with high levels of stability in quality owing to top quality raw materials
- energy optimised for your high performance angle grinders
- environmentally friendly manufacturing process using up-to-date manufacturing processes and optimised formulas
- perfect for a wide variety of Inox and steel materials

Grinding disc for machining stainless steel



- perfectly suited for grinding a wide variety of stainless steel and steel materials
- free of iron, chlorine and sulphur
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomical working with little use of force

★★★

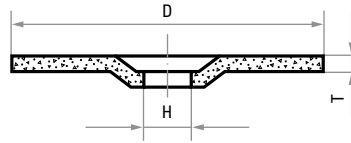
Product number	Description	Quality	D mm	T mm	H mm	n_{max} rpm	Pack contains
AS013491V9802	T27 115x7.0	A24U-BF Inox	115	7.0	22.23	13,300	10
AS013492V9802	T27 125x7.0	A24U-BF Inox	125	7.0	22.23	12,200	10
AS013496V9802	T27 230x7.0	A24U-BF Inox	230	7.0	22.23	6,600	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium



Grinding disc for machining stainless steel

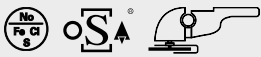
- perfectly suited for grinding a wide variety of stainless steel and steel materials
- free of iron, chlorine and sulphur
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows ergonomical working with little use of force



★★☆

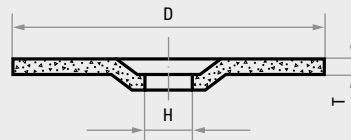
Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AS003100V9802	T27 115x6.0	A24X-BF Inox	115	6.0	22.23	13,300	10
AS003101V9802	T27 125x6.0	A24X-BF Inox	125	6.0	22.23	12,200	10
AS003103V9802	T27 180x6.0	A24X-BF Inox	180	6.0	22.23	8,500	10
AS003104V9802	T27 230x6.0	A24X-BF Inox	230	6.0	22.23	6,600	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium



Grinding disc for machining stainless steel

- perfectly suited for grinding a wide variety of stainless steel and steel materials
- free of iron, chlorine and sulphur
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomical working with little use of force



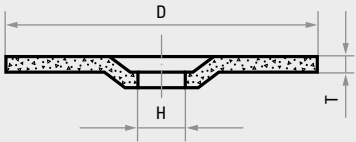
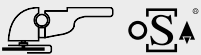
★★☆

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AS002037V9802	T27 100x6.0	A24/30S-BF Inox	100	6.0	16.00	15,300	10
AS000105V980201	T27 115x6.0	A24/30S-BF Inox	115	6.0	22.23	13,300	10
AS000106V980201	T27 125x6.0	A24/30S-BF Inox	125	6.0	22.23	12,200	10
AS000107V9802	T27 150x6.0	A24/30S-BF Inox	150	6.0	22.23	10,200	10
AS000108V9802	T27 180x6.0	A24/30S-BF Inox	180	6.0	22.23	8,500	10
AS000109V9802	T27 230x6.0	A24/30S-BF Inox	230	6.0	22.23	6,600	10

Recommended for: ● Inox/Steel ● Steel



Grinding disc for machining steel



- optimised for precise machining of steel
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomical working with little use of force

★★★

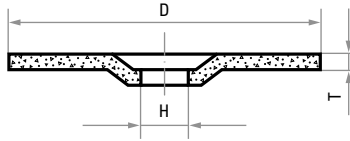
Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AS012451V9802	T27 115x7.0	A24X-BF Steel	115	7.0	22.23	13,300	10
AS012453V9802	T27 125x7.0	A24X-BF Steel	125	7.0	22.23	12,200	10
AS012466V9802	T27 180x7.0	A24X-BF Steel	180	7.0	22.23	8,500	10
AS012468V9802	T27 230x7.0	A24X-BF Steel	230	7.0	22.23	6,600	10

Recommended for: ● Steel



Grinding disc for machining steel

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



★★☆

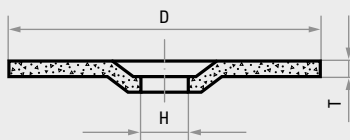
Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AS001679V9802	T27 115x6.0	A24/30T-BF Steel	115	6.0	22.23	13,300	10
AS001710V9802	T27 125x6.0	A24/30T-BF Steel	125	6.0	22.23	12,200	10
AS001811V9802	T27 230x6.0	A24/30T-BF Steel	230	6.0	22.23	6,600	10

Recommended for: ● Steel



Grinding disc for machining steel

- designed for easy machining of steel
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomical working with little use of force



★★☆

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AS000667V9802	T27 115x6.0	A24/30S-BF Steel	115	6.0	22.23	13,300	10
AS000690V9802	T27 125x4.0	A24/30S-BF Steel	125	4.0	22.23	12,200	10
AS000692V9802	T27 125x6.0	A24/30S-BF Steel	125	6.0	22.23	12,200	10
AS000712V9802	T27 150x6.0	A24/30S-BF Steel	150	6.0	22.23	10,200	10
AS000737V9802	T27 180x7.0	A24/30S-BF Steel	180	7.0	22.23	8,500	10
AS000762V9802	T27 230x6.0	A24/30S-BF Steel	230	6.0	22.23	6,600	10

Recommended for: ● Steel

MACHINE SOFT LIGHT METALS TROUBLE-FREE

DESIGNED FOR PERFECTLY MACHINING ALUMINIUM

Aluminium and other non-ferrous metals are difficult to machine – especially because they are so soft. The LUKAS grinding disc for aluminium and non-ferrous metals machines light and non-ferrous metals without interruption.

GRINDING ALUMINIUM WITHOUT “SMEARING”

The major advantage of this grinding disc is that the "smearing" effect can be avoided. When machining pure aluminium and soft alloys, soft chips can stick to the aluminium edges if the tool is not designed specifically for this purpose. However, LUKAS grinding discs were developed and tested for aluminium. The special combination of abrasive grain and bonding agent is a reliable means to prevent this undesirable effect.

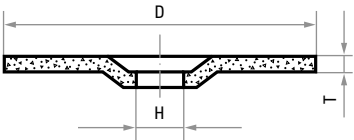
CAN BE USED ON STANDARD MACHINES

This tool can be used on standard angle grinders and is available in different sizes. This allows for light metals to be machined easily and above all with a high level of productivity.



ROUGH GRINDING

NEW Grinding disc for machining non-ferrous metals



★★☆

- for perfectly machining aluminium and non-ferrous metals
- no clogging or smearing
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for economical working with little use of force

Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AS001708V9802	T27 125x7.0	A24N-BF Alu	125	7.0	22.23	12,200	10

Recommended for: ● Aluminium

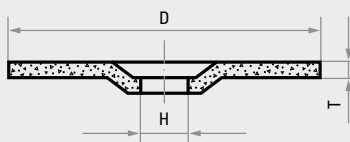
FLEXIBLY GRIND A WIDE RANGE OF BUILDING MATERIALS

ULTIMATE FLEXIBILITY FOR TRADESPEOPLE AND CONSTRUCTION WORKERS



Grinding disc for machining stone **NEW**

- for universal use
- for use on construction sites
- preferable to diamond cutting discs thanks to its excellent value for money and high speed
- low odour and dust levels in daily use
- allows for ergonomic working with little use of force



★★☆

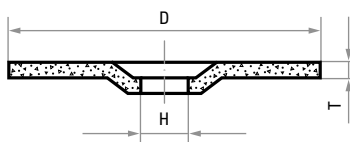
Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AS115060V980201	T27 115x6.0	C24R-BF Stone	115	6.0	22.23	13,300	10
AS125060V980201	T27 125x6.0	C24R-BF Stone	125	6.0	22.23	12,200	10
AS000320V9802	T27 180x6.0	C24R-BF Stone	180	6.0	22.23	8,500	10
AS180080V980201	T27 180x8.0	C24R-BF Stone	180	8.0	22.23	8,500	10

Recommended for: ● Stone ● Cast material



Grinding disc for machining cast material

- for quickly and reliably machining castings with inclusions and surface defects
- tested quality: high level of safety through regular testing
- precise removal with high speed
- low odour and dust levels in daily use
- allows for ergonomic working with little use of force



★★☆

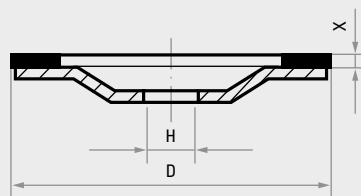
Product number	Description	Quality	D mm	T mm	H mm	n _{max} rpm	Pack contains
AS001711V9802	T27 125x6.0	ZA24R-BF Cast	125	6.0	22.23	12,200	10
AS001773V9802	T27 180x6.0	ZA24R-BF Cast	180	6.0	22.23	8,500	10
AS001812V980201	T27 230x6.0	ZA24R-BF Cast	230	6.0	22.23	6,600	10

Recommended for: ● Cast material

THE DIAMOND CUP WHEEL FOR UNIVERSAL USE

EFFICIENT AND FLEXIBLE GRINDING OF BUILDING MATERIALS

S6 diamond cup wheel



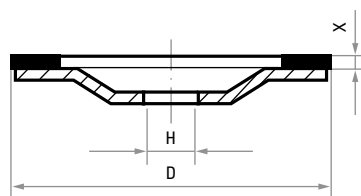
- excellent value for money
- optimised segment arrangement for high grinding performance and clean surfaces
- well suited for: concrete products, building materials (brick, masonry, roof tiles, gas concrete, pumice)
- also suitable for: reinforced concrete, exposed aggregate concrete, dense sand-lime,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

★★☆

Product number	Description	D mm	Segment height X mm	H mm	n _{max} rpm	Pack contains
A344431151506053	DST S6	115	6	22.23	13,300	1
A344431251506053	DST S6	125	6	22.23	12,200	1
A344431801506053	DST S6	180	6	22.23	8,500	1

Recommended for: ● Stone

S5 diamond cup wheel



- the inexpensive cup wheel for many different applications
- suitable for concrete products, building materials (brick, masonry, roof tiles, gas concrete, pumice) and dense sand-lime brick

★★☆

Product number	Description	D mm	Segment height X mm	H mm	n _{max} rpm	Pack contains
A345531151607185	DST S5	115	5	22.23	13,300	1
A345531251607185	DST S5	125	5	22.23	12,200	1

Recommended for: ● Stone

FROM ANIMAL HOOVES TO MACHINING STONE

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

Tungsten carbide granulate-tipped tools (HGW) from LUKAS are available in grit sequences from very coarse to extra fine with dense and open coating. Simply find the grit you require in the illustration below.



APPLICATIONS

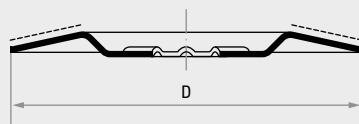
Coarse grit is suitable for machining soft materials. **The harder the material, the finer the required grit.** The LUKAS tungsten carbide granulate-tipped flap disc can be used for many applications. It can be used to roughen rubber (e.g. when repairing conveyor belts), remove residues from cladding or to clean the hooves of horses and cows. It can also be used on glass, ceramic and stone.

The grit of the granulate-tipped disc ranges from extra fine to very coarse, meaning you have the right tool for every application. In addition to the standard products offering, the LUKAS tungsten carbide granulate-tipped disc can be specially coated to meet your needs.



HWGT tungsten carbide granulate-tipped disc

- extremely versatile grinding tool
- perfect as a hoof disc for grinding animal hooves
- also suitable for machining glass, ceramic and stone



Product number	Description	Grit	Shape	Type	D mm	Bore mm	n _{max} rpm	Pack contains
A18031152E	HGWT 115 S	0.8 – 1.2 E		dished	115	22.2	10,500	1
A18031153E	HGWT 115 S	1.2 – 1.8 E		dished	115	22.2	10,500	1
A18031255E	HGWT 125 S	2.5 – 3.0 E		flat	125	22.2	9,600	1

Recommended for: ● Stone/Construction material ● Plastic/Wood



CLEANING

- 7.1 Coarse fleece
- 7.2 Brushes
- 7.3 Rolls and sheets

287/288
289–295
296–298

GENERAL INFORMATION AND PRODUCT INFORMATION

LUKAS BRUSHES, FLEECE AND ABRASIVE CLOTH – ALL YOU NEED FOR CLEANING AND MORE

No matter whether you want to remove wood, car paint or concrete residue or prepare, roughen, derust, debur, clean, polish or texture a wide variety of materials like aluminium, stainless steel, cast material, steel or titanium, at LUKAS you will find the right tool to suit your application. From abrasive paper to cleaning fleece and wire brushes in a wide range of shapes and types, LUKAS offers you the right cleaning tool for construction sites, production lines or your DIY workshop at home.

MACHINE-POWERED CLEANING TOOLS

LUKAS cleaning tools can be used with standard power tools. For instance, you can use the wheel brushes on angle grinders or wire brushes on drilling machines and cordless screwdrivers. The shank dimensions make it easy to fit the brushes into commercially available drilling machines.

LUKAS end brushes let you easily clean even the most inaccessible areas. Depending on the required thickness and elasticity, they are available in both twist-knotted and crimped types.

TOOLS FOR MANUAL USE

In addition to hand wire brushes for cleaning surfaces or finishing weld seams, LUKAS also offers abrasive fleece and paper, both of which are ideal for manually removing old paint from both wood and metal or for cleaning stainless steel. LUKAS abrasive fleece is available in rolls or pads that are perfect for manual use.

AS CLEANING FLEECE

EFFICIENTLY TREAT SURFACES IN A WIDE VARIETY OF MATERIALS

LUKAS AS cleaning fleece consists of a coarse polyamide non-woven material impregnated with high-impact abrasive particles. Thanks to this combination of polyamide non-woven material and hard abrasive particles, LUKAS cleaning fleece is ideal for efficient surface finishing, including removing paint or concrete residue and rust, cleaning, polishing or graining wood. The tool is widely used in the building sector, bodywork and shipbuilding.

With its combination of materials, the cleaning fleece (or disc) offers significant advantages in practical use. Heat generation and the grinding pressure applied are kept to a minimum, ensuring no clogging or damage to workpieces. In practical terms, this means that your cleaning fleece or disc is a tool that you can use efficiently and effectively for a long time to come.

APPLICATION RECOMMENDATIONS

The tools in our AS cleaning fleece range are ideal for the following applications:

- removing paint and adhesive residue
- removing cement and concrete residue
- removing rust, cleaning and polishing a wide variety of surface materials
- graining and cleaning wood
- rust removal and cleaning jobs (e.g. barnacles on boats and ships)
- cleaning car undersides, various vehicle coachbuilding tasks
- cleaning weld seams – before and after welding

PROPERTIES

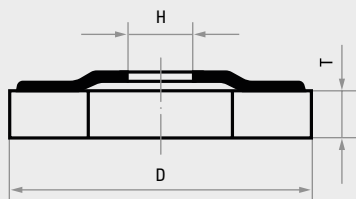
- low heat generation
- operation at low grinding pressure possible
- no clogging
- no damage to workpieces

SAFETY ADVICE

Please adhere to our recommended, never-exceed cutting speeds.



- can be used universally without a backing pad on adjustable or low-speed angle grinders
- the all-rounder for removing paint and adhesive residue, as well as rust removal, cleaning and polishing a wide variety of surface materials
- made of resilient materials for a long service life, high removal rate and fast operation



ASVT flap disc

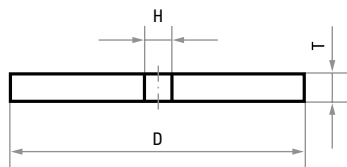
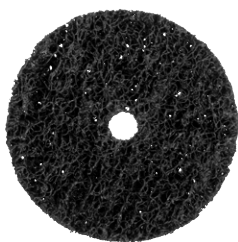


Product number	Description	D mm	T mm	H mm	n recomm. rpm	n max. rpm	Pack contains
A270111500114	ASVT 115	115	13	22.23	5,300	10,500	10
A270112500114	ASVT 125	125	13	22.23	4,900	9,600	10

Recommended for: ● Plastic/Wood ● Titanium ● Aluminium ● Inox/Steel ● Steel ● Cast material

ALSO TRY LUKAS AS CLEANING FLEECE
WITH A PRACTICAL PLASTIC THREAD
FOR FAST TOOL CHANGING ON **PAGE 227**

ASVS grinding disc

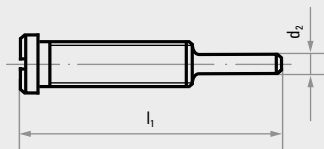


- grinding disc for flexible shaft grinders or drilling machines
- the all-rounder for removing paint and adhesive residue, as well as rust removal, cleaning and polishing a wide variety of surface materials
- made of resilient materials for a long service life, high removal performance and fast operation
- requires only a low grinding pressure

★★☆

Product number	Description	D mm	T mm	H mm	n recomm. rpm	n max. rpm	Matching mounting arbor	Pack contains
A22900601201	ASVS 060	60	13	13	8,000	9,500	ASB 06	10
A22901001201	ASVS 100	100	13	13	5,000	5,700	ASB 06	10
A22901251201	ASVS 125	125	13	13	4,000	4,500	ASB 08	10
A22901501201	ASVS 150	150	13	13	3,000	3,800	ASB 08	10
Recommended for: ● Plastic/Wood ● Titanium ● Aluminium ● Inox/Steel ● Steel ● Cast material								

ASB mounting arbor



- mounting arbor for ASVS grinding discs
- perfect dimensional stability: fits optimally into the power tool
- stainless thanks to zinc-nickel coating
- supplied with spring washers and nuts

★★☆

Product number	Description	Thread	d ₂ mm	l ₁ mm	Pack contains
A1610021007301	ASB 06	M12	6	60	1
A1610021007302	ASB 08	M12	8	60	1

GENERAL INFORMATION AND PRODUCT INFORMATION

LUKAS high-quality technical brushes

FILAMENT QUALITY

High quality steel wire

We use high-quality steel wire with high tensile strength, which ensures an exceptionally long and economical tool life.

Stainless steel wire

This wire is used where residues from normal steel wire would impair surfaces such as stainless steel, aluminium and other non-ferrous metals.

Abrasive impregnated nylon filaments

Abrasive impregnated nylon filaments are very flexible and optimally follow the contour of the workpiece without being too aggressive. During use, new abrasive grains are constantly exposed, thus achieving a consistent performance and long tool life.

TYPES

We supply brushes in both wire qualities with crimped or twist-knotted filaments. Compared to crimped types, brushes with twist-knotted steel wire generally offer a longer tool life and more rugged abrasive performance and are thus suited for extreme requirements. We also supply brushes in high quality crimped steel wire embedded in a resin bond, thus enhancing their performance. These brushes are ideally suited for achieving uniform surfaces and precise edges.

APPLICATIONS

A wide range of jobs can be performed with steel wire brushes. Here are just a few examples: deburring, descaling, derusting, surface cleaning, roughening and paint stripping. Brushes with abrasive impregnated nylon filaments are perfect for removing stains on metal surfaces, graining soft wood, car body repair jobs, stripping off paint residues etc.

WORKING MODE AND POWER TOOLS

Technical brushes are flexible tools that follow the contours of the workpiece. In order to achieve best results, only the tip of the filament should be in contact with the workpiece. Elasticity of the brush depends on the exposed length of the filaments, and in the case of steel wire brushes, on the wire thickness. Brushes with very long filaments are very flexible and should only be used with low pressure. Excessive pressure reduces the life of the brush and results in premature wearing. Technical brushes can be used on stationary and handheld power tools.

OPERATING SPEEDS

Steel wire brushes have a harder effect at higher speeds and a softer effect at low speeds. We recommend the following operating speeds for crimped types to achieve the desired results:

- Machining steel: approx. 30 m/s
- Machining non-ferrous metals: approx. 18 – 20 m/s
- Machining plastic: approx. 15 m/s

Higher operating speeds can be selected for twist knotted types e.g.:

- Machining steel: approx. 40 m/s

Brushes made from nylon filaments achieve best results at operating speeds of 18 to 22 m/s, depending on the material to be machined.

SAFETY ADVICE

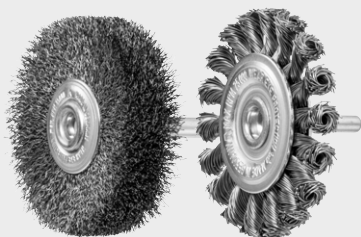
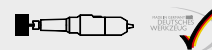
Technical brushes are manufactured according to a rigorous quality control (according to EN 1083-2). However, it is always advisable to wear safety clothing when working with technical brushes.



FLEXIBLE MACHINING OF THE MOST COMPLEX CONTOURS

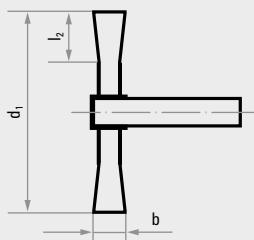
CLEANING METAL SURFACES WITH LUKAS HIGH QUALITY STEEL WIRE

BS wheel brush with shank



crimped

knotted



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

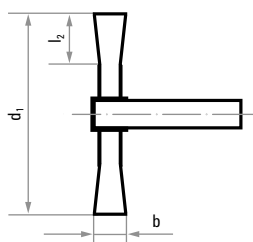
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Product number	Description	Material	Type	d ₁ mm	b mm	l ₂ mm	Wire Ø mm	n _{max} rpm	Pack contains
A35010401011	BSSW 04010	steel	crimped	40	10	9	0.2	18,000	10
A350005026	BSSW 05010	steel	crimped	50	10	12	0.2	15,000	10
A350105014111	BSSW 05014	steel	crimped	50	14	12	0.2	15,000	10
A350006036	BSSW 06018	steel	crimped	60	16	12	0.2	15,000	10
A350106018113	BSSW 06018	steel	crimped	60	19	17	0.3	15,000	10
A350007036	BSSW 07018	steel	crimped	70	16	19	0.2	15,000	10
A350107018113	BSSW 07018	steel	crimped	70	16	19	0.3	15,000	10
A350107508135	BSSZ 07508	steel	knotted	75	12	15	0.5	25,000	10
Recommended for: ● Steel ● Cast material ● Plastic/Wood									
A350107508235	BSVZ 07508	stainless	knotted	75	12	15	0.5	25,000	10
A351004036	BSVW 04011	stainless	crimped	40	11	9	0.2	18,000	10
A350105014211	BSVW 05014	stainless	crimped	50	14	12	0.2	15,000	10
A351006036	BSVW 06018	stainless	crimped	60	16	17	0.2	15,000	10
A350107018213	BSVW 07018	stainless	crimped	70	16	19	0.3	15,000	10
A351007036	BSVW 07018	stainless	crimped	70	16	19	0.2	15,000	10
Recommended for: ● Inox/Steel ● Steel ● Titanium									



BSN wheel brush

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



★★☆

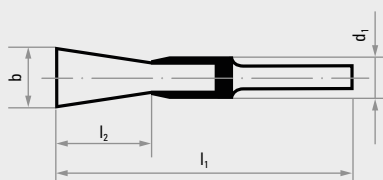
Product number	Description	Type	d ₁ mm	b mm	l ₂ mm	n _{max} rpm	Pack contains
A350105010048	BSNG 05010	coarse	50	10	12	15,000	10
A350105010049	BSNF 05010	fine	50	10	12	15,000	10
A350107012048	BSNG 07012	coarse	70	12	20	15,000	10
A350107012049	BSNF 07012	fine	70	12	20	15,000	10
A350110007048	BSNG 10007	coarse	100	8	22	4,500	10
A350110008050	BSNF 10008	fine	100	8	22	4,500	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Titanium ● Plastic/Wood



BP end brush

- flexibly withstands the toughest challenges
- for deburring, descaling, derusting, surface cleaning, roughening and paint stripping
- made of high-quality steel wire with high tensile strength
- "Stainless" quality is used where residues from normal steel wire would impair surfaces such as stainless steel, aluminium and other non-ferrous metals.
- shank diameter: 6 mm



crimped



knotted

★★☆

Product number	Description	Material	Type	d ₁ mm	b mm	l ₂ mm	l ₁ mm	Wire Ø mm	n _{max} rpm	Pack contains
A350101006	BPSW 01020	steel	crimped	10	10	20	60	0.3	20,000	10
A350101506	BPSW 01725	steel	crimped	16	17	22	65	0.3	20,000	10
A350502029134	BPSZ 02029	steel	knotted	19	20	28	72	0.35	20,000	10
A350102206	BPSW 02525	steel	crimped	22	25	25	68	0.3	18,000	10
A350502329134	BPSZ 02329	steel	knotted	22	23	28	72	0.35	20,000	10
A350102806	BPSW 03025	steel	crimped	29	30	25	68	0.3	18,000	10

Recommended for: ● Steel ● Cast material ● Plastic/Wood

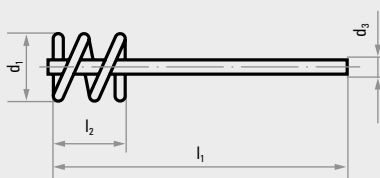
A351101006	BPVW 01020	stainless	crimped	10	10	20	60	0.3	20,000	10
A351101506	BPVW 01725	stainless	crimped	16	17	22	65	0.3	20,000	10
A350502029232	BPVZ 02029	stainless	knotted	19	20	28	72	0.25	20,000	10
A351102206	BPVW 02525	stainless	crimped	22	25	25	68	0.3	18,000	10
A351102806	BPVW 03025	stainless	crimped	29	30	25	68	0.3	18,000	10

Recommended for: ● Inox/Steel ● Steel ● Titanium

EASILY DEBURR EVEN SMALL BORES

LUKAS PIPE BRUSHES WITH STEEL WIRE OR NYLON FILAMENTS

RBSD pipe brush



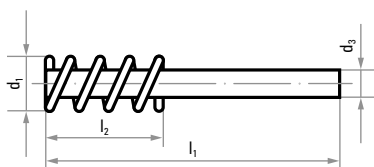
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- brush with steel wire filaments
- deburring of bores, cross-holes and O-ring grooves
- polishing and cleaning of nozzles, small and threaded bores

Product number	Description	Material	Type	d ₁ mm	l ₂ mm	d ₃ mm	l ₁ mm	Wire Ø mm	n _{max} rpm	Pack contains
A359901025	RBSD 1025	steel	crimped	10	25	3.8	90	0.12	2,000	10
A359901325	RBSD 1325	steel	crimped	13	25	3.8	90	0.12	2,000	10
A359901625	RBSD 1625	steel	crimped	16	25	3.8	90	0.12	2,000	10
A359902525	RBSD 2525	steel	crimped	25	25	3.8	90	0.2	2,000	10

Recommended for: ● Steel ● Cast material ● Plastic/Wood

RBSN pipe brush

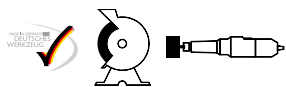


★★☆

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

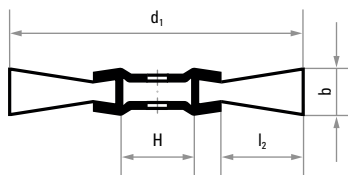
Product number	Description	Material	d ₁ mm	l ₂ mm	d ₃ mm	l ₁ mm	Wire Ø mm	n _{max} rpm	Pack contains
A359901065120	RBSN 1065	C 120	10	65	3.7	125	0.6	2,000	10
A359901365120	RBSN 1365	C 120	13	65	3.7	125	0.6	2,000	10
A359901665120	RBSN 1665	C 120	16	65	5.2	125	0.6	2,000	10
A359902565120	RBSN 2565	C 120	25	65	5.5	125	0.6	2,000	10

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Titanium ● Plastic/Wood



BR wheel brush, crimped

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



The following bores can be accommodated:

- brushes with a bore diameter of H 40 mm:
40 mm, 32 mm, 1", 22.23 mm, 20 mm,
16 mm, 1/2"
- brushes with a bore diameter of H 50 mm:
50 mm, 32 mm, 1", 22.23 mm, 20 mm,
16 mm, 1/2"

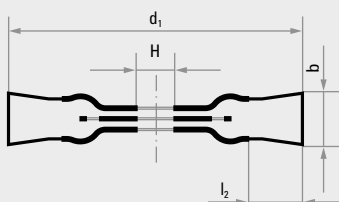
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Product number	Description	Material	Type	d ₁ mm	b mm	H mm	l ₂ mm	Wire Ø mm	n _{max} rpm	Pack contains
A350315022114	BRSW 15022	steel	crimped	150	22	40	33	0.35	6,000	1
A350320024114	BRSW 20024	steel	crimped	200	24	50	48	0.35	6,000	1
Recommended for: ● Steel ● Cast material										
A350315023213	BRVW 15023	stainless	crimped	150	23	50	33	0.3	6,000	1
Recommended for: ● Inox/Steel ● Steel ● Titanium										



BR wheel brush, knotted

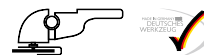
- designed for extreme brush requirements
- can be used on commercially available angle grinders
- for deburring, descaling, derusting, surface cleaning, roughening and paint stripping
- made of high-quality steel wire with high tensile strength
- "Stainless" quality is used where residues from normal steel wire would impair surfaces such as stainless steel, aluminium and other non-ferrous metals.



★★☆

Product number	Description	Material	Type	d ₁ mm	b mm	H mm	l ₂ mm	Wire Ø mm	n _{max} rpm	Pack contains
A350211512135	BRSZ 11512	steel	knotted	115	14	22.23	20	0.5	12,500	1
A350312514135	BRSZ 12514	steel	knotted	125	14	22.23	20	0.5	12,500	1
A350317814135	BRSZ 17814	steel	knotted	178	14	22.23	32	0.5	9,000	1
Recommended for: ● Steel ● Cast material										
A350211512234	BRVZ 11512	stainless	knotted	115	14	22.23	20	0.35	12,500	1
A350312514235	BRVZ 12514	stainless	knotted	125	14	22.23	20	0.5	12,500	1
Recommended for: ● Inox/Steel ● Steel ● Titanium										

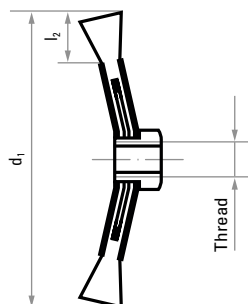
BK conical brush



crimped

knotted

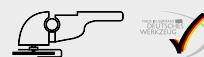
★★☆



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

Product number	Description	Material	Type	d ₁ mm	b mm	l ₂ mm	Thread	Wire Ø mm	n _{max} rpm	Pack contains
A350610012114	BKSW 10012	steel	crimped	100	10	20	M14	0.35	12,500	1
A350610013135	BKSZ 10013	steel	knotted	100	13	20	M14	0.5	12,500	1
Recommended for: ● Steel ● Cast material										
A350610012213	BKVW 10012	stainless	crimped	100	10	20	M14	0.3	12,500	1
A350610013235	BKVZ 10013	stainless	knotted	100	13	20	M14	0.5	12,500	1
Recommended for: ● Inox/Steel ● Steel ● Titanium										

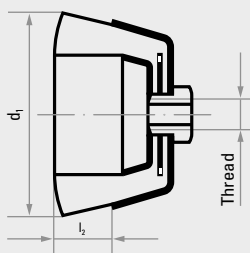
BTG cup brush



crimped

knotted

★★☆



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

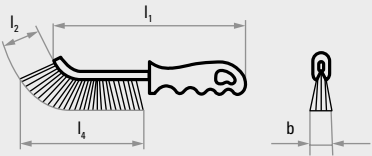
Product number	Description	Material	Type	d ₁ mm	l ₂ mm	Thread	Wire Ø mm	n _{max} rpm	Pack contains
A350406020114	BTSW 06020 G	steel	crimped	60	20	M14	0.35	12,000	1
A350406520135	BTSZ 06520 G	steel	knotted	65	20	M14	0.5	12,500	1
A350408020135	BTSZ 08020 G	steel	knotted	80	20	M14	0.5	9,000	1
A350408025114	BTSW 08025 G	steel	crimped	80	25	M14	0.35	8,500	1
A350410030114	BTSW 10030 G	steel	crimped	100	30	M14	0.35	9,000	1
Recommended for: ● Steel ● Cast material									
A350406021213	BTWV 06021 G	stainless	crimped	60	20	M14	0.3	12,000	1
A350406520234	BTWV 06520 G	stainless	knotted	65	20	M14	0.35	12,500	1
Recommended for: ● Inox/Steel ● Steel ● Titanium									

FLEXIBLE HAND BRUSH FOR UNIVERSAL USE

FOLLOWS EVERY CONTOUR FROM COOKING GRATES TO COMPLEX WORKPIECES



- for universal use
- follow the contours of every workpiece thanks to their flexibility
- perform a wide variety of manual jobs such as deburring, descaling, derusting, surface cleaning, roughening and paint stripping
- made of high-quality steel wire with high tensile strength
- “Stainless” quality is used where residues from normal steel wire would impair surfaces such as stainless steel, aluminium and other non-ferrous metals.



BHU, hand brushes for universal use



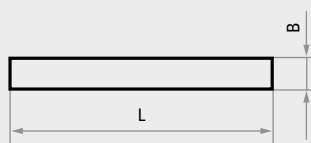
★★☆

Product number	Description	Material	b mm	l ₂ mm	l ₁ mm	l ₄ mm	Wire Ø mm	Pack contains
A350726525113	BHUS 26528	steel	15	28	265	130	0.35	1
Recommended for: ● Steel ● Cast material								
A350726525213	BHUV 26525	stainless	15	28	265	130	0.3	1
Recommended for: ● Inox/Steel ● Steel ● Titanium								

FLEXIBLE REWORKING

LUKAS ECONOMY ROLLS WITH REGULAR ALUMINIUM OXIDE FOR EVERY CONTOUR

SPR economy roll, abrasive material



- for practical manual reworking
- LUKAS economy rolls with their excellent grinding properties help you to optimise manual grinding tasks.

★★☆

Product number	Description	Grit	Width B mm	Length L m	Pack contains
A3821025040	SPR 025	NK 40	25	50	1
A3821025060	SPR 025	NK 60	25	50	1
A3821025080	SPR 025	NK 80	25	50	1
A3821025100	SPR 025	NK 100	25	50	1
A3821025120	SPR 025	NK 120	25	50	1
A3821025150	SPR 025	NK 150	25	50	1
A3821025180	SPR 025	NK 180	25	50	1
A3821025240	SPR 025	NK 240	25	50	1
A3821025320	SPR 025	NK 320	25	50	1
A3821025400	SPR 025	NK 400	25	50	1
A3821040040	SPR 040	NK 40	40	50	1
A3821040060	SPR 040	NK 60	40	50	1
A3821040080	SPR 040	NK 80	40	50	1
A3821040100	SPR 040	NK 100	40	50	1
A3821040120	SPR 040	NK 120	40	50	1
A3821040150	SPR 040	NK 150	40	50	1
A3821040180	SPR 040	NK 180	40	50	1
A3821040240	SPR 040	NK 240	40	50	1
A3821040320	SPR 040	NK 320	40	50	1
A3821040400	SPR 040	NK 400	40	50	1

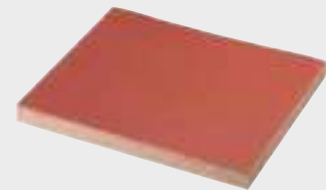
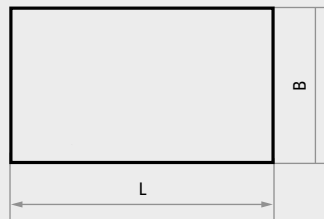
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

PERFECT SURFACES

USE LUKAS SHEETS OF ABRASIVE CLOTH FOR MANUAL OPTIMISATION



SLB sheets of abrasive cloth



- for practical manual reworking
- LUKAS sheets of abrasive cloth with their excellent grinding properties help you to optimise manual grinding tasks.

★★☆

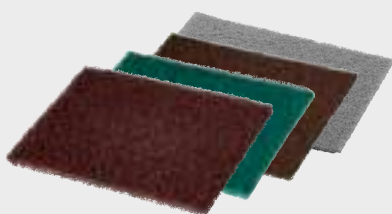
Product number	Description	Grit	Width B mm	Length L m	Pack contains
A3825230280040	SLB 230280	NK 40	230	280	50
A3825230280060	SLB 230280	NK 60	230	280	50
A3825230280080	SLB 230280	NK 80	230	280	50
A3825230280100	SLB 230280	NK 100	230	280	50
A3825230280120	SLB 230280	NK 120	230	280	50
A3825230280150	SLB 230280	NK 150	230	280	50
A3825230280180	SLB 230280	NK 180	230	280	50
A3825230280220	SLB 230280	NK 220	230	280	50
A3825230280240	SLB 230280	NK 240	230	280	50
A3825230280320	SLB 230280	NK 320	230	280	50
A3825230280400	SLB 230280	NK 400	230	280	50
A3825230280999	SLB 230280	NK 1000	230	280	50

Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium

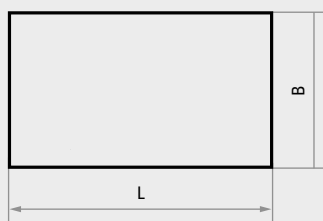
FROM MEDIUM TO ULTRA-FINE

ACHIEVE THE DESIRED SURFACE QUALITY QUICKLY AND EASILY

SVB fleece pads



★★☆



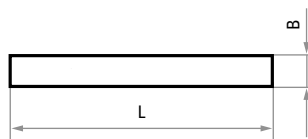
- for practical manual reworking
- LUKAS fleece pads are ideal for removing corrosion and surface staining and for cleaning, polishing and finishing all kinds of materials.

Product number	Description	Quality	Type	Width B mm	Length L m	Pack contains
A380115023011	SVB 150230	A Medium	red-brown	150	230	10
A380115023012	SVB 150230	A Fine	green	150	230	10
A380115023013	SVB 150230	A Very Fine	red-brown	150	230	10
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium						
A380115023024	SVB 150230	C Ultra Fine	grey	150	230	10
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium						

SVR fleece roll



★★☆



- for practical manual reworking
- LUKAS fleece rolls are ideal for removing corrosion and surface staining and for cleaning, polishing and finishing all kinds of materials.

Product number	Description	Quality	Type	Width B mm	Length L m	Pack contains
A382011501012	SVR 115	A Fine	green	115	10	1
A382011501013	SVR 115	A Very Fine	red-brown	115	10	1
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium						
A382011501024	SVR 115	C Ultra Fine	grey	115	10	1
Recommended for: ● Inox/Steel ● Steel ● Aluminium ● Cast material ● Plastic/Wood ● Titanium						