



HERMES COATED ABRASIVES

Program brochure



for an
excellent finish



HERMES YOUR PARTNER AND EXPERT FOR EXCELLENT SURFACES

WHO WE ARE

The aesthetic and functional finish of surfaces is our strength. That is why we are the first point of contact for a large number of users from a wide range of industries. Founded in Hamburg, Germany, we have grown out into the world. With our comprehensive portfolio of coated abrasives and precision bonded abrasives, we have been one of the world's leading manufacturers since 1927.

THE PERFECT SOLUTION FOR THEM – WHAT DRIVES US

At Hermes, we work with passion on tailor-made solutions that perfectly match your individual requirements. We are constantly expanding our in-depth knowledge of your processes, applications and associated challenges, because we want to be more than just your service provider: we want to be your partner.

SERVICE - WHAT CHARACTERIZES US

Wherever and whenever you need our support, we are there for you – internationally, with local contacts at our many locations. For our speed and flexibility we are appreciated by our customers all over the world.

THE CHOICE IS YOURS - YOU WILL FIND YOUR SOLUTION IN OUR EXTENSIVE PRODUCT RANGE

On the following pages, find the product suitable for your grinding process from a list of over 170 Hermes basic grades. The information on the product structure, such as grit material, backing and bonding system, as well as the available grit range and delivery forms will help you to do so.



SEAM THE SUSTAINABILITY INITIATIVE

At Hermes, the topics of environmental protection and corporate responsibility have always shaped business policy. Today, we consider them more important than ever. This is why Hermes is a founding member of SEAM (Sustainable European Abrasive Manufacturers), the sustainability project of the European Abrasives Association. Within this framework, Hermes is continuously developing its sustainability standards in the three core areas of environment, society and economy. Further information on SEAM is available at www.seam.earth

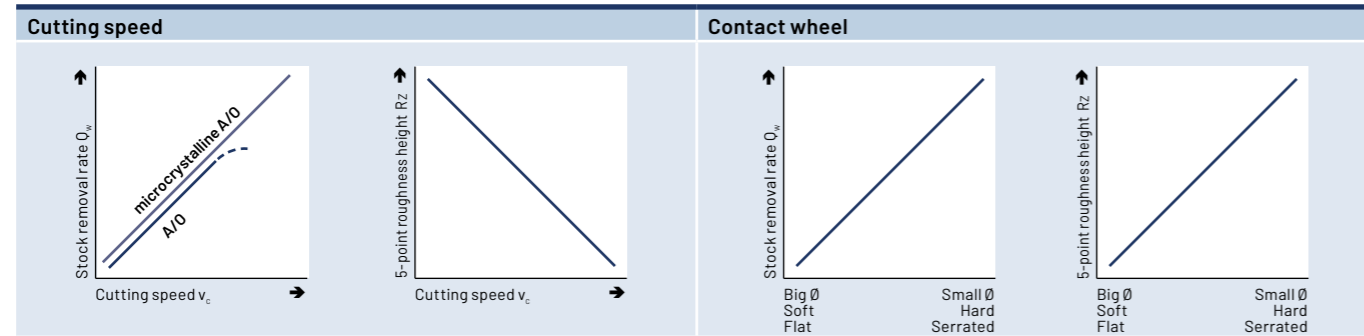


H.A.I. THE OPTIMIZATION INITIATIVE

Within the framework of the Hermes Abrasives Institute, we offer you optimization programmes that provide a customer-oriented combination of consulting services and individual training content.

This ranges from abrasives manuals, grinding process optimization and lean consulting to individual training so that theory becomes excellent practice.

Parameter of belt grinding

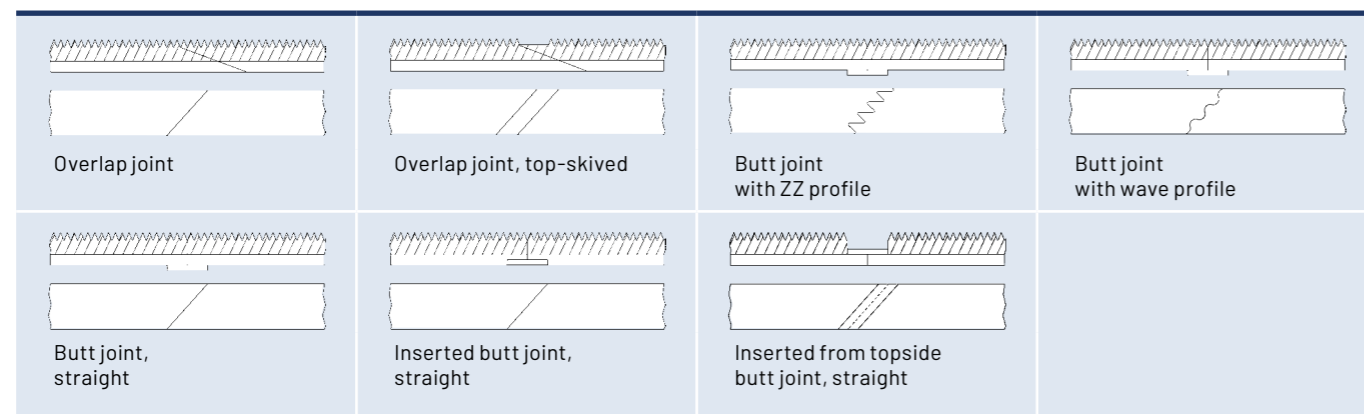


Cutting speed recommendations

Metal				Glass, china, ceramics, leather, rubber, cork, felt, plastic			
Narrow belts and Wide belts	Cutting speed v_c (m/s)			Narrow belts and Wide belts	Cutting speed v_c (m/s)		
	min	Recommendation	max		min	Recommendation	max
Carbon steel	29	35	39	Glass	8	13	18
Tool steel (forging parts)	20	30	30	Crystal-glass (lead glass)	15	20	25
Stainless steel	20	30	30	China, ceramics	10	13	17
Grey cast iron	30	35	40	Leather, rubber, cork, felt	20	25	30
Brass and bronze	27	35	37				
CrNi-base alloy	16	22	28	Plastic			
Aluminum, Al-alloy	28	35	40	- Duroplastic	18	22	26
Titan (dry grinding)	4	8	12	- Plastic (dry grinding)	6	10	12
Titan (wet grinding)	10	12	15	- Plastic (wet grinding)	8	15	18

Wood, lacquer, processed wood boards, mineral fiber boards and melamine							
Narrow belts	Cutting speed v_c (m/s)			Wide belts	Cutting speed v_c (m/s)		
	min	Recommendation	max		min	Recommendation	max
Solid wood, hard	10	20	24	Solid wood	12	20	24
Solid wood, soft	10	12	24	Veneer	10	20	24
Veneer				Plywood	10	20	24
- Lever stroke sanders	10	12	20	Filler	6	8	10
- Edge sanders	6	10	12	Lacquer	2	6	12
- Profile sanders	6	8	12	Particle board / MDF	12	22	36
Lacquer, general	4	8	12	Mineral fiber boards	12	22	26
- Nitro cellulose	2	4	8	Melamine	8	12	20
- Polyester, clear	6	8	12				
- Polyester, pigmented	6	10	12				
- PU	4	8	12				
- Acrylic, pigmented	8	10	12				
- Acid cure lacquer	6	8	12				

Joints for narrow and wide belts

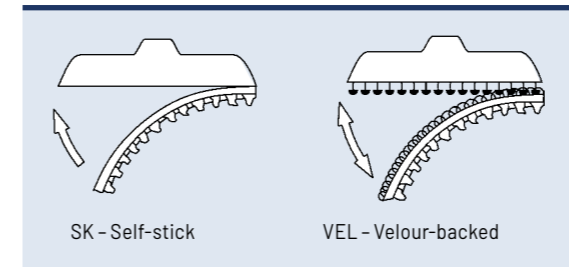


Triangulars, punched

EB	System	Dimensions in mm velour-backed
021	6 x / Ø 52	Schwarz & Decker, Bosch, Makita, Metabo
020	6 x	Festo
022	2 x 3 + 1 x	AEG, Atlas Copco
021	6 x / Ø 52	Kress
023	2 x 2 + 2 x 1	Flex Porter Cable

Ø = Bolt circle

Fastening systems



Strips, punched

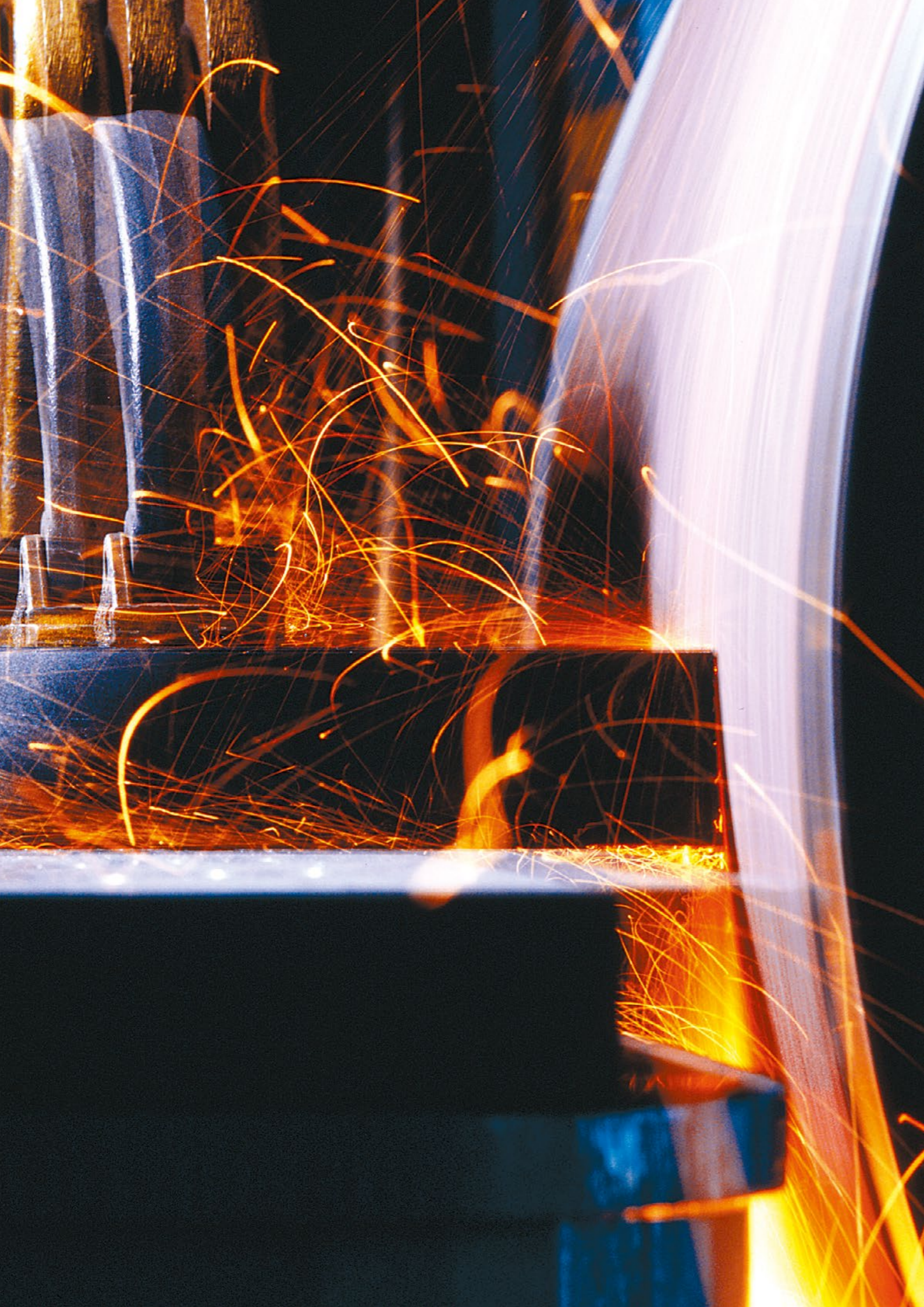
EB	System	Dimensions in mm		
		for clamps	velour-backed	self-stick
001	2 x 5	115 x 280	115 x 230 115 x 240	115 x 230 115 x 240
002	2 x 5 / 2 x 2	115 x 280	115 x 230 115 x 240	115 x 230 115 x 240
003	2 x 4	93 x 230	93 x 178 93 x 184 93 x 195	93 x 178 93 x 184 93 x 195
004	2 x 4	81 x 166	81 x 153 80 x 133	81 x 153 80 x 133
005	2 x 3 / 2 x 1	93 x 230	—	—
006	2 x 2 / 1 x 3	93 x 230	—	—
008	8 x / Ø 87	—	115 x 115	—
009	2 x 3	115 x 140	100 x 115	—
010	2 x 5	93 x 230	—	—
011	4 x 2 / 1 x 2	—	100 x 237	—
012	2 x 7	—	70 x 420	—

Ø = Bolt circle

Discs, punched

Ø	Hole system	Ø	Hole system	Ø	Hole system	Ø	Hole system	Ø	Hole system
73 mm	EB 130 6 x / Ø 41 mm	125 mm	EB 032 3 x / Ø 70 mm + 3 x / Ø 86 mm	125 x 18 mm	EB 119 8 x / Ø 90 mm with center hole	150 x 10 mm	EB 137 8 x / Ø 120 mm + 8 x / Ø 65 mm with center hole	150 x 18 mm	EB 135 8 x / Ø 120 mm + 6 x / Ø 80 mm with center hole
75 mm	EB 150 MULTIHOLE	125 mm	EB 033 5 x / Ø 72 mm	150 mm	EB 026 8 x / Ø 65 mm	150 x 10 mm	EB 237 48 x / Ø 123-39 mm with center hole	185 x 18 mm	EB 136 8 x / Ø 160 mm + 8 x / Ø 120 mm with center hole
115 mm	EB 026 8 x / Ø 65 mm	125 mm	EB 034 4 x / Ø 42 mm + 4 x / Ø 64 mm	150 mm	EB 027 6 x / Ø 80 mm	150 x 16.5 mm	EB 151 MULTIHOLE with center hole	200 mm	EB 028 8 x / Ø 127 mm
125 mm	EB 026 8 x / Ø 65 mm	125 mm	EB 150 MULTIHOLE	150 mm	EB 037 8 x / Ø 116 mm + 8 x / Ø 65 mm	150 x 18 mm	EB 036 8 x / Ø 120 mm with center hole	200 mm	EB 031 8 x / Ø 151 mm + 8 x / Ø 103 mm
125 mm	EB 030 4 x / Ø 41 mm	125 x 18 mm	EB 019 8 x / Ø 65 mm with center hole	150 mm	EB 150 MULTIHOLE	150 x 18 mm	EB 127 6 x / Ø 80 mm with center hole	225 mm	EB 122 8 x / Ø 70 mm

Ø = Bolt circle



HERMES REFERENCE

SAFETY

In order to guarantee the users of our abrasive tools the greatest possible safety at work, corresponding safety pictograms are depicted on the product labels, and we expressly point out that they must be observed.



						
Wear safety glasses	Wear ear protection	Wear safety gloves	Wear a face mask	Observe the instructions in the manual	Only use with a backing pad	Only permitted for grinding with an offset angle >10°.
						
Only suitable for wet grinding	Not suitable for flat grinding	Not suitable for hand-held grinding machines	Do not use damaged grinding tools	Not suitable for wet grinding	Only suitable for use in completely self-contained machines	



Further instructions for the correct use of abrasive tools can be found in the leaflets of the FEPA safety recommendations. If you do not have the leaflets, please request them by e-mail at hsd@hermes-schleifwerkzeuge.com

STORAGE OF ABRASIVES

Hermes abrasives are quality tools and require appropriate storage conditions. Quality can be impaired by incorrect storage. Additionally, careful storage ensures you maximum benefit for at least 5 years.

	<ul style="list-style-type: none"> Room temperature 18 - 22 °C Relative humidity 45 - 65 % Store in original packaging if at all possible, and on shelves or pallets/racks Use deliveries in the order they arrived
	<ul style="list-style-type: none"> Close to radiators Extreme temperature fluctuations (cold/hot) Store directly on concrete or stone floors Store in unheated rooms in winter



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Safety first
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