



MASTER ABRASIVES

Masterflex Polishing Products





How to Order Masterflex Polishing Products

When ordering it is important to give as much information about the operation as possible so that the correct grading is supplied. The information given should include:

- Material to be finished; sketch or description of the part;
- Specific operation (deburring, finishing, breaking edges, etc);
- Equipment available for mounting the wheel (bench grinder, flexible shaft, portable hand tool, etc, power and r.p.m.);
- Dimensions of surface to be finished and allowable tolerance.

The following safety information should be used only as a guide for the MASTERFLEX range of products.

Safety Guide

1. Check all wheels for damage before mounting.
2. Check machine speeds against maximum operating speed of the wheel.
3. Be sure that the wheel bore, fits machine arbor properly and that flanges are clean, flat and of the proper type for the wheel you are mounting.
4. Run the wheel in a protected area at least one minute before grinding.
5. Wheels should be properly guarded.
6. Wear protective safety glasses or a proper face shield.
7. Do not use excessive pressure when mounting wheel between flanges. Tighten nut sufficiently to hold wheel firmly.
8. Do not use heavy side grinding pressure on any Type 1 straight sided wheels.
9. Do not mount more than one wheel on a single arbor.
10. All wheels should be stored flat, not on their edges.

Polishing Products



The MASTERFLEX range of finishing wheels are designed and constructed specifically for polishing and surface finishing. MASTERFLEX products are laminates of non woven fibre and abrasive grain that are bonded together by a special process to produce uniformly impregnated abrasive wheels that provide excellent cutting and finishing properties.

Range

The complete range of MASTERFLEX Polishing Products includes Straight Sided Wheels, Depressed Centre Discs, Mounted Points & Wheels and Dressing Sticks. Masterflex combines the free cutting qualities of bonded abrasives with the smoothing and finishing action of coated abrasives to meet a wide range of grinding, blending and polishing applications.

Mounted Points	Full range of A, B & W shapes (other shapes available on request).
T1 Wheels	Diameters 25mm to 250mm in thickness range 0.8mm to 25mm.
T27 Wheels	Diameters 100mm, 115mm, 180mm in thicknesses 4.5mm and 6mm.
Dressing Sticks	Square, length range 100mm to 150mm in widths 6mm to 25mm.

Applications

The MASTERFLEX range of products was developed specifically for the grinding, polishing and blending of Stainless Steel, Aluminium and other metals and steels.

Industrial applications include: Aerospace, shipbuilding, jewellery, tools and dies, automotive industry, cutlery and manufacturers of stainless steel pressure vessels, storage tanks, heat exchangers, hoppers and sinks. Fabricators of stainless steel equipment for restaurants, hospitals, textile machinery, dairies, breweries, nuclear plants, food and chemical processors. Gear deburring - either offhand grinders or automatic deburring machines and many other industries.

Special Features and Advantages

The composition of MASTERFLEX polishing products enables them to:

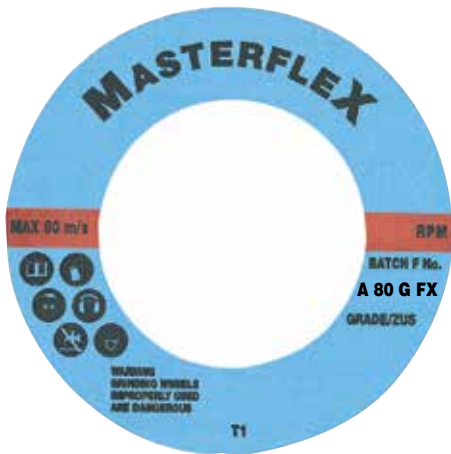
Grind faster – Give more aggressive cutting action - Cut cooler – Resist loading and last longer than conventional abrasive products.

Smooth Action

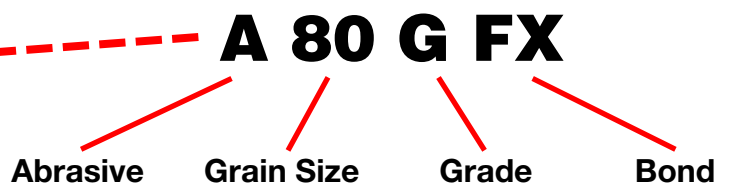
With its soft grinding action any tendency towards vibration or chatter is reduced. It is fast and effective for a smooth uniform finish.

Non Loading

MASTERFLEX polishing products do not load up when working on soft metals or alloys.



Standard Marking System



A (Aluminium Oxide)	24	Coarse	G	Soft	FX – Latex TX – Resin
	36				
	54	Medium			
	80		K	Hard	
	120	Fine			
	180				
	220	V.Fine			
320					

Specifications

Abrasive A (aluminium oxide)	Grain Size: 24, 36, 54, 80, 120, 180, 220, 320
Bond	
TX BOND – Strong resin bond that combines resilience and cutting ability with long life and better finishes. K - grade - light deburring M - grade - stock removal	FX Bond – unique flexible bond that blends, finishes and polishes in one single operation G - grade - blending finishing



Mounted Points and Wheels

The answer to those difficult grinding and finishing problems on Stainless Steel, Aluminium Castings and Fabrications. Widely used in Tool Rooms and Die Shops for maintenance and rectification work on moulds and dies.



A SHAPES		Shape	Dimensions dia. x thickness mm	*Overhang 13mm	*Overhang 25mm	*Overhang 40mm
	A1	A1	22 x 63	19,800	16,500	13,120
	A3	A3	25 x 70	16,100	13,080	10,730
	A4	A4	32 x 32	29,840	24,750	20,250
	A5	A5	20 x 28	45,000	33,750	27,000
	A11	A11	22 x 50	19,860	15,100	12,000
	A12	A12	20 x 32	48,000	35,250	27,370
	A13	A13	30 x 32	33,950	32,250	25,500
	A14	A14	20 x 22	53,050	40,500	30,750
	A15	A15	6.5 x 27	72,750	47,620	34,500
	A21	A21	25 x 25	34,500	26,250	21,000
	A23	A23	20 x 25	39,370	30,370	24,370
	A24	A24	6.5 x 20	76,500	49,500	36,370
	A25	A25	∅ 25	35,620	27,370	22,120
	A26	A26	∅ 16	59,680	46,500	35,250
	A34	A34	40 x 11	25,130	25,130	25,130
	A35	A35	25 x 11	38,200	38,200	31,500
	A36	A36	40 x 11	23,520	23,520	23,520
	A37	A37	30 x 7	29,840	29,840	29,840

The above shapes are all available on 6.0mm or 6.35mm (1/4") shanks. Shapes A15 & A24 also available on 3.00mm or 3.17mm (1/8") shanks.

***Maximum safe operating speed at 13mm, 25mm, 40mm overhang**

B SHAPES		Shape	Dimensions dia. x thickness mm	*Overhang 13mm	*Overhang 25mm	*Overhang 40mm
	B41	B41	16 x 16	33,750	23,250	17,620
	B42	B42	13 x 20	33,750	23,250	17,620
	B51	B51	11 x 20	45,370	28,500	21,000
	B52	B52	10 x 20	45,370	28,500	21,000
	B61	B61	20 x 10	38,250	24,370	17,400
	B62	B62	13 x 10	41,020	26,400	19,500
	B91	B91	13 x 16	34,500	22,500	16,870
	B104	B104	8 x 10	68,400	42,370	28,870
	B111	B111	11 x 18	33,750	23,250	17,620
	B112	B112	10 x 13	45,370	28,500	21,000
	B121	B121	∅ 13	45,370	28,500	21,000
	B122	B122	∅ 10	61,650	37,720	27,000

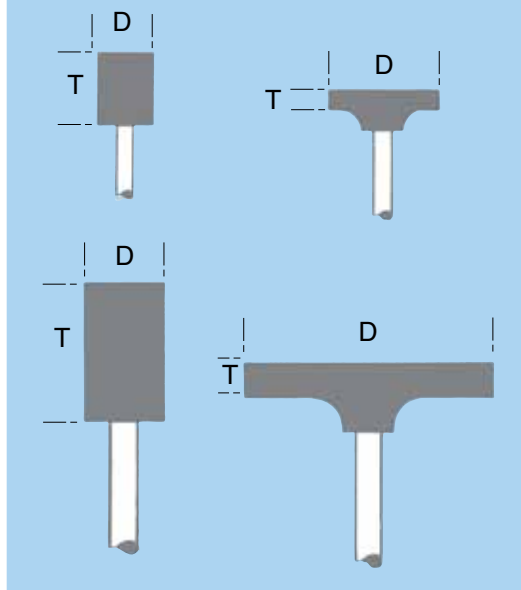
The above shapes are all available on 3.0mm or 3.17mm (1/8") shanks.

***Maximum safe operating speed at 13mm, 25mm, 40mm overhang**

Specifications

Abrasive	Grain Size	Grade	Bond	
A (Aluminium Oxide)	24	Coarse	G Soft K M Hard	FX TX
	36			
	54	Medium		
	80			
	120	Fine		
	180			
	220	V.Fine		
	320			

W SHAPES



Applications

Specifications	Application
A80 GFX	Polish and touch up work on moulds and dies
A36MTX	Smoothing contours of aluminium welded fabrications
A36GFX	Blending contours of Stainless Steel welded fabrications
A80MTX	Polish welded corners of Stainless Steel sinks
A80MTX	Deflashing and polishing die castings
A80GFX	Removal of sharp edges or burrs of machine tools
A80GFX	Deburring Turbine Blades

Shape	Dimensions dia. x thickness mm	*Overhang 13mm	*Overhang 25mm	*Overhang 40mm
W160	6 x 6	81,370	51,000	34,120
W162	6 x 10	68,400	42,370	28,870
W163	6 x 13	60,000	38,020	26,250
W164	6 x 20	45,900	30,000	21,750
W174	10 x 6	69,000	41,250	27,750
W175	10 x 10	54,000	33,000	24,150
W176	10 x 13	Available	45,370	28,500
W177	10 x 20	on	33,750	23,250
W178	10 x 25	3mm	26,250	18,750
W183	13 x 6	or	51,750	31,870
W184	13 x 10	3.17mm	41,020	26,400
W185	13 x 13	(1/8")	34,500	22,500
W186	13 x 20	Shanks	26,250	-
W201	20 x 6		38,250	24,370
W202	20 x 10		30,000	19,500
W203	20 x 13		25,500	15,900
W216	25 x 6		30,520	18,600

*Maximum safe operating speed at 13mm, 25mm, 40mm overhang

Shape	Dimensions dia. x thickness mm	*Overhang 13mm	*Overhang 25mm	*Overhang 40mm
W176	10 x 13	81,000	54,380	42,000
W177	10 x 20	66,000	46,500	32,250
W178	10 x 25	55,200	40,500	30,000
W179	10 x 32	45,000	-	-
W183	13 x 6	73,460	54,750	40,500
W184	13 x 10	71,250	47,620	35,020
W185	13 x 13	61,500	42,000	31,500
W186	13 x 20	51,000	-	-
W187	13 x 25	40,000	-	-
W188	13 x 38	30,370	24,000	18,900
W189	13 x 50	24,000	-	-
W196	16 x 25	35,250	27,000	21,300
W197	16 x 50	21,000	16,500	12,900
W201	20 x 6	47,750	47,750	38,100
W202	20 x 10	47,750	44,100	32,400
W203	20 x 13	47,750	36,370	27,750
W204	20 x 20	Available	42,750	30,750
W205	20 x 25	on	34,500	25,870
W207	20 x 38	6mm	24,000	18,520
W208	20 x 50	or	18,750	15,370
W216	25 x 6	6.35mm	38,200	38,200
W217	25 x 10	(1/4")	38,200	38,200
W218	25 x 13	Shanks	38,200	32,770
W220	25 x 25		25,500	19,120
W221	25 x 38		19,120	14,620
W222	25 x 50		15,900	12,370
W225	32 x 6		29,840	29,840
W226	32 x 10		29,840	29,840
W227	32 x 13		30,000	-
W228	32 x 20		29,840	22,500
W230	32 x 32		20,400	18,750
W232	32 x 50		14,250	10,650
W235	38 x 6		25,130	25,130
W236	38 x 13		25,130	25,130
W237	38 x 25		22,500	17,620
W238	38 x 38		15,600	12,000
W242	50 x 25		19,100	15,950

*Maximum safe operating speed at 13mm, 25mm, 40mm overhang

Other shapes available upon request.



Straight Sided Wheels Type 1

Widely used for deburring and finishing of ferrous and non-ferrous fabrications. Popular for corner blending of tanks and vessels as well as polishing inside diameter of stainless steel pipes. Controlled grinding action cuts fast and leaves a superior finish. Removes medium to small burrs without changing the geometry of the work piece.



Available in a wide range of sizes and specifications, featuring long life, controlled grinding and non-loading.

Wheel Size mm	Maximum Safe RPM		Wheel Size mm	Maximum Safe RPM		Wheel Size mm	Maximum Safe RPM	
	TX Bond	FX Bond		TX Bond	FX Bond		TX Bond	FX Bond
25 x 0.8 x 1.59	54,240	–	76 x 3 x 6.35	18,080	12,095	150 x 13 x 15.88	9,040	6,050
25 x 0.8 x 3.18	54,240	–	76 x 6 x 6.35	18,080	12,095	150 x 20 x 15.88	6,050	6,050
25 x 1.6 x 3.18	54,240	36,290	76 x 6 x 9.53	18,080	12,095	150 x 25 x 15.88	6,050	6,050
25 x 3 x 3.18	54,240	36,290	76 x 10 x 9.53	18,080	12,095	180 x 3 x 12.70	7,750	5,185
25 x 6 x 6.35	54,240	36,290	76 x 13 x 9.53	18,080	12,095	180 x 3 x 15.88	7,750	5,185
25 x 10 x 6.35	54,240	36,290	76 x 25 x 12.70	12,095	12,095	180 x 6 x 15.88	7,750	5,185
38 x 1.6 x 3.18	36,160	24,195	100 x 1.6 x 6.35	13,560	9,075	180 x 10 x 15.88	7,750	5,185
38 x 3 x 3.18	36,160	24,195	100 x 1.6 x 9.53	13,560	9,075	180 x 13 x 15.88	7,750	5,185
38 x 6 x 6.35	36,160	24,195	100 x 3 x 6.35	13,560	9,075	180 x 20 x 19.05	5,185	5,185
38 x 10 x 6.35	36,160	24,195	100 x 3 x 9.53	13,560	9,075	180 x 25 x 25.40	5,185	5,185
50 x 0.8 x 6.35	27,120	–	100 x 6 x 6.35	13,560	9,075	200 x 6 x 19.05	6,780	4,535
50 x 1.6 x 6.35	27,120	18,145	100 x 6 x 9.53	13,560	9,075	200 x 6 x 25.40	6,780	4,535
50 x 3 x 6.35	27,120	18,145	100 x 10 x 9.53	13,560	9,075	200 x 10 x 25.40	6,780	4,535
50 x 3 x 9.53	27,120	18,145	100 x 13 x 12.70	13,560	9,075	200 x 13 x 25.40	6,780	4,535
50 x 6 x 6.35	27,120	18,145	100 x 20 x 12.70	9,075	9,075	200 x 20 x 25.40	4,535	4,535
50 x 6 x 9.53	27,120	18,145	100 x 25 x 12.70	9,075	9,075	200 x 25 x 25.40	4,535	4,535
50 x 10 x 6.35	27,120	18,145	125 x 3 x 12.70	10,850	7,260	230 x 6 x 19.05	6,030	4,030
50 x 10 x 9.53	27,120	18,145	125 x 6 x 12.70	10,850	7,260	230 x 10 x 19.05	6,030	4,030
50 x 13 x 9.53	27,120	18,145	125 x 10 x 12.70	10,850	7,260	230 x 13 x 25.40	6,030	4,030
63 x 0.8 x 6.35	21,695	14,515	125 x 13 x 12.70	10,850	7,260	230 x 20 x 25.40	4,030	4,030
63 x 1.6 x 6.35	21,695	14,515	125 x 20 x 12.70	7,260	7,260	230 x 25 x 25.40	4,030	4,030
63 x 3 x 6.35	21,695	14,515	125 x 25 x 15.88	7,260	7,260	250 x 6 x 19.05	5,425	3,630
63 x 6 x 6.35	21,695	14,515	150 x 3 x 12.70	9,040	6,050	250 x 10 x 25.40	5,425	3,630
76 x 1.6 x 6.35	18,080	12,095	150 x 3 x 15.88	9,040	6,050	250 x 13 x 25.40	5,425	3,630
76 x 1.6 x 9.53	18,080	12,095	150 x 6 x 12.70	9,040	6,050	250 x 20 x 25.40	3,630	3,630
76 x 3 x 3.18	18,080	12,095	150 x 10 x 12.70	9,040	6,050	250 x 25 x 25.40	3,630	3,630
			150 x 13 x 12.70	9,040	6,050			

Note: Type 1 wheels with smaller bores than those listed are available in special circumstances for use on **THREADED TAPER SPINDLES ONLY**. Other nominal metric bores are available upon request.

Specifications

Abrasive	Grain Size	Grade	Bond
A (Aluminium Oxide)	24 Coarse	G Soft K M Hard	FX TX
	36		
	54 Medium		
	80		
	120 Fine		
	180		
	220 V.Fine		
320			

Applications

Light Deburring		Finishing/Polishing	
Steel (mild)	A24MTX	Steel (mild)	A54GFX
Aluminium	A36MTX	Aluminium	A80GFX
Other non-ferrous	A36MTX	Other non-ferrous	A80GFX
Steel (stainless)	A54MTX	Steel (stainless)	A80GFX
Finer finish	A80MTX	Finer finish	A120GFX
		Polishing	A320GFX



Depressed Centre Discs Type 27



Generally used in the metal fabrication industry for grinding, polishing and blending stainless steel and aluminium welds. Its non-loading qualities and cool cutting action give a consistent finish over the long operating life of the wheel.

TX Bond A24 MTX

For light or medium weld removal. Offers excellent results for grinding aluminium or ferrous materials where finish is important.

FX Bond A36 GFX

For fine finishing, blending, and polishing applications on ferrous and non-ferrous metals. Ideal for stainless steel tanks, vessels, and other fabrications.

Wheel Size mm	Maximum Safe R.P.M.	Grit Size	
		G-FX Bond	M-TX Bond
100 x 4.5 x 15.88 100 x 6 x 15.88	15,250 15,250	{ A36 A54 A80	A24 N/A A36
115 x 4.5 x 22.23 115 x 6 x 22.23	13,300 13,300	{ A36 A54 A80	A24 N/A A36
180 x 4.5 x 22.23 180 x 6 x 22.23	8,500 8,500	{ A36 A54 A80	A24 N/A A36

Applications

Weld Removal	
Steel (mild)	A24MTX
Aluminium	A24MTX
Steel (Stainless)	A24MTX
Better finish	A36MTX
Blending	
Aluminium	A36GFX
Brass	A36GFX
Bronze	A36GFX
Copper	A36GFX
Wrought Iron	A36GFX
Steel (mild)	A36GFX
Steel (stainless)	A36GFX
Finer finish	A54GFX A80GFX












Square Finishing Sticks

- Hand Deburring
- Finishing
- Polishing

Specifications

Size	Abrasive	Grain Size	Grade	Bond
6 x 6 x 100 10 x 10 x 100 13 x 13 x 100 13 x 13 x 150	A (Aluminium Oxide)	80 Medium 120 Fine 180 320 V.Fine	G Soft K M Hard	FX TX

Other sizes available upon request.

-  Precision Mounted Points
-  Precision Internal Grinding Wheels
-  Precision Toolroom Wheels
-  CBN and Diamond Superabrasives
-  Ceralox Ceramic Abrasives
-  Non Woven Surface Finishing Products
-  Coated Abrasives
-  Pneumatic Tools, Accessories & Servicing
-  Tungsten Carbide Rotary Burrs
-  Flapwheels
-  Dressing Equipment
-  Grinding Quills
-  Grinding Wheels
-  Cut-off Wheels
-  Cratex Rubber Products

For further information on our full range of products or advice on a particular applications problem please contact us at the address shown below.



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