

**METAL DISC, INOX STAINLESS STEEL DISC, STONE DISC**

XAKT Discs are made from high quality material to provide durability and functionality to professional worldwide. Our cutting and grinding discs are used for multiple applications including Stone, Steel, Stainless Steel, Inox, and others. XAKT discs acknowledge the highest safety requirements as set by oSa, and thus, are manufactured to conform with the specifications that ensure safe usage on various applications.

**Pictograms**

Applications (for steel & SS)



**Safety Symbols**



Read the instructions



Wear dust mask



Wear ear protection



Wear safety protection



Wear safety gloves



Not suitable for hand-held machines



Not suitable for grinding



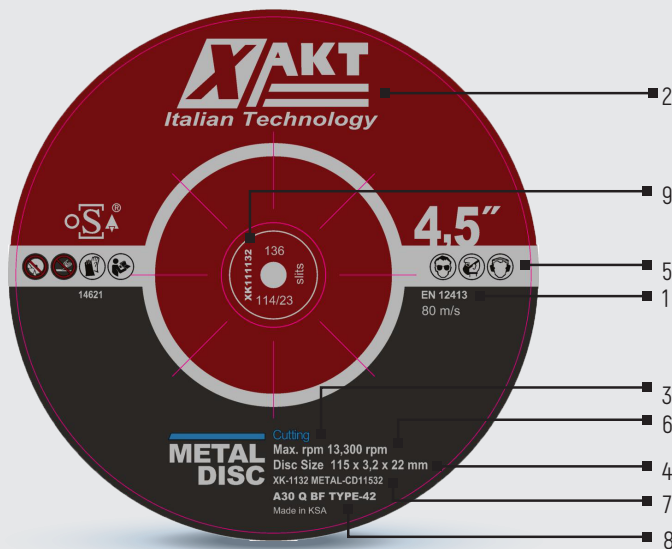
Do not use if damage



## Symbols & Designations of the Wheel

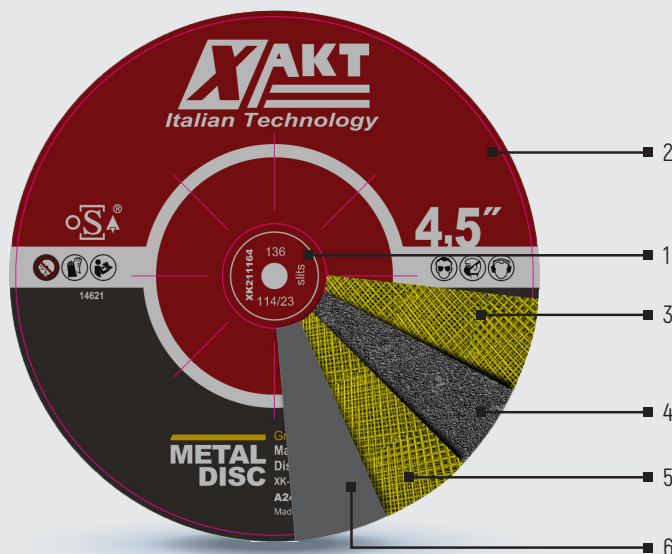
Understanding the right product to use for an application is essential for both the operator's safety as well as making sure you achieve the desired product performance.

### Information & Description of the disc



- 1- European Safety Standards EN:12413
- 2- Our Premium trusted brand
- 3- Usage
- 4- Disc Dimension
- 5- Safety Instruction
- 6- Specifications & max rotation speed
- 7- Application
- 8- Grade
- 9- Validity & Batch Number

### Disk Anatomy



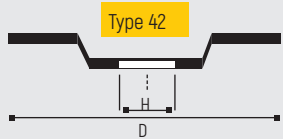
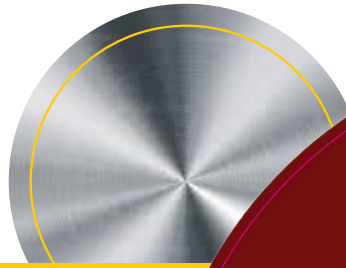
- 1- Bore Ring
- 2- Label
- 3- Reinforcement
- 4- Abrasive Grain
- 5- Reinforcement
- 6- (Glass fabric with paper)

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### METAL APPLICATIONS

- Universal metal
- Structural Steel
- Construction Steel (high tensile)



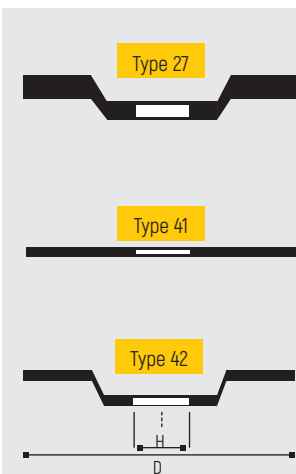
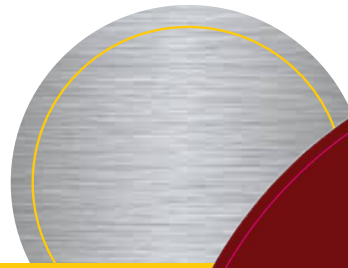
Usage	Item #	Size In Inch	Dimensions D x T x B	Formula	Max RPM	Pieces / Carton	Machine type	
CUTTING	TYPE 42	111030	4	100x3x16	A36Q SF	15300	100	
		111132	4.5	115x3.2x22.23	A30Q SF	13300	100	
		111232	5	125x3.2x22.23	A24Q SF	12250	50	
		111832	7	180x3.2x22.23	A24Q SF	8500	50	
		112332	9	230x3.2x22.23	A24Q SF	6650	25	
	TYPE 41	113030	12	300x3.0x25.4	A30Q SF	5100	25	
		113032	12	300x3.2x25.4	A30Q SF	5100	25	
		113038	12	300x3.8x25.4	A24Q SF	5100	25	
		113530	14	350x3.0x25.4	A30Q SF	4400	25	
		113532	14	350x3.2x25.4	A30Q SF	4400	25	
		113538	14	350x3.8x25.4	A24Q SF	4400	25	
		114035	16	400x3.5x25.4	A24Q SF	3850	20	
GRINDING	TYPE 27	211064	4	100x6.4x16	A30Q SF	15300	50	
		211164	4.5	115x6.4x22.23	A24Q SF	1300	50	
		211264	5	125x6.4x22.23	A24Q SF	12250	20	
		211864	7	180x6.4x22.23	A24Q SF	8500	25	
		212364	9	230x6.4x22.23	A24Q SF	6650	10	

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## STAINLESS STEEL APPLICATIONS

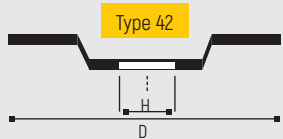
- Stainless Steel
- High Grade Steel
- Railway Tracks
- Fe, s, cl ≤0.1%



Usage	Item #	Size In Inch	Dimensions D x T x B	Formula	Max RPM	Pieces / Carton	Machine type	
CUTTING	TYPE 42	121030	4	100x3x16	A36 Q BF INOX	15300	100	
		121132	4.5	115x3.2x22.23	A30 Q BF INOX	13300	100	
		121232	5	125x3.2x22.23	A24 Q BF INOX	12250	50	
		121832	7	180x3.2x22.23	A24 Q BF INOX	8500	50	
		122332	9	230x3.2x22.23	A24 Q BF INOX	6650	25	
	TYPE 41	123030	12	300x3.0x25.4	A30 Q BF INOX	5100	25	
		123032	12	300x3.2x25.4	A30 Q BF INOX	5100	25	
		123038	12	300x3.8x25.4	A24 Q BF INOX	5100	25	
		123530	14	350x3.0x25.4	A30 Q BF INOX	4400	25	
		123532	14	350x3.2x25.4	A30 Q BF INOX	4400	25	
		123538	14	350x3.8x25.4	A24 Q BF INOX	4400	25	
		124035	16	400x3.5x25.4	A24 Q BF INOX	3850	20	
GRINDING	TYPE 27	221064	4	100x6.4x16	A30 Q BF INOX	15300	50	
		221164	4.5	115x6.4x22.23	A24 Q BF INOX	1300	50	
		221264	5	125x6.4x22.23	A24 Q BF INOX	12250	20	
		221864	7	180x6.4x22.23	A24 Q BF INOX	8500	25	
		222364	9	230x6.4x22.23	A24 Q BF INOX	6650	10	

## STONE APPLICATIONS

- Concrete
- Roof tiles
- Marble
- Asphalt
- Natural stone
- Artificial stone



Usage	Item #	Size In Inch	Dimensions D x T x B	Formula	Max RPM	Pieces / Carton	Machine type
CUTTING	TYPE 42	141030	4	100x3x16	C36 R BF	15300	100
		141132	4.5	115x3.2x22.23	C36 R BF	13300	100
		141232	5	125x3.2x22.23	C36 R BF	12250	50
		141832	7	180x3.2x22.23	C36 R BF	8500	50
		142332	9	230x3.2x22.23	C36 R BF	6650	25
GRINDING	TYPE 27	241064	4	100x6.4x16	C36 R BF	15300	50
		241164	4.5	115x6.4x22.23	C36 R BF	1300	50
		241264	5	125x6.4x22.23	C36 R BF	12250	20
		241864	7	180x6.4x22.23	C36 R BF	8500	25
		242364	9	230x6.4x22.23	C36 R BF	6650	10



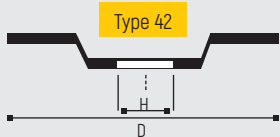
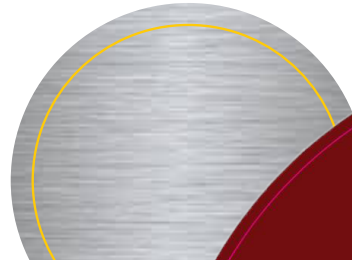
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## INOX /STAINLESS STEEL

Thin Cutting Wheels

- Fast, cool cutting, longest service life.
- Premium Aluminum Oxide grain
- Fe, s, cl ≤0.1%



Usage	Item #	Size In Inch	Dimensions D x T x B	Formula	Max RPM	Pieces / Carton	Machine type
CUTTING	TYPE 41	121010	4	100x1.0x16	A 46TBF INOX	15300	200
		121012	4	100x1.2x16	A 46TBF INOX	15300	200
		121016	4	100x1.6x16	A 46TBF INOX	15300	200
		121110	4.5	115x1.0x22.23	A 46TBF INOX	13300	200
		121112	4.5	115x1.2x22.23	A 46TBF INOX	13300	200
		121116	4.5	115x1.6x22.23	A 46TBF INOX	13300	200
		121210	5	125x1.0x22.23	A 46TBF INOX	12250	100
		121212	5	125x1.2x22.23	A 46TBF INOX	12250	100
		121216	5	125x1.6x22.23	A 46TBF INOX	12250	100
		121816	7	180x1.6x22.23	A 46TBF INOX	8500	90
		122319	9	230x1.9x22.23	A 46TBF INOX	6650	90



## FLAP DISC T27

### Alumina, Zirconia & Ceramic T27 Flap Disc

Alumina, Zirconia & ceramic T27 Flap Discs Strong, high quality and optimum performance for carbon steel, alloy steel, cast iron and stainless steel.

#### PRODUCT FEATURES:

High consistent cut rate, operator friendly, finer finish, long life, high stock removal, less noise, high safety, durable high strength fiber glass backing. Unique individual coating process. Minimum grain shedding. Premium X wt backing for aggressive grinding.



TYPE	SIZE	DIMENSIONS	Mox RPM	GRIT
T27/T29	4"	100x16	15300	40,60,80,100
T27/T29	4.5"	115x22	13300	40,60,80,100
T27/T29	5"	125x22	12250	40,60,80,100
T27/T29	7"	180x22	8500	40,60,80,100

## FLAP DISC T29

### Alumina, Zirconia & Ceramic T29 Flap Disc

Alumina, Zirconia & ceramic T29 Flap Discs Strong, high quality and performance for carbon steel, alloy steel, cast iron and stainless steel.

#### PRODUCT FEATURES:

High consistent cut rate, operator friendly, finer finish, high stock removal, long lasting, economical, less noise, high safety. Minimum grain shedding



TYPE	SIZE	DIMENSIONS	Mox RPM	GRIT
T27/T29	4"	100x16	15300	40,60,80,100
T27/T29	4.5"	115x22	13300	40,60,80,100
T27/T29	5"	125x22	12250	40,60,80,100
T27/T29	7"	180x22	8500	40,60,80,100

## Mounted Flap wheel

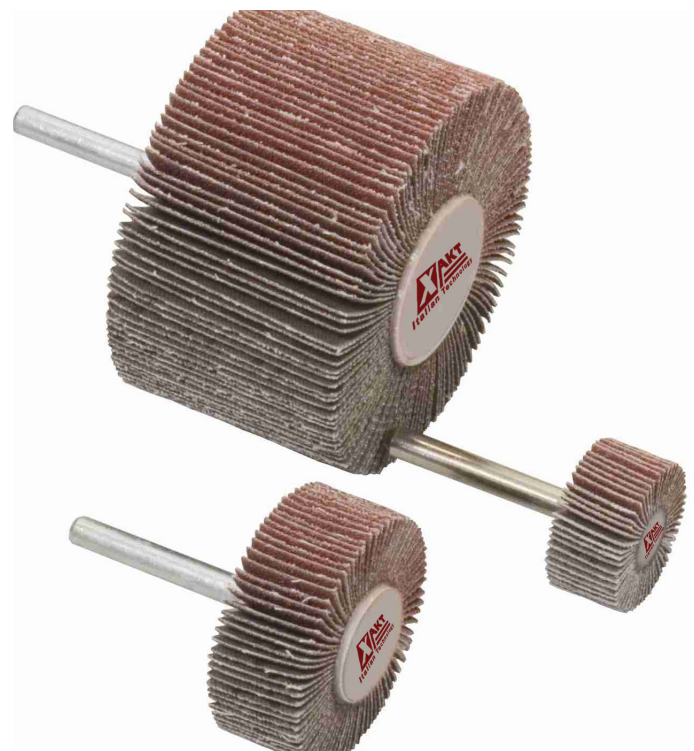
### Premium High Performance Flapper Wheels

Mounted Flap Wheels are characterised by top quality cloth and excellent fabric of the support cloth that does not burn during use and does not produce bad smells: it wears evenly ensuring optimum change and cutting rate.

#### Grit

16	24	30	36	40	50	60	80	100
				■		■	■	■

Diameter x height x shaft in mm	Max. RPM
20x20x6	38.150
20x15x6	38.150
20x15x6	38.150
25x20x6	30.500
25x15x6	30.500
30x5x3	25.400
30x10x3	25.400
30x15x6	25.400
40x10x6	19.000
40x15x6	19.000
40x20x6	19.000
50x5x6	15.200
50x10x6	15.200
50x15x6	15.200
50x20x6	15.200
50x30x6	15.200
60x15x6	12.700
60x20x6	12.700
60x30x6	12.700
60x40x6	12.700
60x50x6	12.700
80x15x6	9.500
80x20x6	9.500
80x30x6	9.500
80x40x6	9.500
80x50x6	8.400





# ALWAYS

- Observe the safety recommendations of the machine and wheel manufacturer.
- Keep the working area well lit, clean, tidy and free from obstructions.
- Avoid slippery and uneven floors and do not work on ice or snow.
- Ensure other workers in the vicinity and passers by are protected from sparks and debris.
- Exercise care when handling abrasive wheels - they can easily be damaged.
- Store wheels in dry and frost free conditions avoiding wide variations in temperature and the risk of damage.
- Visually check the wheel for damage or defects and conduct a ring test before mounting.
- Check that the wheel is the correct specification for the application and that the markings are intact and legible.
- Use the correct tools when mounting or removing a wheel.
- Ensure mounting flanges are in matched pairs, clean, free from burrs and undistorted.
- Use blotters to prevent wheel slippage where required.
- Make sure that work rests and work piece clamping devices are secure and correctly positioned.
- Ensure guards are in position and correctly adjusted so that they do not foul the wheel.
- Rotate the wheel manually to ensure that it runs true and freely before turning on the power.
- Wear suitable protective clothing.
- Run the wheel for at least 30 seconds at operating speed after mounting or remounting. Stand out of the line of the wheel when turning on the machine.
- Dress bench grinding wheels regularly to keep the cutting surface in good condition.
- Allow the wheel to come to rest naturally after turning off the machine.
- Ensure the work piece is properly supported or clamped so that it cannot move during grinding or cutting.
- Spin out residual coolant from the wheel before turning off the machine.
- Report wheel breakages, keeping hold of all of the debris for examination.
- Ensure machine spindle speed is checked periodically using a tachometer.
- Ensure that damaged or defective wheels and worn-out wheels are destroyed to prevent them from being used.
- Ensure that the wheel is removed before transporting or storing portable machines.

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METAL

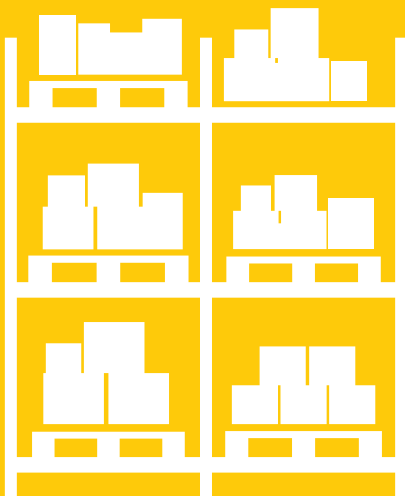
Cutting

Max. rpm 6,600 rpm

# NEVER

- Permit untrained people to handle, store, mount or use abrasives.
- Mount or remove a wheel until the machine has been isolated from its power source
- Mount a wheel that cannot be identified or one which does not bear the correct market.
- Mount a wheel on a machine which does not display its spindle speed.
- Mount a wheel which is beyond its marked expiry date or recommended shelf life.
- Mount a wheel that has been dropped, damaged or incorrectly stored.
- Apply force to fit the wheel on the mounting device or alter the bore size or allow the wheel to overheat.
- Tighten flanges with excessive force or use a hammer or extension
- Use damaged, distorted or dirty flanges and fastening screws.
- Use a machine until the wheel guard has been re-fitted, secured and adjusted correctly.
- Stand in the line of grinding wheel when starting the motor after fitting or re-fitting a wheel.
- Start the wheel in contact with the work piece or any other object.
- Mount a wheel on a machine running at a speed higher than the maximum operating speed marked on the wheel.
- Work from a ladder or in a position where you do not have full control of the machine.
- Impact the work onto the wheel or the wheel onto the work.
- Grind on the side of a wheel unless it is specially designed for this application.
- Apply side pressure by trying to cut curves or by grinding surfaces with cutting-off wheels.
- Allow the wheel to bounce or be trapped or pinched in the cut.
- Use type 27 depressed centre grinding wheels at a sleep angle or try to cut with them
- Dress the wheel with any device other than that recommended.
- Press against the wheel surface to stop it or put down a machine until the wheel has stopped running.
- Wear the wheel down to the mounting flanges.
- Allow the gap between the wheel and workrest to exceed 3 mm.
- Allow coolant to run a stationary wheel or leave the wheel running on an unattended machine.

# CORRECT STORAGE



Please store in dry and well-ventilated premises without major temperature changes (temperatures between 10°C and 30°C and max. 70% relative humidity).

This will help preserve the physical properties of reinforced resin bonded grinding wheels for up to three years, up to two years for non reinforced ones.

The storage premises should be as close to the place of use as possible in order to avoid mechanical damage to the wheels during transport, as well as moisture condensation while in transit on colder days.