

Disc Categories :

Grade	Disc Size	Grit Style						
		24	36	50	60	80	100	120
Ikkon (Alumina)	4"	DO	DO		DO	DO		DO
	5"	DO	DO	DO	DO	DO	DO	DO
	7"	DO	DO		DO	DO		DO
Zirconia	4"	DO	DO		DO	DO		
	5"	DO	DO		DO	DO		
	7"	DO	DO		DO	DO		

Disc Selection Guide (Suggested)

<i>Dressing & Stock Removal of Stainless</i>	<i>Zirconia 60</i>	<i>Zirconia 60</i>	<i>Zirconia 36</i>
<i>Stock Removal of Non-ferrous & Soft Metals</i>	<i>Ikkon 36</i>	<i>Ikkon 24</i>	<i>Zirconia 24</i>
<i>Rust & Scale Removal</i>	<i>Ikkon 60</i>	<i>Ikkon 80</i>	<i>Zirconia 60</i>
<i>Titanium Stock Removal</i>	<i>Zirconia 80</i>	<i>Zirconia 60</i>	<i>Zirconia 60</i>
<i>Wood Sanding</i>	<i>Ikkon 60</i>	<i>Zirconia 60</i>	<i>Zirconia 60</i>
<i>Grinding Fibreglass / Composites</i>	<i>Ikkon 60</i>	<i>Ikkon 60</i>	<i>Zirconia 60</i>
<i>General Purpose Grinding and Polishing</i>	<i>Ikkon 60</i>	<i>Ikkon 60</i>	<i>Zirconia 60</i>
<i>Grinding of Stainless Steel & Carbon Steel</i>	<i>Ikkon 36</i>	<i>Zirconia 36</i>	<i>Zirconia 36</i>
<i>Stone grinding</i>	<i>Ikkon 60</i>	<i>Ikkon 60</i>	<i>Zirconia 60</i>

Major Applications :

Grinding of cast iron, wood, fiber glass, stones

Used in industries :

Wood furniture, metal fabrication (cupboards, home appliances) automobile, ship building and aerospace

Availability :

Disc Diameter (mm)-100, 125, 178

Grit Size-# 24, 36, 60, 80, 120

Safety Guide Preparation Before Use

- Abrasive Fibre discs must be used with a back-up pad of the correct size.
- Do not use other abrasive fibre discs (used or unused) as a back-up pad.
- The diameter of the disc must be at least 3 mm but not more than 15 mm greater than the diameter of the back-up pad.
- Do not use a fibre disc which is damaged In any way.
- Always check visually for damage before use.
- Make certain that both the disc and the back-up pad are fitted correctly to the machine spindle.
- Never attach a sander/grinder designed for 110 volts into a 220-V power source. Take all normal electric tool precautions.

Personal Protection

Safety goggles, ear muffs, safety gloves, dust masks and, if grinding conditions conditions are severe, additional face protection, leather aprons and safety shoes must be worn.

Proper Storage

- Store discs at 40 to 50 percent relative humidity and 60 to 80 degrees F (15 to 29 degrees C)
- Store discs at least 4 inches (10 or more centimeters) above the surface of floors; away from open windows; out of direct sunlight; and away from heat sources such as radiators, steam pipes, and air-conditioner exhaust vents.
- Protect them from exposure to water and other fluids and solvents.
- Always follow the abrasive manufacturer's storage instructions
- Never use hoods when handling or transporting coated abrasive disc containers.
- Do not drop or in any way damage the discs' packaging.
- Do not use the discs if their packaging is damaged; return any damaged product to its manufacturer.
- Rotate stock; use on a first-in, first-out basis. Store the discs in their original packaging

How Moisture Affects Discs

Temperature and humidity are two very important environmental factors that influence coated abrasive disc performance and safety improper or inadequate storage can damage discs and make them unsafe. Backings and adhesives are sensitive to climatic changes and gain or lose moisture according to the relative tumidity of their surroundings.

Excessive moisture also can soften the adhesive bond and cause the disc to suddenly shed or lose large amounts of abrasive grains.

Excessive dryness can make the disc curl or arch down in a concave concave manner, which causes it to become brittle and lose its flexibility. In short, high and low humidity can cause convex and concave cupping, respectively.

Grinding Operation

The abrasive fibre disc should only be brought into contact with the work piece when the machine is running at its operational speed.

The disc should be applied to the work piece at the shallowest angle possible - about 10 degrees is recommended.

Grind 'off' an edge rather than 'into' it when grinding rough welds or metal edges.

Do not attempt to use a fibre disc for slot grinding, cutting-off or wet grinding.

After use the angle grinder should be stored with care. The face of the disc must not be in contact with bench or floor.

Following recommended disc storage guidelines, using proper equipment wearing the right personal protective equipment, and employing safe methods of operation can reduce the likelihood of disc breakage and personal injury when using coated abrasive fiber discs. Coated abrasive discs have an excellent safety record with few reported disc breakages and personal injuries. Still, every effort should be made to prevent them. As with most accidents, operator error is a major factor. Following established safety rules reduces the probability of such an occurrence.