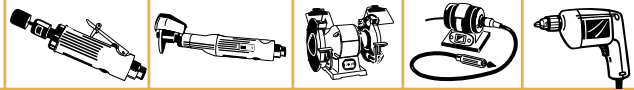


## NON-WOVEN WHEELS

### MACHINES USED



### CATEGORY DEFINITION

Made from non-woven synthetic fiber mesh, which is impregnated with abrasives and bound with resins, non-woven wheels are designed to create desired surface finish where little or no stock removal is required. The industry's broadest offering is available for light stock removal, deburring, blending, finishing and polishing.

Non-woven wheels have an open mesh construction that is waterproof, washable, conformable and non-loading.

**APPLICATIONS:** Cleaning and removing imperfections on metal surfaces, cleaning built-up residue, deburring or finishing a variety of surfaces, blending weld seams or creating decorative finishes. Non-woven surface finishing products have excellent versatility.

**ABRASIVE GRAIN:** Aluminum Oxide, Silicon Carbide

**GRIT RANGE:** Extra Coarse (XC), Coarse (C), Medium (M), Fine (F),



### APPLICATION/GRIT RECOMMENDATION GUIDE

	MOST AGGRESSIVE							LEAST AGGRESSIVE	
<b>NORTON</b>	RAPID STRIP WHEELS	RAPID BLEND UNIFIED WHEELS	SERIES 4000 & 1000 CONVOLUTE WHEELS	METAL FINISHING CONVOLUTE WHEELS	CLEAN & FINISH CONVOLUTE WHEELS	LIGHT FINISHING CONVOLUTE WHEELS	NON-WOVEN / INTERLEAF FLAP WHEELS		
SCALE REMOVAL	BEST CHOICE								
STOCK REMOVAL		BEST CHOICE		2ND CHOICE					
HEAVY DEBURRING		BEST CHOICE		2ND CHOICE					
DECORATIVE FINISHING				BEST CHOICE		2ND CHOICE			
BLENDING				BEST CHOICE		2ND CHOICE			
CLEANING				2ND CHOICE		BEST CHOICE			
LIGHT DEBURRING				2ND CHOICE				BEST CHOICE	
LIGHT FINISHING				2ND CHOICE				BEST CHOICE	
POLISHING								BEST CHOICE	
								2ND CHOICE	
BUFFING								BEST CHOICE	

### SURFACE FINISH VARIABLES

Changes in any one of many factors can affect the surface finish on the workpiece. This chart shows the effect on surface finish by changes in single factors of product specifications. Arrows have been used to signify the trend direction. The arrow length does not signify that the effect of each factor is equal.

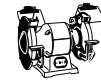
Variable Factor	Rough Finish High Rms Reading	Smooth Surface Lower Rms Reading
<b>1. Wheel Speed</b>	Slow	Fast
<b>2. Feed Speed</b>	Faster (Long Scratch)	Slower (Short Scratch)
<b>3. Oscillation</b>	No Oscillation	Oscillation
<b>4. Lubricants</b>	Dry	Water
	Soluble Oil	Straight Oil
	Compounds	

### NON-WOVEN MARKING SYSTEM

<b>ABRASIVE</b>	S/C			A/O
	SHARPER, FINER/BRIGHTER SCRATCH PATTERN		MORE DURABLE, LONGER LASTING, POLISHED FINISH	
<b>GRIT SIZE</b>	XC (24-36)	C (50-80)	M (100-150)	F (180-220)
	FASTER, AGGRESSIVE CUT, ROUGHER FINISH		REDUCED CUT RATE, FINER FINISH	
<b>DENSITY</b>	2			9
	SOFT, OPEN, CONFORMABLE, LESS BURNING/LOADING		HARDER, MORE DURABLE, FASTER CUTTING, BETTER FINISH	

## NON-WOVEN CONVOLUTE WHEELS

MACHINES USED



### Convolute Wheels

Formed by wrapping and bonding web material impregnated with abrasive grain and resin around a center core. Convolute wheels offer a wide range of uses:

- Burr and flashing removal
- Surface roughness reduction
- Blending weld areas on stainless steel
- Blending scratch patterns
- Weld polishing
- Removing rust and oxides
- Applying decorative finishes including antique patterns

## TECHtip

- Convolute wheels must always run in the direction indicated by the arrow printed on the side of each wheel.
- Light to medium pressure is recommended. Excessive pressure may result in part damage.
- Lubricants such as water-soluble oil and straight oil will decrease the heat and improve the surface finish and lustre.



It is the user's responsibility to refer to and comply with all safety regulations.

## FEATURED PRODUCTS



### SERIES 4000 RAPID FINISH CONVOLUTE WHEELS BEST CHOICE FOR HEAVY DEBURRING APPLICATIONS

#### FEATURES

- Advanced resin bond system
- High quality synthetic web

#### BENEFITS

- Free cutting
- Use both wet and dry
- Long life for heavy deburring, edge breaking and removing parting lines on exotic metals

### AVAILABILITY

TIER: **BEST**  
BRAND: Norton

TRADENAME: **SERIES 4000 RAPID FINISH CONVOLUTE WHEELS**

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	8 DENSITY PART #	9 DENSITY PART #
<b>Series 4000 Rapid Finish Convolute Wheels</b>						
6 x 1/2 x 1	S/C	F	6,000	4		66261004021
6 x 1 x 1	A/O	M	6,000	3	66261004208	
	S/C	F	6,000	3	66261004142	66261004141
8 x 1 x 3	A/O	M	4,500	3	66261004165	
	S/C	F	4,500	3	66261004123	66261004135
12 x 1 x 5	S/C	F	3,000	2	66261004284	66261004148
12 x 2 x 5	S/C	F	3,000	1		66261004011



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