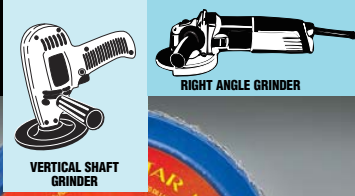


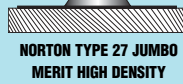
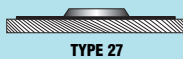
FLAP DISCS



Our flap discs are engineered for light stock removal, blending and finishing all in one application. They grind like a depressed center wheel and finish like a fiber disc to reduce process time and lower total grinding costs.

Typical Applications

- Stock removal
- Deburring
- Blending welds
- Edge chamfering
- Rust removal
- Cleaning and finishing



BEST Norton SG Blaze R980 – Longest life, coolest cut rate

FEATURES	BENEFITS
• Next generation SG ceramic abrasive grain	• Last 50% – 200% longer than any flap discs on stainless steel, cobalt, chrome, Inconel, titanium and other hard-to-grind materials
• Improved Y-wt polyester cloth	• Significantly improves life, grain retention and fray resistance
• Supersized grinding aid	• Cool, noticeably fast cut rate
• Durable fiberglass back	• Quick stock removal and long life
• Type 29 conical shape	• Maximum contact with workpiece without loading
• Type 27 flat face	• Fine finishing primarily on flat surfaces



BEST TwinFiber – Aggressive stock removal

FEATURES	BENEFITS
• Premium ceramic and zirconia alumina abrasive blend	• Excellent performance and efficiencies on stainless steel applications
• Durable, fiberglass back	• Less pressure for aggressive stock removal; long life
• Type 29 angled face, conical shape	• Maximum contact with work surface without loading
• 4-1/2" and 7" with 5/8"-11 hub	• Less downtime for disc changes
• 6" with 7/8" hole	• Support increasing volume of 6" tools



BEST TwinStar – Fine finishes

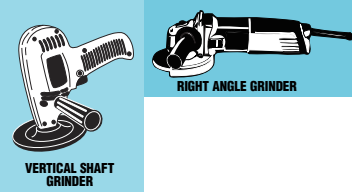
FEATURES	BENEFITS
• Premium ceramic and zirconia alumina abrasive blend	• Excellent performance and efficiencies on stainless steel applications
• Type 27 – flat face; plastic back	• Plastic wears away with abrasive – for longer life • More forgiving than Type 29 – producing smooth finishes
• 4-1/2" and 7" with 5/8"-11 hub	• Less downtime for disc changes
• 4" with 5/8" hole	• Support increasing volume of smaller tools



BETTER Charger R822 – Versatile; high performance

FEATURES	BENEFITS
• High performance zirconia alumina abrasive	• Aggressive cut and long life • Up to 30% longer life than aluminum oxide products
• Durable, fiberglass back	• Less pressure for aggressive stock removal and long life





GOOD Merit Zirconia – Ideal, general purpose flap disc

FEATURES

- Quality zirconia alumina grain with a phenolic resin back

BENEFITS

- Fast cutting; fine finishes
- Great value for MRO operations



SPECcheck



Flap Disc Starting Recommendations by Material

MATERIAL	HEAVY-DUTY / AGGRESSIVE STOCK REMOVAL	FINE FINISHING
Stainless steel and other tough applications	Type 29 SG Blaze R980, TwinFiber	Type 27 Norton SG Blaze R980 TwinStar
Other ferrous and nonferrous materials	Charger R822 Type 29	Charger R822 Type 27

Flap Disc Competitive Cross Reference

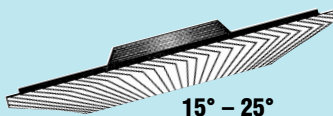
NORTON	DEWALT	GARRYSON	GEMTEX	KLINGSPOR	PFERD	SAIT	3M	WALTER	WEILER
SG Blaze R980							947D		
TwinStar								Enduroflex	
TwinFiber		Zirc +					747D Regalite		
Charger R822	Zirc	Zirc	Zirc	SMT626	Polifan	Saitlam F ZH	563D	Quick Step	Tiger, Big Cat
Merit		Zirc							Vortec

Two Basic Flap Disc Designs

Norton Type 29 Conical / Merit Type 27C Conical

THE MOST AGGRESSIVE CHOICE

- Conical flap discs have flaps angled at 10 degrees and may be used on both conical and flat surfaces
- The angle provides greater surface contact and as a result, tends to be the most aggressive choice
- The best choice when speed and stock removal are primary considerations

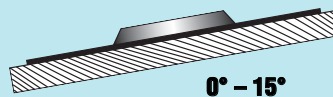


GRIND AT
STEEPER ANGLES

Norton and Merit Type 27 Flat

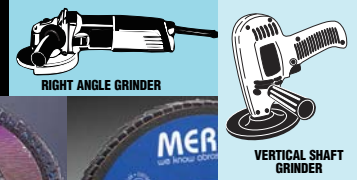
THE CHOICE FOR THE BEST FINISH

- The Type 27 flap discs have a flat design and are used primarily on flat surfaces
- The best choice for smooth finishing
- Also available in Norton Jumbo / Merit High Density sizes with extra large flaps lasting up to 40% longer than standard flap discs
- Choice will also depend on user preference of grinding angle (severe angle will weaken the edges)



GRIND AT
FLATTER ANGLES

FLAP DISCS



FLAP DISCS



BEST
T29 – SG BLAZE R980

BEST
T29 – TWINFIBER

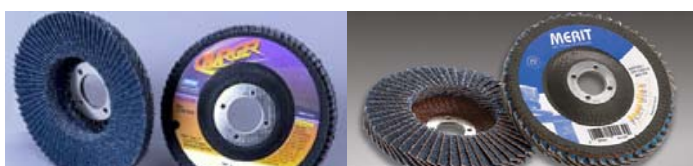
BETTER
T29 – CHARGER R822

GOOD
T27C – MERIT ZA

SIZE D X H	GRIT	MAX. RPM	STD.		STD.		STD.		STD.	
			PKG.	UPC NO.	PKG.	UPC NO.	PKG.	UPC NO.	PKG.	UPC NO.

TYPE 29 / TYPE 27C CONICAL

4 x 5/8	36	13,000					5	66261119265										
	40							66261119264										
	60							66261119263										
	80							66261119262										
	120							66261119261										
4-1/2 x 5/8-11	24	13,000	10	66261183490	66261183491	66261183492	66261183493	5	63642536156	63642536157	63642536158	63642597115	5	66261121291	10	66261121290	08834194803	
	36													66261121289		08834194804		
	40													66261121288		08834194805		
	60													66261121287		08834194806		
	80													66261121286				
4-1/2 x 7/8	24	13,000	10	66261183486	66261183487	66261183488	66261183489	10	63642504329	63642504330	63642504331	63642504332	63642504333	5	66261119271	10	66261119270	08834194296
	36														66261119269		08834194766	
	40														66261119268		08834194767	
	60														66261119267		08834194768	
	80														66261119266			
5 x 7/8	24	12,000	10	66261190001	66261190002	66261190003	66261190004	5	66261119277	66261119276	66261119275	66261119274	66261119273	66261119272	10	08834193649	08834193650	
	36															08834193651		
	40															08834193652		
	60																	
	80																	
6 x 7/8	40	10,200						10	63642541406	63642541407	63642541408							
	60																	
	80																	
7 x 5/8-11	24	8,500	10	66261183498	66261183499	66261183500	66261183501	5	63642536159	63642536160	63642536161		5	66261119289	10	66261119288	08834197210	
	36													66261119287		08834197212		
	40													66261119286		08834197213		
	60													66261119285				
	80													66261119284				
7 x 7/8	24	8,500	10	66261183494	66261183495	66261183496	66261183497	10	63642504334	63642504335	63642504336	63642504337	63642504338	5	66261119283	10	66261119282	08834197194
	36														66261119281		08834197195	
	40														66261119280		08834197199	
	60														66261119279		08834197204	
	80																	



BETTER
T27 – JUMBO CHARGER R822

GOOD
T27 – HIGH DENSITY MERIT ZA

SIZE D X H	GRIT	MAX. RPM	STD.		STD.	
			PKG.	UPC NO.	PKG.	UPC NO.

TYPE 27 JUMBO / HIGH DENSITY

4-1/2 x 5/8-11	40	13,000	5	63642503527		
	60			63642503528		
	80			63642503529		
4-1/2 x 7/8	40	13,000	5	63642503531	10	08834190172
	60			63642503532		08834190767
	80			63642503533		08834194360
7 x 5/8-11	40	8,500	5	63642503539		
	60			63642503540		
7 x 7/8	40	8,500	5	63642503535	10	08834190933
	60			63642503536		08834194514
	80			63642503537		08834194362

TECHtip

Use flap discs one grit size coarser than fiber discs, except in 36 grit.

It is the user's responsibility to refer to and comply with ANSI B7.7