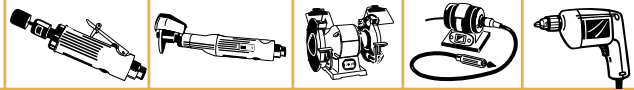


NON-WOVEN WHEELS

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			
NORTON	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.

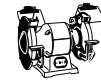
Variable Factor	Rough Finish High Rms Reading	Smooth Surface Lower Rms Reading
1. Wheel Speed	Slow	Fast
2. Feed Speed	Faster (Long Scratch)	Slower (Short Scratch)
3. Oscillation	No Oscillation	Oscillation
4. Lubricants	Dry	Water
	Soluble Oil	Straight Oil
	Compounds	

NON-WOVEN MARKING SYSTEM

ABRASIVE	S/C			A/O
	SHARPER, FINER/BRIGHTER SCRATCH PATTERN		MORE DURABLE, LONGER LASTING, POLISHED FINISH	
GRIT SIZE	XC (24-36)	C (50-80)	M (100-150)	F (180-220)
	FASTER, AGGRESSIVE CUT, ROUGHER FINISH		REDUCED CUT RATE, FINER FINISH	
DENSITY	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**

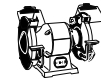
SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	8 DENSITY PART #	9 DENSITY PART #
Series 4000 Rapid Finish Convolute Wheels						
6 x 1/2 x 1	S/C	F	6,000	4		66261004021
6 x 1 x 1	A/O	M	6,000	3	66261004208	
	S/C	F	6,000	3	66261004142	66261004141
8 x 1 x 3	A/O	M	4,500	3	66261004165	
	S/C	F	4,500	3	66261004123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



BEAR-TEX®

NON-WOVEN CONVOLUTE WHEELS

MACHINES USED



Convolute Wheels CONTINUED



METAL FINISHING CONVOLUTE WHEELS

BEST CHOICE FOR DECORATIVE FINISHING, BLENDING, AND FINAL FINISHING

FEATURES

- Premium, medium grit aluminum oxide grain
- Dense, very durable web
- Strongest resin binders
- Uniform grain dispersion and coating
- Available in 5 and 6 densities

BENEFITS

- Generates uniform distinct satin and antique finishes
- Can be used for blending applications
- Resilient, long life construction
- Clean and condition without gouging or changing dimensions of workpiece
- Ideal for blending and matching #3 and 4 mil. finishes, and surface prep for buffing, polishing and applying decorative finishes

AVAILABILITY

TIER: **BEST**

BRAND: Norton

TRADENAME: **METAL FINISHING CONVOLUTE WHEELS**

SIZE (D x T x H)	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #
Metal Finishing Convolute Wheels						
6 x 1 x 1	A/O	M	5	6,000	3	66261007936
		M	6	6,000	3	66261010148
6 x 2 x 1	A/O	M	5	6,000	2	66261007957
		M	6	6,000	2	66261009635
8 x 1 x 3	A/O	M	5	4,500	3	66261007831
8 x 2 x 3	A/O	M	5	4,500	2	66261007904
		M	6	4,500	2	66261012971
12 x 1 x 5	A/O	M	5	3,000	2	66261007434
		M	6	3,000	2	66261009481
12 x 2 x 5	A/O	M	5	3,000	1	66261007212
14 x 2 x 8	A/O	M	5	2,550	1	66261007817
		M	6	2,550	1	66261012041



CLEAN & FINISH CONVOLUTE WHEELS

BEST CHOICE FOR FINE FINISHING WITH LIGHT PRESSURE

FEATURES

- Silicon carbide grain
- Open mesh construction

BENEFITS

- Good for blending, rust removal, applying decorative, contrast finishes and low- to moderate-speed applications
- Not used for deburring
- Used with light to moderate pressure, low speed

AVAILABILITY

TIER: **BEST**

BRAND: Norton

TRADENAME: **CLEAN & FINISH CONVOLUTE WHEELS**

SIZE (D x T x H)	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #
Clean & Finish Convolute Wheels						
4 x 1 x 1	S/C	M	4	4,000	10	66261058502
		F	4	4,000	10	66261058501
6 x 1 x 1	S/C	M	4	3,000	4	66261058507
		F	4	3,000	4	66261058506
6 x 2 x 1	S/C	M	4	3,000	2	66261058510
		F	4	3,000	2	66261058509
6 x 3 x 1	S/C	M	4	3,000	1	66261058512
6 x 4 x 1	S/C	M	4	3,000	1	66261058514
8 x 1 x 3	S/C	M	4	2,500	3	66261058518
8 x 2 x 3	S/C	M	4	2,500	2	66261058521
8 x 3 x 3	S/C	M	4	2,500	1	66261058524
8 x 4 x 3	S/C	M	4	2,500	1	66261058526

