

NEW SERIES Hi-tech  
«THIN» CUT-OFF WHEELS  
CUT-OFF AND GRINDING WHEELS  
FOR PORTABLE APPLICATION  
CUT-OFF AND GRINDING WHEELS  
FOR STATIONARY GRINDERS



MADE IN RUSSIA  
JSC «Luga abrasive plant»


















# SYSTEM OF ABRASIVE TOOLS MARKING









1 <sup>D</sup>150x<sup>T</sup>25x<sup>H</sup>32 14A 24 Q B 50  
1 2 3 4 5 6 7

## 1. TYPE

### WHEELS

-  1 - straight profile wheels
-  2 - annular wheels
-  3 - cone profile wheels
-  5 - recessed wheels
-  6 - cup cylinder wheels
-  7 - double-sided recessed wheels
-  11 - cup cone wheels
-  12 - flat dish wheels
-  27 - depressed center wheels
-  35 - straight profile butt-end wheels
-  36,37,40 - wheels with pressed-in fastening components
-  41 - cut-off wheels
-  42 - cut-off wheels with depressed center

### SEGMENTS

-  SP -rectangular
-  4S -flat-convex
-  1S -convexo-concave
-  5S -trapezoidal
-  2S -concave-convexo
-  6S -for floor grinding
-  3S -convexo-flat
-  9S -for rail grinding

### HONES

-  BP - rectangular
-  BKw - square

## 2. WHEEL SIZES

D - outer diameter      T - height      H - hole diameter

## 3. ABRASIVE MATERIAL

14A (A)	REGULAR ALUMINA
25A (WA)	WHITE ALUMINA
38A (ZK)	ZIRCONIA ALUMINA
53C, 54C (C)	BLACK SILICON CARBIDE
63C, 64C (GC)	GREEN SILICON CARBIDE

## 4. GRIT

### ABRASIVE GRAIN

GOST	GOST	GOST
F10 (200)	F24 (80)	F60 (25)
F12 (160)	F30 (63)	F70 (20)
F14 (160)	F36 (50)	F80 (20)
F16 (162/125)	F40 (40)	F90 (16)
F20 (100)	F46 (40)	
F22 (80)	F54 (32)	

### POWDERS

F100 (12)	F180 (6)
F120 (10)	F220 (5)
F150 (8)	

## 5. HARDNESS

F, G (BM1, BM2)	HIGHLY SOFT
H, I, J (M1, M2, M3)	SOFT
K, L (CM1, CM2)	AVERAGE SOFT
M, N (C1, C2)	AVERAGE
O, P, Q (CT1, CT2, CT3)	AVERAGE HARD
R, S (T1, T2)	HARD
T (BT)	HIGHLY HARD
V (CT)	EXTREMELY HARD

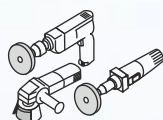
## 6. BOND

V (K)	CERAMIC
B (B)	RESINOID
BF (BY)	RESINOID WITH REINFORCEMENT
B4 (B4)	RESINOID WITH GRAPHITE FILLER

## 7. OPERATING SPEED, MPS

20; 25; 32; 35; 40; 50; 63; 80; 100

## Type of equipment



Portable grinder



Grinding machine



Butt-end grinding machine



Cutter-grinding machine



Surface grinding machine with rectangular table and horizontal spindle of grinding wheel



Surface grinding machine with rectangular table and vertical spindle of grinding wheel



Surface grinding machine with vertical spindle



Internal grinding machine



External grinding machine



Grinding machine without centre



For portable cutting-off machines with petrol and electric driver

## Choosing of abrasive material

MARK OF ABRASIVE MATERIAL GOST		AREA OF APPLICATION
14A	(A)	Processing of materials with high rupture strength, snagging of steel castings, rolled stock, high-strength cast iron, processing of carbon and alloyed steel, bronze, nickel and aluminum alloys.
25A	(WA)	Processing of the hardened details of carbon, high-speed and stainless steel. Processing of the fine details and tools (teeth, knives, drills, chisels), sharpening.
38A	(ZK)	Power grinding of steel work pieces by snagging
54C; 63C	(C; GC)	Processing of hard materials with low rupture strength (cast iron, bronze, brass, hard alloy, glass, precious stones, marble, granite, porcelain), and very tenacious materials (high-temperature steel, alloys, copper, aluminium).

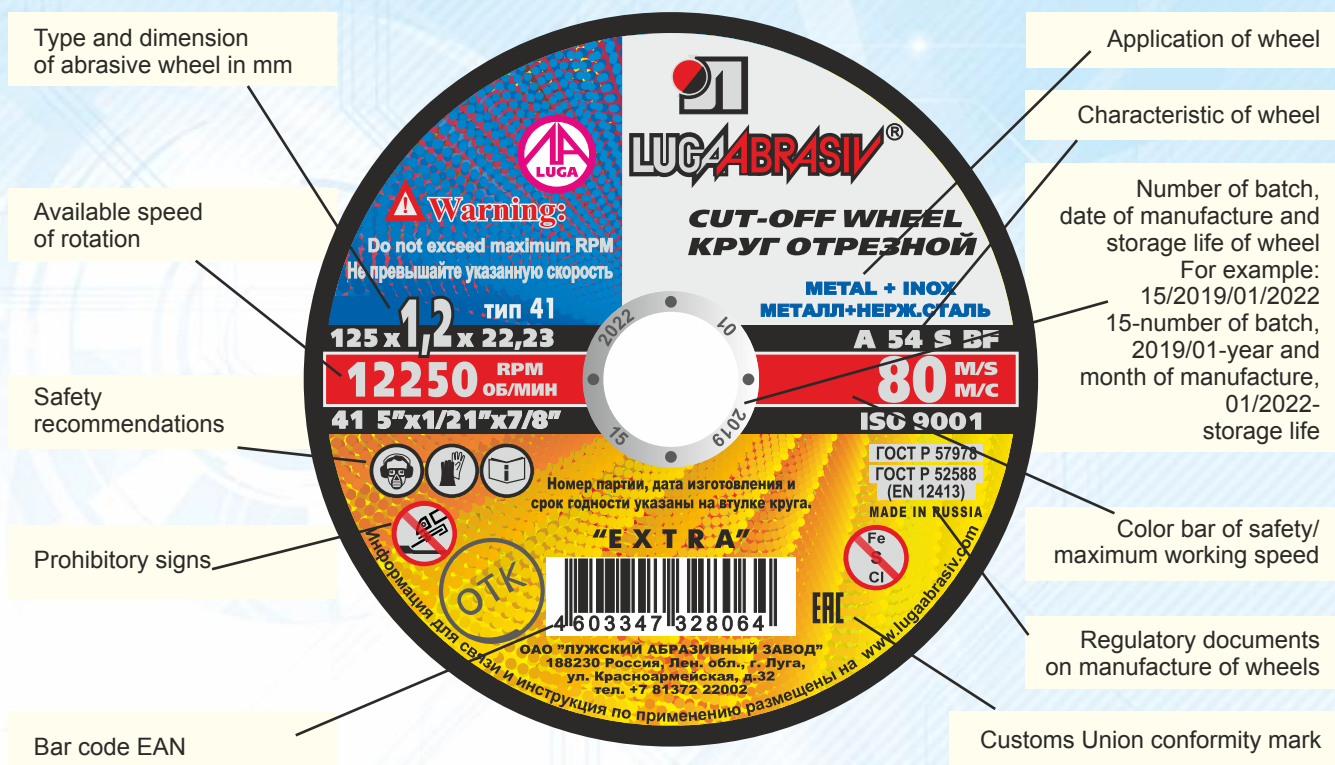
## Choosing of wheel grit

GRIT GOST	TYPE OF PROCESSING
F10-F22 (200-80)	Snagging operations with a large cutting depth, billet and casting grinding. Treatment of materials, causing loading of wheel's surface (brass, copper, aluminum).
F22-F36 (80-50)	Cutting off, surface grinding with the wheel face, chisel sharpening, abrasive tool dressing.
F30-F60 (63-25)	Preliminary and combined grinding, cutting tool sharpening.
F40-F220 (40-5)	Flat surface grinding.
F54-F90 (32-16)	Fine grinding, profile surface processing, small tool sharpening, grinding of brittle materials.
F100-F180 (12-6)	Finish grinding, lapping of cutting tools and steel billets, thin edge sharpening, preliminary honing.
F180-F280 (6-M50)	Finish grinding of metals, glass, marble and etc., thread grinding finish honing.
F230-F600 (M63-M14)	Superfinishing, finish honing, thin edge lapping, thread grinding of pieces with a fine pitch, polishing.

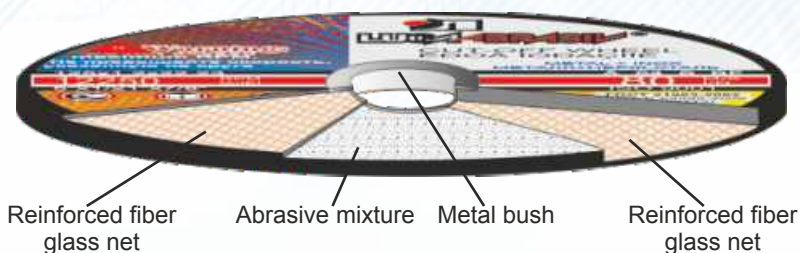
## Choosing of tool hardness

HARDNESS GOST	TYPE OF PROCESSING
W; T (4T; BT)	Snagging operations, abrasive tool setting, ball-bearing ball grinding
S; R; Q; P (T2; T1; CT3; CT2)	Cutting off, slotting, hand snagging operations, circular external grinding, centreless grinding, uneven surface and profile grinding.
P; O; N (CT2; CT1; C2)	Preliminary circular external and centreless grinding of steel, malleable cast iron. Profile grinding, uneven surface processing, honing and thread grinding of parts with a coarse.
O; N; M (CT1; C2; C1)	Flat surface grinding with the segments and annular wheels, thread grinding with the resinoid bond wheels.
N; M; L; K (C2; C1; CM2; CM1)	Fine and combined circular, external centreless and internal grinding of steel, flat surface grinding, thread grinding, cutting tools
L; K; J (CM2; CM1; M3)	Sharpening and lapping of hard-faced cutting tools, grinding of special-property alloys that are hard to process, polishing.

## MARKING ON ABRASIVE TOOLS



## CONFIGURATION OF WHEEL



It is necessary to keep safety regulations while application of cut-off and grinding wheels.

The corresponding pictograms are placed on all wheels.



To read the manual on safety before application



To work in safety gloves



Do not contain ferrum, sulfur and chlorine



To work in self-contained respiratory protective devices



To work in safety earphones



To work in safety goggles



It is prohibited to use on portable grinders



It is prohibited to use for frontal grinding



**NEW SERIES  
OF CUT-OFF WHEELS**

**Hi-tech**



**THIN**

**unique technology of manufacture  
of the thinnest in the world wheel!**

**INNOVATIVE**

**special materials and coating  
not just increase storage life  
but provide humidity  
resistance  
of the wheel**

**EFFECTIVE**

**provides cutting quickly, clearly,  
exactly, effortlessly**

***Clear and exact cutting  
without efforts!***

The wheels are made according to unique technology that allows to get the thinnest wheel.

The use of advanced technologies, modern equipment and specialized high-quality materials allows to achieve "thin" wheel height, regular hardness, the lowest disbalance that certainly guarantees an accurate and high-quality cutting.

**Wheels «Hi-tech» have a lot of advantages:**

- special materials and coating are used while manufacture of wheels that allows not just increase storage life but to provide also their humidity resistance that is important while transporting by sea;
- the thinnest wheels according to the world standards allow to make cuttings quickly, clearly, exactly, effortlessly;

Wheels work with a low level of noise and dust, herewith no burrs are formed and there is no discoloration of the metal. Minimal quantity of burrs and clean cut edges reduce machining times that makes cutting work much easier.



## THIN CUT-OFF WHEELS

**THIN CUT-OFF WHEELS** are produced according to the unique technology that does not have analogues in the world. Regular distribution of mass and reinforcing material in the wheel allows to have low disbalance, increased elasticity and flexibility of the wheels that is important when cutting various profile materials.

The persistence of "thin" wheels is at the level with wheels of greater height, and in some cases even higher.

**THIN cut-off wheels are intended for cutting by portable grinders:**

- tubes and profiles of each diameter;
- metal canes and wire;
- sheet metal;
- vehicle bodies etc.

**Type 41**

diameter mm	height mm	tool bore mm
115	0.8; 1.0; 1.2; 1.4; 1.6	22.23
125	0.8; 1.0; 1.2; 1.4; 1.6	22.23
150	1.0; 1.2; 1.4; 1.6; 1.8	22.23
180	1.4; 1.6; 1.8	22.23
230	1.6; 1.8; 2.0	22.23

**The main advantages while using of «thin» cut-off wheels:**

- ideal for cutting of above mentioned materials;
- metal is saved when cutting by thin cut-off wheels;
- high durability of the wheels, since work does not require large cutting forces (soft cutting);
- reduction of electricity consumption by 60% ;
- high cutting performance;
- low cutting temperature and smoothness are ensured by cutting less material;
- reducing of cutting temperature significantly reduces the risk of changes in the structure of metals - "burns";
- time is saved for additional processing of material, since when cutting the wheels leave less burrs;
- reduction of transport costs, storage facilities;
- the amount of wheel waste is reduced, and, accordingly, the problem with their disposal.

### APPLICATION

### AREA OF APPLICATION

#### INOX

corrosion-resistant (inox), acid-resistant and heat-resistant steels

#### NONFERROUS METALS

nonferrous metals, alloys on the base of nonferrous metals

#### METAL + INOX

universal wheels for cutting all grades of steel of a wide range, including INOX steel





## Series EXTRA PROFESSIONAL

**80m/s**

Applied equipment

Portable grinders

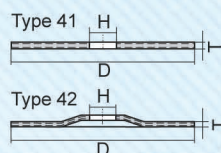


Well-known and popular series of cutting wheels presented on the Russian and foreign markets, with an optimal «price/quality» ratio.



They are applied to solve professional and household problems.

THIN cut-off wheels are represented in series in diameters from 76 mm to 230 mm and heights from 0.8 to 1.8 mm.



### Application:

■ Metal + inox

■ Non-ferrous metals

	Type	Dimension	Characteristic ■	Characteristic ■	RPM	Quantity of pcs in box
Thin cut-off wheels	41	76x0,8x9,55	A60 S BF		20110	200
	41	76x1,0/1,2x9,55	A54 S BF		20110	200
	41	76x1,4/1,6/1,8x9,55	A40 S BF		20110	200
	41	105x1,0x16	A54 S BF		15300	400
	41	115x0,8x22,23	A60 S BF		13300	400
	41/42	115x1,0/1,2x22,23	A54 S BF	A54 R BF	13300	400
	41/42	115x1,4x22,23	A40 S BF	A54 R BF	13300	400
	41/42	115x1,6x22,23	A40 S BF	A40 R BF	13300	400
	41/42	115x1,8x22,23	A40 S BF	A40 R BF	13300	200
	41	125x0,8x22,23	A60 S BF		12250	400
	41/42	125x1,0x22,23	A54 S BF	A54 R BF	12250	400
	41/42	125x1,2x22,23	A54 S BF	A54 R BF	12250	400
	41/42	125x1,4/1,6x22,23	A40 S BF	A54 R BF	12250	400
	41/42	125x1,8x22,23	A40 S BF	A40 R BF	12250	200
	41/42	150x1,0x22,23	A54 S BF		10200	200
	41/42	150x1,2x22,23	A54 S BF		10200	200
	41/42	150x1,4x22,23	A40 S BF	A54 R BF	10200	200
	41/42	150x1,6x22,23	A40 S BF	A40 R BF	10200	200
	41/42	150x1,8x22,23	A40 S BF		10200	200
	41/42	180x1,4x22,23	A40 S BF	A54 R BF	8500	200
	41/42	180x1,6x22,23	A40 S BF	A40 R BF	8500	150
	41/42	180x1,8x22,23	A40 S BF	A40 R BF	8500	150
	41/42	230x1,4x22,23/32	A40 S BF	A40 R BF	6650	100
	41/42	230x1,8x22,23/32	A36 S BF	A40 R BF	6650	100
	41/42	230x2,0x22,23	A36 S BF	A40 R BF	6650	50
	41	100x2,0x16/20	A36 S BF		15300	200
	41	100x2,5x16/20/22,23	A30 S BF		15300	200
	41	100x2,0x22,23	A36 S BF		15300	200
	41/42	115x2,0x22,23	A36 S BF	A40 R BF	13300	200
	41/42	115x2,5x22,23	A30 S BF	A36 R BF	13300	200
	41/42	115x3,0x22,23	A24 S BF	A36 R BF	13300	200
	41/42	125x2,0x22,23/32	A36 S BF	A40 R BF	12250	200
	41/42	125x2,5x22,23/32	A30 S BF	A36 R BF	12250	200
	41/42	125x3,0x22,23/32	A24 S BF		12250	200
	41/42	125x4,0x22,23/32	A24 S BF		12250	160
	41/42	150x2,0x22,23/32	A36 S BF	A40 R BF	10200	200
	41/42	150x2,5x22,23/32	A30 S BF	A36 R BF	10200	100
	41/42	150x3,0x22,23/32	A24 S BF	A36 R BF	10200	100
	41/42	150x4,0x22,23/32	A24 S BF		8500	60
	41/42	180x2,0x22,23/32	A36 S BF		8500	150
	41/42	180x2,5x22,23/32	A30 S BF	A36 R BF	8500	100
	41/42	180x3,0/4,0x22,23/32	A24 S BF	A36 R BF	8500	50
	41/42	230x2,5x22,23/32	A30 S BF	A36 R BF	6650	50
	41/42	230x3,0/4,0x22,23/32	A24 S BF	A36 R BF	6650	50/40

\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.



# CUTT-OFF WHEELS SERIES

## Series PREMIUM



Cut-off wheels of series Premium have the higher durability. It is achieved by usage of new technologies and materials of leading European producers.

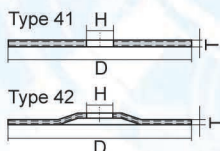
All line is universal, for high-performance cutting of all grades of steels of a wide range, including inox.

The series is represented by thin cut-off wheels in diameters from 115 to 230 mm and heights from 0,8 to 1,8 mm.

**80m/s**

Applied equipment

Portable grinders



### Application:

■ Metal + inox

	Type	Dimension	Characteristic	RPM	Quantity of pcs in box
Thin cut-off wheels	41	115x0,8x22,23	A60 S BF	13300	400
	41	115x1,0/1,2x22,23	A54 S BF	13300	400
	41	115x1,4/1,6x22,23	A40 S BF	13300	400
	41	115x1,8x22,23	A40 S BF	13300	200
	41	125x0,8x22,23	A60 S BF	12250	400
	41/42	125x1,0/1,2x22,23	A54 S BF	12250	400
	41/42	125x1,4/1,6x22,23	A40 S BF	12250	400
	41/42	125x1,8x22,23	A40 S BF	12250	200
	41	150x1,0x22,23	A54 S BF	10200	200
	41/42	150x1,2x22,23	A54 S BF	10200	200
	41/42	150x1,4/1,6/1,8x22,23	A40 S BF	10200	200
	41	180x1,4x22,23	A40 S BF	8500	200
	41/42	180x1,6/1,8x22,23	A40 S BF	8500	150
	41/42	230x1,6/1,8x22,23	A40 S BF	6650	100
	41/42	230x2x22,23	A36 S BF	6650	50
	41/42	115x2,0x22,23	A36 S BF	13300	200
	41/42	115x2,5x22,23	A30 S BF	13300	200
	41/42	115x3,0x22,23	A24 S BF	13300	200
	41/42	125x2,0x22,23	A36 S BF	12250	200
	41/42	125x2,5x22,23	A30 S BF	12250	200
	41/42	125x3,0x22,23	A24 S BF	12250	200
	41/42	150x2,0x22,23	A36 S BF	10200	200
	41/42	150x2,5x22,23	A30 S BF	10200	100
	41/42	180x2,0x22,23	A36 S BF	8500	50
	41/42	180x2,5x22,23	A30 S BF	8500	100
	41/42	180x3,0x22,23	A24 S BF	8500	50
	41/42	230x2,5x22,23	A30 S BF	6650	50
	41/42	230x3,0x22,23	A24 S BF	6650	50

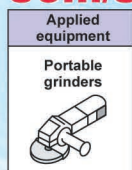


\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.



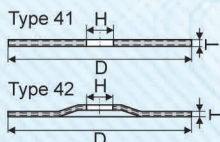
## Series LONG LIFE (stainless steel)

**80m/s** Specialized wheels for cutting of **STAINLESS STEEL**.



The special composition of the wheels allows you to avoid "burns" of the material to be cut and its soiling during processing.

The series includes THIN cut-off wheels in diameters from 76 to 230 mm and heights from 0.8 to 1.8 mm.



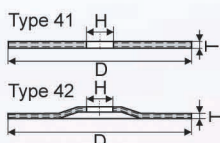
**Application:**

☒ Stainless steel



	Type	Dimension	Characteristic	Characteristic	RPM	Quantity of pcs in box
			<input type="checkbox"/>	<input checked="" type="checkbox"/>		
Thin cut-off wheels	41	76x1,0x9,55	WA54 S BF		20110	200
	41	105x1,2x16		A54 S BF	15300	400
	41	105x1,0/1,2x16/22,23	WA54 S BF		15300	400
	41	115x0,8x22,23	WA60 S BF	A60 S BF	13300	400
	41/42	115x1/1,2x22,23	WA54 S BF	A54 S BF	13300	400
	41/42	115x1,4/1,6x22,23	WA40 S BF	A40 S BF	13300	400
	41/42	115x1,8x22,23	WA40 S BF	A40 S BF	13300	200
	41	125x0,8x22,23	WA60 S BF	A60 S BF	12250	400
	41/42	125x1/1,2x22,23	WA54 S BF	A54 S BF	12250	400
	41/42	125x1,4x16	WA40 S BF		12250	400
	41/42	125x1,4/1,6x22,23	WA40 S BF	A40 S BF	12250	400
	41/42	125x1,8x22,23	WA40 S BF	A40 S BF	12250	200
	41/42	150x1,0/1,2x22,23	WA54 S BF	A54 S BF	10200	200
	41/42	150x1,4/1,6/1,8x22,23	WA40 S BF	A40 S BF	10200	200
	41/42	180x1,4x22,23	WA40 S BF	A40 S BF	8500	200
	41/42	180x1,6/1,8x22,23	WA40 S BF	A40 S BF	8500	150
	41/42	230x1,6/1,8x22,23	WA40 S BF	A40 S BF	6650	100
	41/42	230x2,0x22,23	WA36 S BF	A36 S BF	6650	150
	41	100x2,0x16	WA36 S BF		15300	200
	41/42	115x2,0x22,23	WA36 S BF		13300	200
	41/42	115x2,5x22,23	WA30 S BF	A30 S BF	13300	200
	41/42	125x2,0x22,23	WA36 S BF	A36 S BF	12250	200
	41/42	125x2,5x22,23	WA30 S BF	A30 S BF	12250	200
	41/42	125x3,0x22,23	WA24 S BF	A24 S BF	12250	200
	41/42	125x4,0x22,23	WA24 S BF		12250	160
	41/42	150x2,0x22,23	WA36 S BF	A36 S BF	10200	200
	41/42	150x2,5x22,23	WA30 S BF	A30 S BF	10200	100
	41/42	150x3,0/4,0x22,23	WA24 S BF		10200	100/60
	41/42	180x2,0x22,23	WA36 S BF	A36 S BF	8500	150
	41/42	180x2,5x22,23	WA30 S BF	A30 S BF	8500	100
	41/42	180x3,0/4,0x22,23	WA24 S BF		8500	150
	41/42	230x2,5x22,23/32	WA30 S BF	A30 S BF	6650	50
	41/42	230x3,0/4,0x22,23	WA24 S BF		6650	50/40

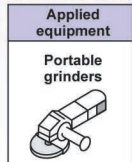
## Series LONG LIFE (metal + inox)



**Application:**

☒ Metal + inox

**80m/s** Special purpose wheels for cutting of different kinds of steel, including stainless steel.



The series includes THIN cut-off wheels in diameters from 76 to 230 mm and heights from 0.8 to 1.8 mm.



\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.

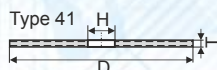


# CUTT-OFF WHEELS SERIES

## Cut-off wheels for HAND GRINDERS WITH PETROL OR ELECTRIC DRIVE



For high-performance cutting of the material with large cross-section made of different kinds of steels.

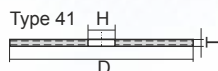


**Application:**  
☒ Metal + inox

Speed	Type	D(mm)	T(mm)	H(mm)	Characteristic	RPM
<b>80 m/s</b>	41	250	2.0-4.0	32	A24 S BF	6150
	41	300	2.5	20;22.23;25.4;32	A30 S BF	5100
	41	300	2.5-4.0	20;22.23;25.4;32	A24 S BF	5100
	41	350	3.0-4.0	20;22.23;25.4;32	A24 S BF	4400
	41	355	3.0-4.0	20;22.23;25.4;32	A24 S BF	4400
	41	400	3.0-4.0	22.23;25.4;32	A24 S BF	3850
<b>100 m/s</b>	41	300	3.0-4.0	20;22.23;25.4;32	A24 S BF	6400
	41	355	3.0-4.0	20;22.23;25.4;32	A24 S BF	5500
	41	400	4.0	32	A24 S BF	4800



For high-performance cutting of material with large cross-section made of stainless steel.



**Application:**  
☐ Stainless steel

Speed	Type	D(mm)	T(mm)	H(mm)	Characteristic	RPM
<b>80 m/s</b>	41	300	3.0-4.0	32	WA 24 S BF	5100
	41	355	3.0-4.0	25.4	WA 24 S BF	4400
	41	400	4.0	32	WA 24 S BF	3850

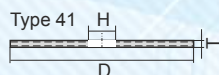


\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.

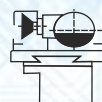


## Cut-off wheels for STATIONARY MACHINES

For high-performance cutting the details and constructions made of different kinds of steels.



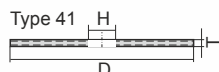
**Application:**  
 Metal + inox



Speed	Type	D(mm)	T(mm)	H(mm)	Characteristic	RPM
<b>80 m/s</b>	41	300	2.5	20;22.23;25.4;32	A30 S BF	5100
	41	300	2.5-4.0	20;22.23;25.4;32	A24 S BF	5100
	41	350	3.0-4.0	20;22.23;25.4;32	A24 S BF	4400
	41	355	3.0-4.0	20;22.23;25.4;32	A24 S BF	4400
	41	400	3.0-4.0	22.23;25.4;32	A24 S BF	3850
	41	300	3.0-4.0	20;22.23;25.4;32	A24 S BF	6400
	41	355	3.0-4.0	20;22.23;25.4;32	A24 S BF	5500
	41	400	4.0	32	A24 S BF	4800



For cutting of natural and artificial stone, fireproof bricks with large cross-section.



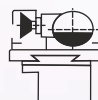
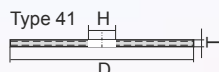
**Application:**  
 Stone+concrete



Speed	Type	D(mm)	T(mm)	H(mm)	Characteristic	RPM
<b>80 m/s</b>	41	500	4.5-5.0	32	C24 R BF	3100
	41	600	6.0	32	C24 R BF	2550
	41	610	7.0	76.2	C24 R BF	2550
	41	710	8.0	60	C24 R BF	2150
	41	900	8.0-12.0	100	C24 R BF	1700
	41	1200	12.0	100	C24 R BF	1300



For cutting reinforced concrete sleepers, natural and artificial stone, refractory bricks with a large cross-section.



Speed	Type	D(mm)	T(mm)	H(mm)	Characteristic	RPM
<b>100 m/s</b>	41	710	8.0	60	C 24 R BF	2700
	41	813	11.0	152.4	C 20 R BF	2400



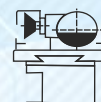
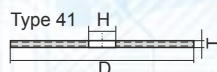
\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.

## Cut-off wheels for cutting of **RAILWAY RAILS**

### for **STATIONARY MACHINES**



For high-performance cutting of thermo-strengthened rails without burns.

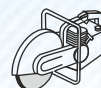
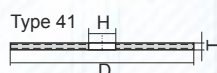


Speed	Type	D(mm)	T(mm)	H(mm)	Characteristic	RPM
<b>80 m/s</b>	41	300	3.0-4.0	32	A24 Q BF	5100
	41	350	3.5-4.0	32	A24 Q BF	4400
	41	400	4.0	32	A24 Q BF	3850
	41	500	5.0	32	A24 Q BF	3100

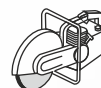
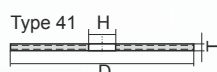
### for **HAND MACHINES WITH PETROL**

### OR **ELECTRIC DRIVE**

For high-performance cutting of thermo-strengthened rails without burns.



Speed	Type	D(mm)	T(mm)	H(mm)	Characteristic	RPM
<b>80 m/s</b>	41	300	3.0-4.0	20;22.23;25.4;32	A24 R BF	5100
	41	350	3.0-4.0	20;22.23;25.4;32	A24 R BF	4400
	41	355	3.5-4.0	20;22.23;25.4;32	A24 R BF	4400
	41	400	4.0	20;22.23;25.4;32	A24 R BF	3850



Speed	Type	D(mm)	T(mm)	H(mm)	Characteristic	RPM
<b>100 m/s</b>	41	300	3.0-4.0	22.23;25.4;32	A24 R BF	6400
	41	350	4.0	22.23;25.4;32	A24 R BF	5500
	41	355	4.0	22.23;25.4;32	A24 R BF	5500
	41	400	4.0	22.23;25.4;32	A24 R BF	4800

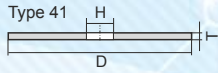


\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.

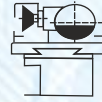


## Cut-off wheels for STATIONARY MACHINES

Specialized wheels for high-performance cutting without burns of all kinds of steels, cast iron, non-ferrous metal, aluminum, stone, concrete and other mineral materials.



**Application:**  
■ Steel



Wheel size (mm)		Characteristic	
D	100-400	Material	14A; 25A; 54C
T	1.0-4.0	Grit	F40-F90
H	20; 32	Hardness	K-Q

**50  
m/s**



**We test our products in factory's testing laboratory on automatic machines of leading European manufacturers.**



\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.



# SERIES OF GRINDING WHEELS

## Series EXTRA

## PROFESSIONAL

**80m/s**

Applied equipment

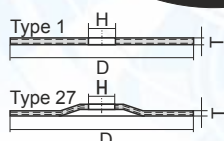
Portable grinders



Grinding wheels are intended for all kinds of smoothing of the details and constructions made of different kinds of steels. Smoothing of the welded and corner joints, chamfering, etc.

Application in industrial and craft production.

Suitable for all types and brands of angle grinders.



### Application:

■ Steel

■ Stone-concrete

■ Non-ferrous metals

Type	Dimension	Characteristic ■	Characteristic ■	Characteristic ■	RPM	pcs. in a box
1/27	100x6x16	A24 R BF			15300	80
1/27	115x5x22,23	A24 R BF			13300	120
1/27	115x6x22,23	A24 R BF	C24 R BF	A30 R BF	13300	80
1/27	125x5x22,23	A24 R BF			12250	120
1/27	125x6x22,23	A24 R BF	C24 R BF	A30 R BF	12250	80
1/27	125x7x22,23	A24 R BF			12250	80
1/27	125x8x22,23	A24 R BF	C24 R BF		12250	64
1/27	150x5x22,23	A24 R BF			10200	60
1/27	150x6x22,23	A24 R BF	C24 R BF	A30 R BF	10200	40
1/27	150x8x22,23	A24 R BF	C24 R BF		10200	40
1	150x10x22,23	A24 R BF	C24 R BF		10200	32
1	150x10x32	A24 R BF			10200	32
1/27	180x5x22,23	A24 R BF			8500	60
1/27	180x6x22,23	A24 R BF	C24 R BF	A30 R BF	8500	40
1/27	180x8x22,23	A24 R BF	C24 R BF		8500	30
1	180x10x22,23	A24 R BF	C24 R BF		8500	26
1	180x10x32	A24 R BF			8500	26
1/27	200x6x22,23	A24 R BF			7650	20
1	200x10x32	A24 R BF			7650	16
1/27	230x5x22,23	A24 R BF		A30 R BF	6650	30
1/27	230x6x22,23	A24 R BF	C24 R BF	A30 R BF	6650	20
1/27	230x8x22,23	A24 R BF	C24 R BF		6650	18
1/27	230x10x22,23	A24 R BF	C24 R BF		6650	14



\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.

Tel.: +7(81372) 22002

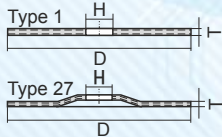
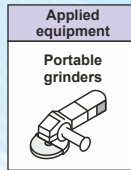
e-mail: lap@abrasives.ru

www.abrasives.ru



## Series PREMIUM

**80m/s**



Wheels of the **Premium** series have higher tool life and productivity. This is achieved by using new technologies and materials from leading European manufacturers. They are used for finish grinding of the details and constructions made of different kinds of steels.

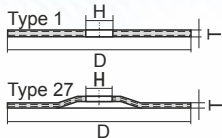
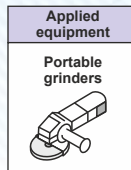
**Application:**  
☒ Steel



Type	Dimension (DxTxH)	Characteristic	RPM	pcs. in a box
1/27	115x6x22,23	A24 R BF	13300	80
1/27	125x6x22,23	A24 R BF	12250	80
1/27	150x6x22,23	A24 R BF	8500	40
1/27	180x6x22,23	A24 R BF	8500	40
1/27	230x6x22,23	A24 R BF	6650	20

## Series LONG LIFE

**80m/s**



The special composition of the grinding wheels allows to smoothing of the details and constructions made of noble stainless steels.

**Application:**  
☐ Stainless steel



Type	Dimension (DxTxH)	Characteristic	RPM	pcs. in a box
27	100x6x16	WA24 S BF	15300	80
1/27	115x6x22,23	WA24 S BF	13300	80
1/27	125x6x22,23	WA24 S BF	12250	80
27	125x7x22,23	WA24 S BF	12250	80
1/27	150x6/7x22,23	WA24 S BF	10200	40
1/27	180x6x22,23	WA24 S BF	8500	40
1/27	230x6x22,23	WA24 S BF	6650	20
1/27	230x7x22,23	WA24 S BF	6650	20/16

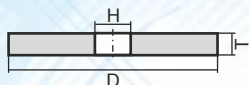


\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.



# GRINDING WHEELS

## Type 1



Intended for all kinds of grinding of the details and constructions made of different kinds of steels, cast-iron, non-ferrous metals, natural and artificial stone and other mineral materials.



**50  
m/s**

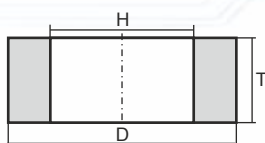
**40  
m/s**

Wheel size (mm)		Characteristic	
D	50-900	Material	14A; 54C
T	6-100	Grit	F16-F90
H	16-305	Hardness	K-Q

**63  
m/s**

D, (mm)	T, (mm)	H, (mm)	Characteristic	Characteristic	RPM	pcs. in a box
63	20	20	14A 24 R BF	54C 24 R BF	19100	50
80	20	20	14A 24 R BF	54C 24 R BF	15100	20
100	20	20	14A 24 R BF	54A 24 R BF	12100	32
125	16/20/25	32	14A 24 R BF	54C 24 R BF	9650	32/24/16
150	16/20/25	32	14A 24 R BF	54C 24 R BF	8050	20/16/12
200	25	32	14A 24 R BF	54C 24 R BF	6050	6

## Type 2



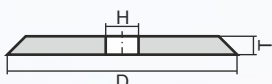
**32  
m/s**

**40  
m/s**

Intended for flat grinding by a butt-end of the wheel of the details and constructions made of different kinds of steels and mineral materials.

Wheel size (mm)		Characteristic	
D	125-500	Material	14A; 25A; 54C
T	75-150	Grit	F36-F90
H	18-60	Hardness	J-Q

## Type 3



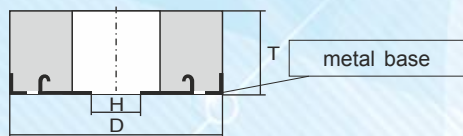
**40  
m/s**

Intended for sharpening of teeth of rip- and disc saws made of tool steels.

Wheel size (mm)		Characteristic	
D	80-300	Material	14A; 25A
T	3-16	Grit	F24-F90
H	12,7-127	Hardness	L-Q

\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.

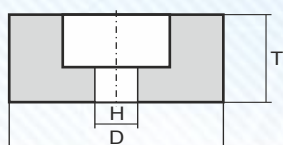


**Type 5 with metal bottom****50  
m/s**

Bedding of wheel is strengthened by special metal base. This kind of tool allows to increase life cycle of the tool by about 20% by reducing holding height.

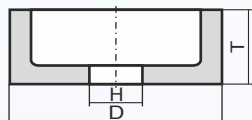
Wheel size (mm)	Characteristic
D 100;125;150	Material 14A; 54C
T 40-65	Grit F16-F100
H 20;M14;M20	Hardness K-Q

**Field of application:** processing of concrete products, surfaces of concrete, granite, marble (for example: monuments, floors). They allow to carry out pre-alignment of surfaces and removal of coating, as well as finishing with required roughness.

**Type 5****32  
m/s**

Intended for all kinds of grinding and roughing jobs, details and constructions made of different kinds of steels, stone, concrete and other mineral materials.

Wheel size (mm)	Characteristic
D 40-63/125-250	Material 14A; 54C
T 40-80	Grit F16-F40
H 32-76	Hardness K-Q

**Type 6****32  
m/s**

Intended for flat, round external and internal grinding details, constructions made of different kinds of steels, stone, concrete and other mineral materials.

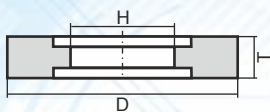
Wheel size (mm)	Characteristic
D 80-250	Material 14A; 25A; 54C
T 40-100	Grit F20-F150
H 20-150	Hardness J-Q

\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.



# GRINDING WHEELS

## Type 7

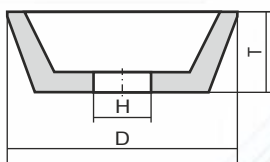
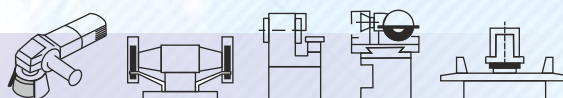


Intended for flat, round external and internal grinding of the details and constructions made of different kinds of steels, sharpening the cutting tool made of high-speed steels.

**40  
m/s**

Wheel size (mm)		Characteristic	
D	250-300	Material	14A; 54C
T	63-150	Grit	F16-F90
H	127	Hardness	M-Q

## Type 11



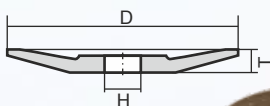
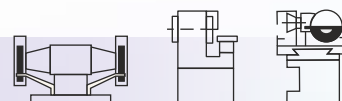
Intended for high-performance grinding and smoothing of the details and constructions made of different kinds of steels, cast-iron, non-ferrous metals and mineral materials.

**32  
m/s**

**50  
m/s**

Wheel size (mm)		Characteristic	
D	80-150	Material	14A; 54C
T	32-50	Grit	F16-F90
H	20-32	Hardness	K-Q
D	110-125	Material	14A; 54C
T	50-55	Grit	F16-F30
H	22,23-32 M14; M16	Hardness	O-Q

## Type 12



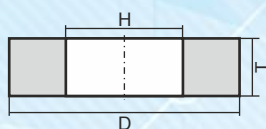
Intended for sharpening the cutting tool made of tool steels, slotting of grooves in details made of different kinds of steels and mineral materials.

**32  
m/s**

Wheel size (mm)		Characteristic	
D	80-125	Material	63C
T	8-13	Grit	F90-F150
H	13-32	Hardness	J-P

\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.

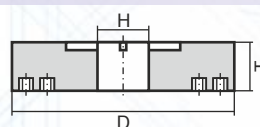
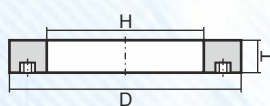
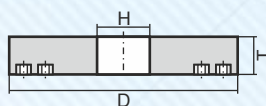


**Type 35**

**40  
m/s**

Intended for flat grinding by a butt-end of the wheel of the details and constructions made of different kinds of steels and mineral materials.

Wheel size (mm)		Characteristic	
D	350-900	Material	14A; 54C
T	20-150	Grit	F16-F90
H	127-305	Hardness	K-Q

**Type 36****Type 37****Type 40**

**30 m/s  
32 m/s  
35 m/s**

**40 m/s  
50 m/s**

Intended for flat grinding by a butt-end of the wheel of the details and constructions made of different kinds of steels, cast iron, non-ferrous metals and mineral materials.

Wheel size (mm)		Characteristic	
D	450-900	Material	14A; 25A; 54C
T	40-75	Grit	F16-F120
H	25-350	Hardness	J-Q
		Structure	6-9
D	150	Material	14A; ZK
T	63- 73	Grit	F16-F40
H	51-56	Hardness	M-Q

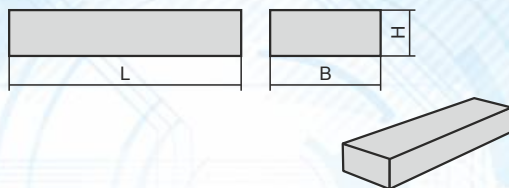


\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.



# SEGMENTS AND WHETSTONES

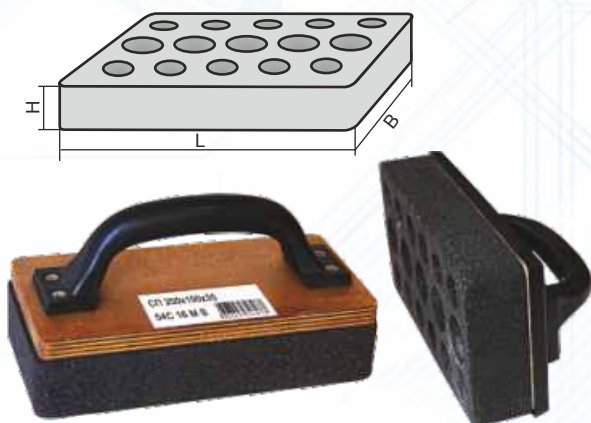
## Type SP



Segment size (mm)	Characteristic
B 60 -200 H 25 -100 L 35 -160	Material 14A; 54C Grit F16-F90 Hardness J-Q

Intended for flat grinding the details and constructions made of different types of steels, cast iron construction, non-ferrous metals and mineral materials.

## SP-art.5

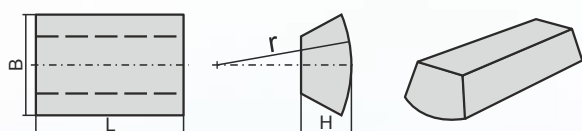
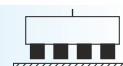


Segment size (mm)	Characteristic
B 100 H 35 L 200	Material 54C Grit F16-F40 Hardness K-M

Intended for hand processing of concrete surfaces, artificial and natural stone.

Segments production with handle is possible.

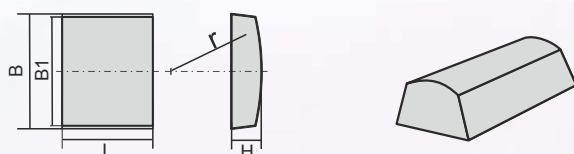
## Type 3C



Segment size (mm)	Characteristic
B 100-150 H 75-240 L 220-380	Material 14A; 54C Grit F16-F90 Hardness K-Q

Intended for flat grinding the details and constructions made of different types of steels and mineral materials.

## Type 4C



Segment size (mm)	Characteristic
B 100-190 H 40 -50 L 150	Material 14A; 54C Grit F16-F90 Hardness K-Q

Intended for flat grinding the details and constructions made of different types of steels and mineral materials.

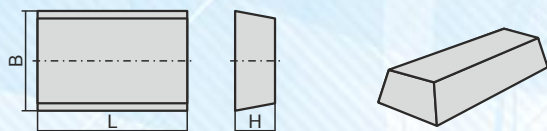
\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.



## Type 5C

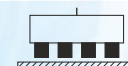


Intended for flat grinding the details and constructions made of different types of steels and mineral materials.

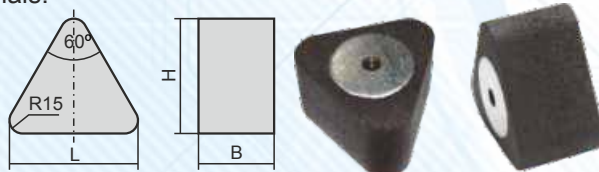


Segment size (mm)		Characteristic	
B	60-120	Material	14A; 25A; 54C
H	16-40	Grit	F16-F120
L	125-220	Hardness	J-Q

## Type 6C



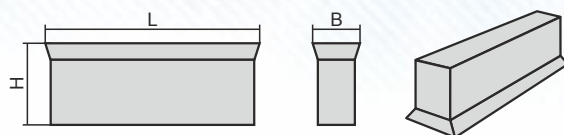
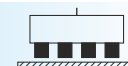
Intended for flat grinding the details and constructions made of different types of steels and mineral materials.



Segment size (mm)		Characteristic	
B	50	Material	14A; 54C
H	78	Grit	F16-F90
L	85	Hardness	K-Q

Grinding segment 6C 85x78x50 has a base group of which metal plain washer with nut for thread M10 is pressed in. The construction lets fix segment with the help of screw bolt to holder block of mosaic-grinding machine more durably. Metal plain washer and anchor nut are situated from the side of holder block and don't disturb work on the machines without holding tool also.

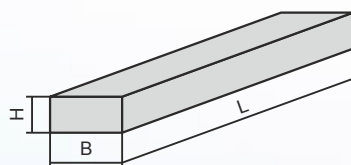
## Type 9C



Segment size (mm)		Characteristic	
B	86	Material	14A
H	150	Grit	F16
L	394	Hardness	O-Q

For equipping of rail-grinding trains RShP-112 at processing of thermo-strengthened rails.

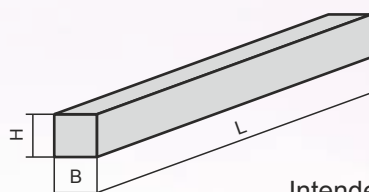
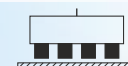
## Type BP



Segment size (mm)		Characteristic	
B	15-80	Material	14A; 25A; 54C; 63C
H	14-25	Grit	F40-F150
L	150-200	Hardness	N-O

Intended for flat and round outer grinding, honing the details made of different types of steels, sharpening and setting of cutting tools.

## Type BKv



Segment size (mm)		Characteristic	
B	13-40	Material	14A; 25A; 54C; 63C
H	13-40	Grit	F40-F150
L	75-200	Hardness	J-P

Intended for flat grinding and constructions made of different types of steels.

\* The plant receives orders for the manufacture of wheels with dimensions and characteristics not specified in present tables.



## Skin-packing is leading packaging view

Top film fits closely of wheel, therefore it is possible to prolongate shelf life of wheel and to demonstrate wheel on store shelves profitably.

The film is impervious. It completely defends subject from anyone atmospheric agents during transportation.

Skin-packing made from heat-shrink film and it is much more economical than other types of packing. It saves its properties over a wide temperature range.

It is convenient to large distribution network. Availability of Euro Hang Tab allows to place conveniently the goods on stands of salesroom.

Products are protected from damages during storage and transportation.







JSC «LUGA ABRASIVE PLANT» was founded in 1906.

We cherish our rich history, traditions and vast experience in manufacture of abrasive tools. Today JSC "Luga Abrasive Plant" is one of the largest and highly efficient plants in the world.

We sell more 300 000 000 pieces per year of cut-off resinoid bond wheels, manufacture flap wheels made of coated abrasives and other goods, ceramic bonded tool, crucibles for melting of non-ferrous metals.

The products of the plant enjoy great popularity both in Russia and abroad. Competent and well-thought-out strategy, the latest technologies, modern equipment, professional and cohesive team - all that is a reliable basis for the successful and dynamic development of the plant!

## QUALITY RELIABILITY EXPERIENCE!

The products of JSC "Luga Abrasive Plant" comply with the requirements of the Technical Regulations of the Customs Union "On the safety of machinery and equipment" (TRSU 010/2011) and the Unified Sanitary and Epidemiological Requirements.



The plant is constantly awarded with state awards and diplomas for achieving high success in the engineering industry.

The company is a member of Federation of European Producers of Abrasives – FEPA.

Since November 2001, JSC "Luga Abrasive Plant" has developed, implemented and successfully operates a quality management system for compliance with the requirements of EN ISO 9001. The system is maintained in working order due to constant internal tests and an annual inspection audit. Every 3 years the QMS of JSC "Luga Abrasive Plant" is recertified for compliance with the requirements of EN ISO 9001.

QMS ISO EN 9001: 2015 TUV AUSTRIA HELLAS certificate No. 061610009862 is received on November 20, 2017. It confirms the eligibility of the production of JSC "Luga Abrasive Plant" to enter the international market and expands the possibilities of concluding contracts. Abroad, it is the presence of a quality management system certificate that is a decisive factor in choosing a supplier and a necessary condition for concluding a contract. Compliance with ISO standards is the best guarantee that manufacturers can give their customers in terms of quality.





## DRIVING DIRECTIONS:

LUGA ABRASIVE PLANT



DRIVING DIRECTIONS  
TO CENTRAL OFFICE



DRIVING DIRECTIONS  
TO LUGA2 WAREHOUSE



JSC "Luga Abrasive Plant"



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