



For many different applications, PFERD provides a comprehensive range of abrasive spiral bands with various

- shapes,
- dimensions,
- abrasives,
- grit sizes and
- packaging units.

Matching, reusable rubber drum holders in two different shapes are available for using abrasive spiral bands:

- Cylindrical
- Conical

The high degree of fitting accuracy between the components ensures that the abrasive spiral band remains securely attached to the rubber drum holder during use.

Abrasive spiral bands are designated "Cylindrical Abrasive Sleeves" according to ISO 2421.

Cylindrical rubber drum holders are designated "Holding Fixtures of Cylindrical Abrasive Sleeves" according to ISO 15637-1.

Advantages:

- Because of slots, the holder expands during use, guaranteeing that the abrasive spiral band is firmly clamped in place
- Outstanding tool life due to special manufacturing process – even under the most demanding operating conditions
- Particularly high stock removal and high aggressiveness of the abrasive

Recommendations for use:

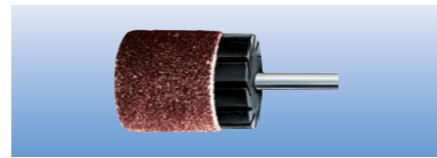
- Abrasive spiral bands can be mounted and removed by turning them slightly to the right
- Abrasive spiral bands are easier to mount when the rubber drum holder is mounted on the tool drive
- The secure attachment of the abrasive spiral band is only guaranteed if the minimum rotational speed is observed
- Abrasive spiral bands achieve their best performance at a recommended cutting speed of 20–30 m/s
- Use grinding oil that is suitable for the material in order to significantly increase the tool life and the abrasive performance of the tools. More detailed information and ordering data for grinding oils can be found on page 120.

Application examples:

- Removing weld seams in steel construction
- Fine grinding work in equipment, tank and vessel construction
- Post-processing for assembly and repair work
- Machining edges and contours in aircraft engine construction

Safety notes:

- The maximum permitted peripheral speed is 30 m/s
- For safety reasons, it is imperative to remain within the stated maximum permitted rotational speed at all times
- Do not allow abrasive spiral bands to protrude beyond the rubber body



Ordering instructions:

When ordering, please state the EAN or the complete description. Please complete the description with the desired grit size.

Ordering example:
EAN 4007220148426
GSB 4530 Z-COOL 36

Ordering example explanation:
GSB = Abrasive spiral bands, bulk pack
4530 = Inner dia. D x width T [mm]
Z = Abrasive
COOL = Bond type
36 = Grit size



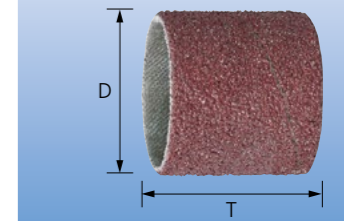
Suitable for general grinding applications from fine to very fine grinding on metals and other materials.


Abrasive: Aluminium oxide A

Ordering example:
EAN 4007220149461
KSB 4530 A 40

Please complete the description with the desired grit size.

**Abrasive spiral bands
Aluminium oxide A – small pack**

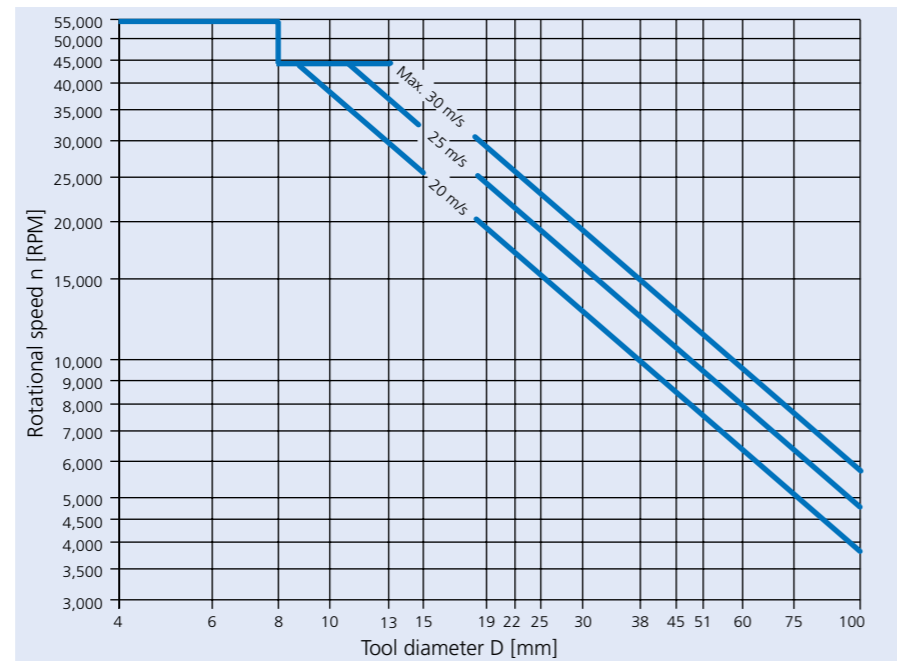


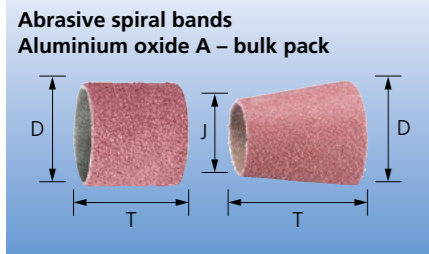
Description	Grit size						D x T [mm]	Recom. speed [RPM]	
	40	50	60	80	150	240			
EAN 4007220									
Cylindrical shape									
KSB 0410 A	-	-	-	-	148860	-	4 x 10	30,000–55,000	25
KSB 0610 A	-	-	-	-	148884	-	6 x 10	30,000–55,000	25
KSB 0810 A	-	-	-	-	148907	-	8 x 10	30,000–55,000	25
KSB 1010 A	-	-	-	148921	148938	-	10 x 10	30,000–44,000	25
KSB 1020 A	-	-	-	148952	148969	148976	10 x 20	30,000–44,000	25
KSB 1310 A	-	-	-	148983	148990	-	13 x 10	30,000–44,000	25
KSB 1325 A	-	-	-	149010	149027	-	13 x 25	30,000–44,000	25
KSB 1510 A	-	-	149041	149058	149065	-	15 x 10	26,000–36,000	25
KSB 1530 A	-	149089	149096	149102	149119	149126	15 x 30	26,000–36,000	25
KSB 1925 A	-	-	149133	149140	149157	149164	19 x 25	20,000–30,000	25
KSB 2220 A	-	149171	149188	149195	149201	-	22 x 20	18,000–26,000	25
KSB 2525 A	-	-	149225	149232	149249	-	25 x 25	16,000–22,900	25
KSB 3020 A	149263	-	149270	149287	149294	-	30 x 20	13,000–19,100	25
KSB 3030 A	149324	149317	149331	149348	149355	-	30 x 30	13,000–19,100	25
KSB 3825 A	149379	-	149386	149393	149409	-	38 x 25	10,000–15,900	25
KSB 4530 A	149461	149454	149478	149485	149492	-	45 x 30	8,500–12,700	10
KSB 5125 A	149515	-	149522	149539	149546	-	51 x 25	7,500–11,200	10
KSB 6030 A	149577	149560	149584	149591	149607	-	60 x 30	6,500–9,500	10
KSB 7530 A	149614	-	149621	149638	149645	-	75 x 30	5,000–7,600	10

Cutting speeds

In the diagram, the cutting speeds are represented by blue diagonal lines. The vertical line representing the tool diameter meets the given cutting speed (diagonals). From its point of intersection, proceed horizontally to the left margin, where you will find the corresponding rotational speed [RPM] for the abrasive spiral band and tool drive.

Example:
KSB 4530 A 60
Cutting speed: 20–30 m/s
Rotational speed: 8,500 – 12,500 RPM





Abrasive spiral bands
Aluminium oxide A – bulk pack

Suitable for general grinding applications from fine to very fine grinding on metals and other materials.

Available in cylindrical and conical shapes.

Abrasive: Aluminium oxide A

Ordering example:
EAN 4007220148372
GSB 4530 A 40
Please complete the description with the desired grit size.

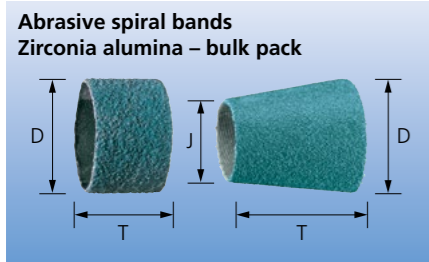
Description	Grit size						D x J x T [mm]	Recom. speed [RPM]	
	40	50	60	80	150	240			

Cylindrical shape

EAN 4007220									
GSB 0410 A	-	-	-	-	147610	-	4 x 10	30,000–55,000	100
GSB 0610 A	-	-	-	-	147634	-	6 x 10	30,000–55,000	100
GSB 0810 A	-	-	-	-	147658	-	8 x 10	30,000–55,000	100
GSB 1010 A	-	-	-	147672	147689	-	10 x 10	30,000–44,000	100
GSB 1020 A	-	-	949740	147702	147719	147726	10 x 20	30,000–44,000	100
GSB 1310 A	-	-	-	147733	147740	-	13 x 10	30,000–44,000	100
GSB 1325 A	-	-	-	147764	147771	-	13 x 25	30,000–44,000	100
GSB 1510 A	-	-	147795	147801	147818	-	15 x 10	26,000–36,000	100
GSB 1530 A	-	147832	147849	147856	147863	147870	15 x 30	26,000–36,000	100
GSB 1925 A	-	-	147931	147948	147955	-	19 x 25	20,000–30,000	100
GSB 2220 A	-	147979	147986	147993	148006	148013	22 x 20	18,000–26,000	100
GSB 2525 A	-	-	148075	148082	148099	-	25 x 25	16,000–22,900	100
GSB 3020 A	148112	-	148129	148136	148143	-	30 x 20	13,000–19,100	100
GSB 3030 A	148174	148167	148181	148198	148204	148211	30 x 30	13,000–19,100	100
GSB 3825 A	148280	-	148297	148303	148310	-	38 x 25	10,000–15,900	100
GSB 4530 A	148372	148365	148389	148396	148402	148419	45 x 30	8,500–12,700	100
GSB 5125 A	148488	-	148495	148501	148518	-	51 x 25	7,500–11,200	100
GSB 6030 A	148549	148532	148556	148563	148570	-	60 x 30	6,500–9,500	100
GSB 7530 A	148648	-	148655	148662	148679	-	75 x 30	5,000–7,600	100
GSB 10040 A	148686	-	148693	148709	148716	-	100 x 40	4,000–5,700	50

Conical shape

GSB 201463 A	148723	-	148730	148747	148754	148761	20 x 14 x 63	19,000–26,000	100
GSB 292230 A	148778	-	148785	148792	148808	-	29 x 22 x 30	13,000–19,100	100
GSB 362260 A	148822	-	148839	148846	148853	-	36 x 22 x 60	10,000–15,900	100



Abrasive spiral bands
Zirconia alumina – bulk pack

Designed for maximum stock removal.

The outstandingly aggressive cutting quality of zirconia alumina is effective at increased contact pressures and ensures exceptional stock removal.

Available in cylindrical and conical shapes.

Abrasive: Zirconia alumina Z

Ordering example:
EAN 4007220805664
GSB 4530 Z 40
Please complete the description with the desired grit size.

Description	Grit size						D x J x T [mm]	Recom. speed [RPM]	
	36	40	50	60	80	120			

Cylindrical shape

EAN 4007220									
GSB 1325 Z	-	-	804827	804872	804889	949757	13 x 25	30,000–44,000	100
GSB 1925 Z	-	804896	804902	804940	804957	949764	19 x 25	20,000–30,000	100
GSB 2525 Z	949771	805022	805077	805084	805091	949788	25 x 25	16,000–22,900	100
GSB 3030 Z	949795	805145	805152	805176	805183	-	30 x 30	13,000–19,100	100
GSB 3825 Z	949801	805190	949818	805206	949825	949832	38 x 25	10,000–15,900	100
GSB 4530 Z	-	805664	805671	805725	805732	-	45 x 30	8,500–12,700	100

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Description	Grit size						D x J x T [mm]	Recom. speed [RPM]	
	36	40	50	60	80	120			

EAN 4007220									
GSB 5125 Z	949849	803943	949856	803950	803967	949863	51 x 25	7,500–11,200	100

Conical shape

GSB 201463 Z	950050	-	950074	950081	950098	950104	20 x 14 x 63	19,000–26,000	100
GSB 292230 Z	950067	-	950128	950135	950142	950159	29 x 22 x 30	13,000–19,100	100
GSB 362260 Z	950166	-	950241	950258	950265	950289	36 x 22 x 60	10,000–15,900	100

Particularly suitable for work on stainless steel (INOX).

Ordering example:
EAN 4007220148426
GSB 4530 Z-COOL 36

Active grinding additives in the coating significantly improve stock removal, prevent clogging and result in cooler grinding.

Please complete the description with the desired grit size.

Abrasive: Zirconia alumina Z-COOL



Abrasive spiral bands
Zirconia alumina Z-COOL – bulk pack

Description	Grit size				D x T [mm]	Recom. speed [RPM]	
	36	50	80	150			

Cylindrical shape

EAN 4007220							
GSB 1530 Z-COOL	-	147887	147894	147924	15 x 30	26,000–36,000	100
GSB 2220 Z-COOL	-	148020	148037	148068	22 x 20	18,000–26,000	100
GSB 3030 Z-COOL	148228	148235	148242	148273	30 x 30	13,000–19,100	100
GSB 4530 Z-COOL	148426	148433	148440	148471	45 x 30	8,500–12,700	100
GSB 6030 Z-COOL	148587	148594	148600	148631	60 x 30	6,500–9,500	100

For aggressive grinding with maximum stock removal on hard and tough materials which do not conduct heat well.

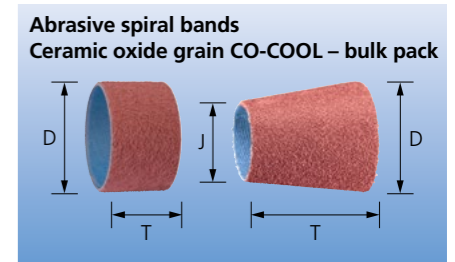
Ordering example:
EAN 4007220772362
GSB 4530 CO-COOL 60

Active grinding additives in the coating significantly improve stock removal, prevent clogging and result in cooler grinding.

Please complete the description with the desired grit size.

Available in cylindrical and conical shapes.

Abrasive: Ceramic oxide grain CO-COOL



Abrasive spiral bands
Ceramic oxide grain CO-COOL – bulk pack

Description	Grit size				D x J x T [mm]	Recom. speed [RPM]	
	36	60	80	120			

Cylindrical shape

EAN 4007220							
GSB 1530 CO-COOL	-	772195	772201	772218	15 x 30	26,000–36,000	100
GSB 2220 CO-COOL	-	772225	772232	772249	22 x 20	18,000–26,000	100
GSB 2525 CO-COOL	-	772256	772263	772270	25 x 25	16,000–22,900	100
GSB 3030 CO-COOL	772287	772294	772317	772331	30 x 30	13,000–19,100	100
GSB 4530 CO-COOL	772355	772362	772393	772409	45 x 30	8,500–12,700	100
GSB 6030 CO-COOL	772416	772423	772430	772447	60 x 30	6,500–9,500	100

Conical shape

GSB 201463 CO-COOL	950302	950319	950326	950340	20 x 14 x 63	19,000–26,000	100
GSB 292230 CO-COOL	950364	950388	950395	950418	29 x 22 x 30	13,000–19,100	100
GSB 362260 CO-COOL	950432	950456	950463	950487	36 x 22 x 60	10,000–15,900	100

