

## Felt wheels

### Felt wheels



Felt wheels are mainly used for polishing with the peripheral surface.

Felt wheels with metal inserts (MS) provide increased stock removal in pre-polishing with diamond abrasive pastes.


#### Ordering note:

Please order arbor separately.

#### Ordering example:

EAN 4007220**295359**

FK SC 10020/10 MS

| Description       | EAN<br>4007220 | D x T<br>[mm] | H<br>[mm] | Recom.<br>speed<br>[RPM] | Max.<br>perm.<br>speed<br>[RPM] | Suitable<br>arbors               |  |
|-------------------|----------------|---------------|-----------|--------------------------|---------------------------------|----------------------------------|---|
| FK SC 3007/6      | 153864         | 30 x 7        | 6         | 3,000–6,000              | 20,000                          | BO 6/6 3-10                      | 5   |
| FK SC 4509/6      | 153840         | 45 x 9        | 6         | 2,000–4,000              | 13,500                          | BO 6/6 3-10                      | 5   |
| FK SC 6010/6      | 297605         | 60 x 10       | 6         | 1,500–3,000              | 10,000                          | BO 6/6 3-10                      | 5   |
| FK SC 8010/10     | 154069         | 80 x 10       | 10        | 1,000–2,000              | 7,500                           | BO 8/10 6-20                     | 5   |
| FK SC 10020/10    | 297612         | 100 x 20      | 10        | 900–1,800                | 6,100                           | BO 8/10 6-20                     | 1   |
| FK SC 12520/20    | 297629         | 125 x 20      | 20        | 750–1,500                | 4,900                           | BO 12/20 10-50, BO MK 1/20 10-50 | 1   |
| FK SC 15025/20    | 297636         | 150 x 25      | 20        | 600–1,200                | 4,000                           | BO 12/20 10-50, BO MK 1/20 10-50 | 1   |
| FK SC 20030/20    | 297643         | 200 x 30      | 20        | 500–1,000                | 3,000                           | BO 12/20 10-50, BO MK 1/20 10-50 | 1   |
| FK SC 8010/10 MS  | 295342         | 80 x 10       | 10        | 1,000–2,000              | 7,500                           | BO 8/10 6-20                     | 5   |
| FK SC 10020/10 MS | 295359         | 100 x 20      | 10        | 900–1,800                | 6,100                           | BO 8/10 6-20                     | 1   |
| FK SC 12520/20 MS | 295366         | 125 x 20      | 20        | 750–1,500                | 4,900                           | BO 12/20 10-50, BO MK 1/20 10-50 | 1   |



Felt flap discs are used with polishing pastes for pre-polishing and high-gloss polishing of medium to large-sized components.

With its flap design, this polishing tool adapts ideally to the workpiece contours. The thermal load of the workpiece is significantly reduced.

### Recommendations for use:

- The hard type is ideal for pre-polishing flat surfaces
- The soft type is optimal for buffing and work on workpieces with lots of contours
- If very fine finishes need to be achieved, the two types can be used successively. This requires the use of suitable polishing pastes.


### Ordering example:

EAN 4007220936085

FFS 115/22.23 W

Please complete the description with the desired type.



| Description   | Type        |          | D x T [mm] | H [mm] | Recom. speed [RPM] | Max. perm. speed [RPM] |  |
|---------------|-------------|----------|------------|--------|--------------------|------------------------|---|
|               | W (soft)    | H (hard) |            |        |                    |                        |   |
|               | EAN 4007220 |          |            |        |                    |                        |   |
| FFS 115/22,23 | 936085      | 936139   | 115 x 22   | 22.23  | 1,650              | 8,350                  | 5   |
| FFS 125/22,23 | 936146      | 936153   | 125 x 22   | 22.23  | 1,500              | 7,650                  | 5   |

Cloth rings are used with polishing pastes for pre-polishing and high-gloss polishing.

For very smooth finishes it may be recommended to use several, or even all, types in succession.

Cloth rings are available in four types:

- ST (sisal fabric) = Coarse pre-polishing
- TH (hard cloth) = Pre-polishing
- TW (soft cloth) = High-gloss polishing
- FL (flannel) = High-gloss polishing/buffing

### Recommendations for use:

- Pre-polishing of steel and INOX: cloth rings ST or TH with polishing paste PP 1 VP Fe
- Pre-polishing of aluminium and brass: cloth rings ST or TH with polishing paste PP 2 VP MS
- Pre-polishing of non-ferrous metals: cloth rings ST or TH with polishing paste PP 3 VP NE

- High-gloss polishing of all metals: cloth rings TW or FL with polishing paste PP 4 HGP
- High-gloss polishing of plastics: cloth rings TW or FL with polishing paste PP 5 HGP K

Recommended cutting speeds:

- Cloth rings of type TW and FL achieve their best performance at a recommended cutting speed of 5–15 m/s
- Cloth rings of type ST and TH achieve their best performance at a recommended cutting speed of 10–15 m/s

### Ordering note:

Please order arbors separately.  
TR 12510 type ST: 10 mm centre hole (25.4/6 edge, arbor FR/VR12/25.4)


### Ordering example:

EAN 4007220294185

TR 12510-20 TW

Please complete the description with the desired type.



| Description | Type        |        |        |        | D [mm] | Used width [mm] | H [mm] | Recom. speed [RPM] | Max. perm. speed [RPM] | Suitable arbors                     |  |
|-------------|-------------|--------|--------|--------|--------|-----------------|--------|--------------------|------------------------|-------------------------------------|---|
|             | ST          | TH     | TW     | FL     |        |                 |        |                    |                        |                                     |   |
|             | EAN 4007220 |        |        |        |        |                 |        |                    |                        |                                     |   |
| TR 5010-6   | -           | 804315 | 804322 | 804339 | 50     | 10              | 6      | 3,800              | 12,000                 | BO 6/6 3-10                         | 5   |
| TR 8010-10  | 294086      | 294093 | 294109 | 294116 | 80     | 10              | 10     | 2,500              | 7,500                  | BO 8/10 6-20                        | 5   |
| TR 10010-10 | 294123      | 294130 | 294147 | 294154 | 100    | 10              | 10     | 1,900              | 6,100                  | BO 8/10 6-20                        | 5   |
| TR 12510-20 | 294161      | 294178 | 294185 | 294192 | 125    | 10              | 20     | 1,300              | 4,900                  | BO 12/20 10-50,<br>BO MK 1/20 10-50 | 5   |
| TR 15010-20 | 294208      | 294215 | 294222 | 294239 | 150    | 10              | 20     | 1,250              | 4,000                  | BO 12/20 10-50,<br>BO MK 1/20 10-50 | 5   |
| TR 20010-20 | 294246      | 294253 | 294260 | 294277 | 200    | 10              | 20     | 950                | 3,000                  | BO 12/20 10-50,<br>BO MK 1/20 10-50 | 5   |