



HERMES COATED ABRASIVES

Program brochure



for an
excellent finish



HERMES ABRASIVES - MORE THAN GRINDING TOOLS!



EXPERTISE & CONSULTING

Whenever you need support: our experts are there for you.

Whether it's choosing the right grinding tool, process optimization, product testing or training your employees.

Whether at your or at our premises, by phone or email - you can count on us.





RESPONSIBILITY & SUSTAINABILITY

Responsible action and sustainable management are and have always been key components of our corporate strategy.

We are continuously developing our activities in this regard, are regularly certified and are measured against our successes at all times.

HERMES CONNECT

ONLINE-SERVICE PORTAL

Get information, order goods and track them - around the clock! Hermes Connect is your key source for all important services and information on our abrasive tools: stock availability and prices as well as a direct shop function and your personal order overviews.























































































CONTACT

Contact us at any time so that we can find the right solution for you.

In the contact area on our website [HERMES-ABRASIVES.COM](https://www.hermes-abrasives.com) you can find with just a few clicks the right contact person responsible for you.

Grain	Type	Code	Bak- king	Bon- ding	Grit range																																Delivery forms	
					12	16	20	24	30	36	40	50	60	80	100	120	150	180	220	240	280	320	360	400	500	600	800	1000	1200	1500	2000	2500	3000	4000	5000	ohne		
A/O	RB 306 J-flex	30660	J-flex	R	P																																 	
	HSB	32220	X	R	P																																	
	FW 340 X	34000	X	R	P																																 	
	RB 346 MJ	34602	J	R	P																																  	
	RB 346 J-flex	34660	J-flex	R	P																																  	
	RB 377 YX	37710	YX _w	R	+																																	  
	RB 406 J-flex	40660	J-flex	RPC	P																																	 
	RB 346 23 MX	34623	X	R	P																																	    
	Cork RB 525 X **	52522	X _w	R	P																																	 
	HERMESIT® RB 530 X	53021	X	R	P																																	 
	HERMESIT® RB 535 X	53521	X _w	R	P																																	 
	HERMESIT® RB 535 Y	53530	Y _w	R	P																																	 
	MERCURIT® RB 590 Y	59030	Y _w	R	P																																	 
	MERCURIT® RB 591 Y	59130	Y _w	R	P																																	 
	MERCURIT® RB 591 Y op	59131	Y _w	R	P																																	
S/C	RB 315 YX	31510	YX _w	R	P																																  	
	RB 319 J	31900	J	R	P																																	 
	ProBoard® RB 374 92 ZZ	37492	ZZ _w	RAS	P																																	
	Cork RB 515 X ***	51522	X _w	R	P																																	 
	Cork RB 515 Y ***	51530	Y _w	R	P																																	 
	HERMESIT® RB 540 X	54020	X	R	P																																	 
	HERMESIT® RB 545 X	54521	X _w	R	P																																	 
	HERMESIT® RB 545 Y	54530	Y _w	R	P																																	 
	MERCURIT® RB 595 Y	59530	Y _w	R	P																																	 
	MERCURIT® RB 598 Y	59830	Y _w	R	P																																	 
Z/O	RB 480 24 YX	48024	YX _w	R	+																																   	
	RB 480 X-flex	48070	X-flex	R	+																																	 
	RB 484 44 Z	48444	Z _w	R	+																																	 
	RB 485 Z	48544	Z _w	R	+																																	 
	RB 486 24 YX	48624	YX _w	RPC	+																																	   
	RB 486 44 Z	48644	Z _w	RPC	+																																	
	ZIRCONIT ZR 494 Z	49440	Z _w	R	#																																	 
	ZIRCONIT ZR 496 Z	49640	Z _w	RPC	+																																	 
	CER	CERAMIT® CR 454 Z	45440	Z _w	R	+																																  
CERAMIT® CR 456 Z		45640	Z _w	RPC	+																																	  
CERAMIT® CR 456 J-flex		45660	J-flex	RPC	+																																	  
CERAMIT® CN 464 Z		46440	Z _w	R	+																									</								

A/O: Aluminum oxide; **S/C:** Silicon carbide; **Z/O:** Zirconia alumina; **CER:** Ceramic grain; **R:** Resin; **RAS:** Resin, antistatic; **RPC:** Resin, Procut: Size coat with abrasive additives; **RPL:** Resin, Prolub: Additional stearate coating to prevent premature clogging; **PES:** Polyester; **Index w:** waterproof; * A/O + CER; ** A/O + Cork; *** S/C + Cork; **** No grain

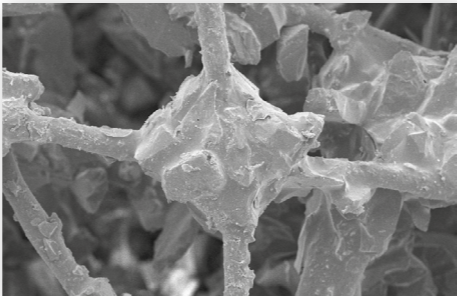
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3 benefits of webrax non-woven abrasive

1. Backing
Our non-woven abrasives are manufactured from a special fiber web. During this process, the abrasive grit is firmly anchored by a bond and is correspondingly durable.
The following designs are available:
Non-woven // non-woven, on XW-cloth // non-woven, high-density //
Non-woven, reinforced with cloth // non-woven, reinforced on vulcanized fiber

2. Types of grain
We use the following types of grain in grit range 80 to 1500: A/O (Al₂O₃) and S/C (SiC).
Warning: Information on grit sizes is not comparable with that relating to abrasive paper.

3. Bonding
The resin bond allows the product to be used under both dry and wet conditions.



Open structure of **webrax** non-woven abrasive

Grit size comparison for webrax non-woven abrasive (incl. details of product colors)

Standard Hermes	+ 80	+ 100	+ 120	+ 150	+ 180	+ 240	+ 280	+ 320	+ 400	+ 500	+ 800	no grain
Grit size name	coarse	medium		fine			very fine		super fine		ultra fine	
webrax-MAG	brown	-	brown	-	-		-	-	-	-	-	-
webrax-MSG	black	-	-	black	black		black	-	black	black	-	-
webrax-AN 70150	brown	red	-	-	red/blue		blue	-	-	-	grey	-
webrax-AN 701 Flex	brown	red			green		blue					
webrax-AN 702	brown	brown	-	-	brown		brown	brown	brown	-	-	-
webrax-PN 721	-	-	-	-	-		-	-	-	-	-	yellow
webrax-CW	med				fin							
webrax-UW	coarse	medium		fine								

Cutting speed recommendations v_c for dry grinding

	Cleaning	Decorative grinding	Deburring	Polishing
webrax discs				
All	-	8 - 25 m/s	20 - 25 m/s	-
webrax belts and wide belts				
MAG, MSG	5 - 10 m/s	8 - 15 m/s	-	-
AN 702	5 - 10 m/s	8 - 15 m/s	-	-
AN 70150, AN 701 flex	-	8 - 15 m/s	20 - 25 m/s	
PN 721	5 - 10 m/s	-	-	5 - 20 m/s when using polishing paste or liquid
webrax wheels and rollers				
LMO (Flap wheels and rollers)	5 - 10 m/s	8 - 15 m/s	-	-
LMI (impregnated flap wheels and rollers)	-	-	20 - 30 m/s	-
GWS (Wheels and rollers convolutely wrapped)	-	8 - 15 m/s	20 - 30 m/s	-
CW (Convoluted wheels)	-	-	25 - 35 m/s	30 - 35 m/s
LGG (Laminated wheels)	-	8 - 15 m/s	20 - 30 m/s	-
UW (Unitized wheels)	-	-	25 - 35 m/s	30 - 35 m/s

Grinding patterns compared using grinding belts, grit size 180



Grain	Type	Code	Backing	Grit range														Delivery forms
				80	100	120	150	180	220	280	320	360	400	500	600	800	1000	1500

webrax non-woven abrasive

A/O	MAG	70000	Non-woven on XXw cloth	+	•	•													
	AN 701 50	70150	Non-woven, reinforced with cloth	+	•	•		•		•									
	AN 701 flex	70170	Non-woven, reinforced with cloth	+	•	•		•		•									
	AN 702	70200	Non-woven, reinforced with cloth	+	•	•		•		•	•	•							
	AN 707	70700	Non-woven, reinforced with cloth	+	•					•									
	OA 708	70800	Non-woven	+		•		•		•	•								
	OA 708 flex	70870	Non-woven	+				•		•	•								
	OA 710	71002	Non-woven	+	•	•	•	•		•									
	OA 713	71300	Non-woven, high-density	+	•			•		•									
S/C	AN 701 50	70150	Non-woven, reinforced with cloth												•				
	MSG	70500	Non-woven on Xw cloth	+	•		•	•		•		•	•						
	OS 709	70900	Non-woven	+				•		•			•	•		•			
	OS 709 flex	70970	Non-woven	+									•			•			
	OS 715	71502	Non-woven	+	•	•	•	•		•			•	•					
	OS 716	71600	Non-woven, high-density	+				•		•									

webrax non-woven abrasive, velour-backed

A/O	OA 708 VEL	70807	Non-woven	+				•		•	•								
	OA 710 VEL	71007	Non-woven	+	•														
	OA 713 VEL	71307	Non-woven, high-density	+				•											
S/C	OS 709 VEL	70907	Non-woven	+												•			

webrax non-woven abrasive, on fiber backing

A/O	AN 703 50	70350	Non-woven, reinforced on vulcanized fiber	+	•	•													
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webrax cleaning non-web abrasives

A/O	GP 70604 Olive	70604	Non-woven	+															
S/C	Multiclean	70650	Non-woven, high-density	-															
None	GP 70600 White	70600	Non-woven	-															
	PN 721	72100	Non-woven, reinforced with cloth	-															

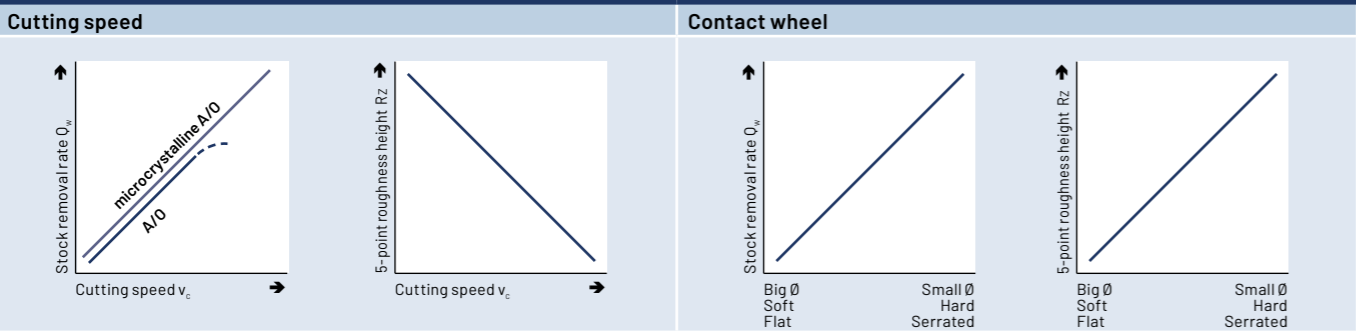
webrax-CW, convoluted wheels

A/O	CW 8A-MED DE	74800	Non-woven, high-density	+	•														
S/C	CW 7S-FIN DE	74720	Non-woven, high-density	+				•											
	CW 9S-FIN-X2 DE	74921	Non-woven, high-density	+				•											

webrax-UW, unitized wheels

A/O	UW 2A-MED DF	75200	Non-woven, high-density	+	•														
	UW 3A-MED DF	75300	Non-woven, high-density	+	•														
	UW 6A-MED DF	75600	Non-woven, high-density	+	•														
	UW 8A-CRS DF	75800	Non-woven, high-density	+	•														
S/C	UW 2S-FIN DF	75220	Non-woven, high-density	+				•											
	UW 3S-FIN DF	75320	Non-woven, high-density	+				•											
	UW 6S-FIN DF	75620	Non-woven, high-density	+				•											

Parameter of belt grinding

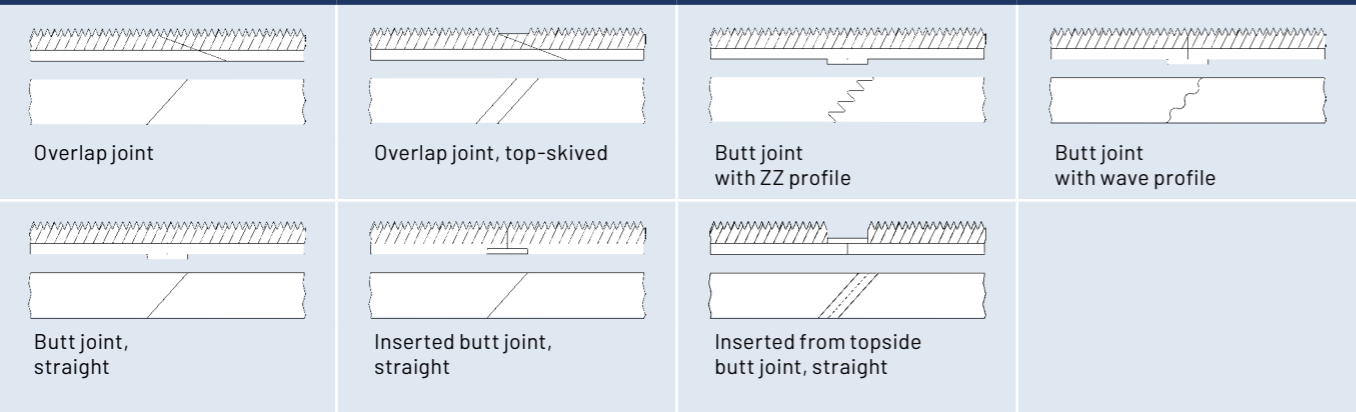


Cutting speed recommendations






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	Plastic			
CrNi-base alloy	16	22	28				
Aluminum, Al-alloy	28	35	40				
Titan (dry grinding)	4	8	12				
Titan (wet grinding)	10	12	15	- Duroplastic	18	22	26
				- Plastic (dry grinding)	6	10	12
				- 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

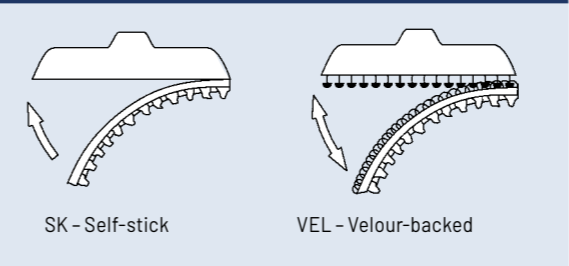


Triangulars, punched

EB	System	Dimensions in mm velour-backed	
021	 6 x / Ø 52	Schwarz & Decker, Bosch, Makita, Metabo	88 x 93
020	 6 x	Festo	88 x 95
022	 2 x 3 + 1 x	AEG, Atlas Copco	99 x 147
021	 6 x / Ø 52	Kress	100 x 105
023	 2 x 2 + 2 x 1	Flex Porter Cable	68 x 121

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	—

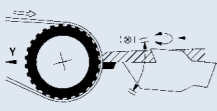
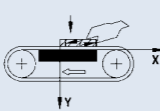
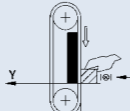
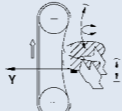
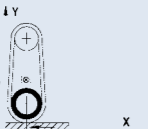
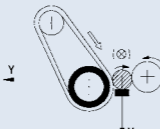
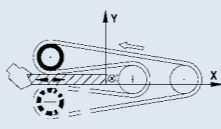
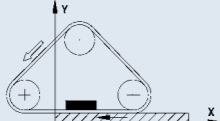
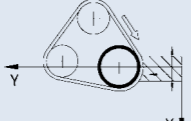
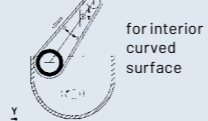

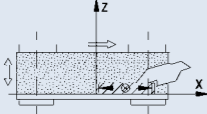
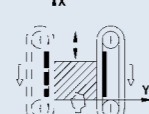
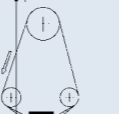
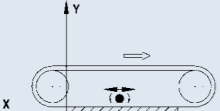
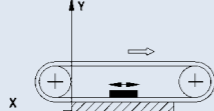
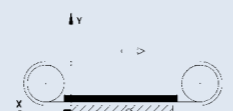


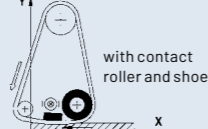
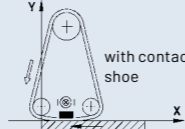
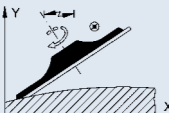



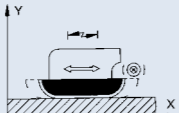

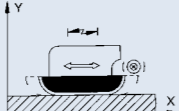
Ø = Bolt circle

Discs, punched

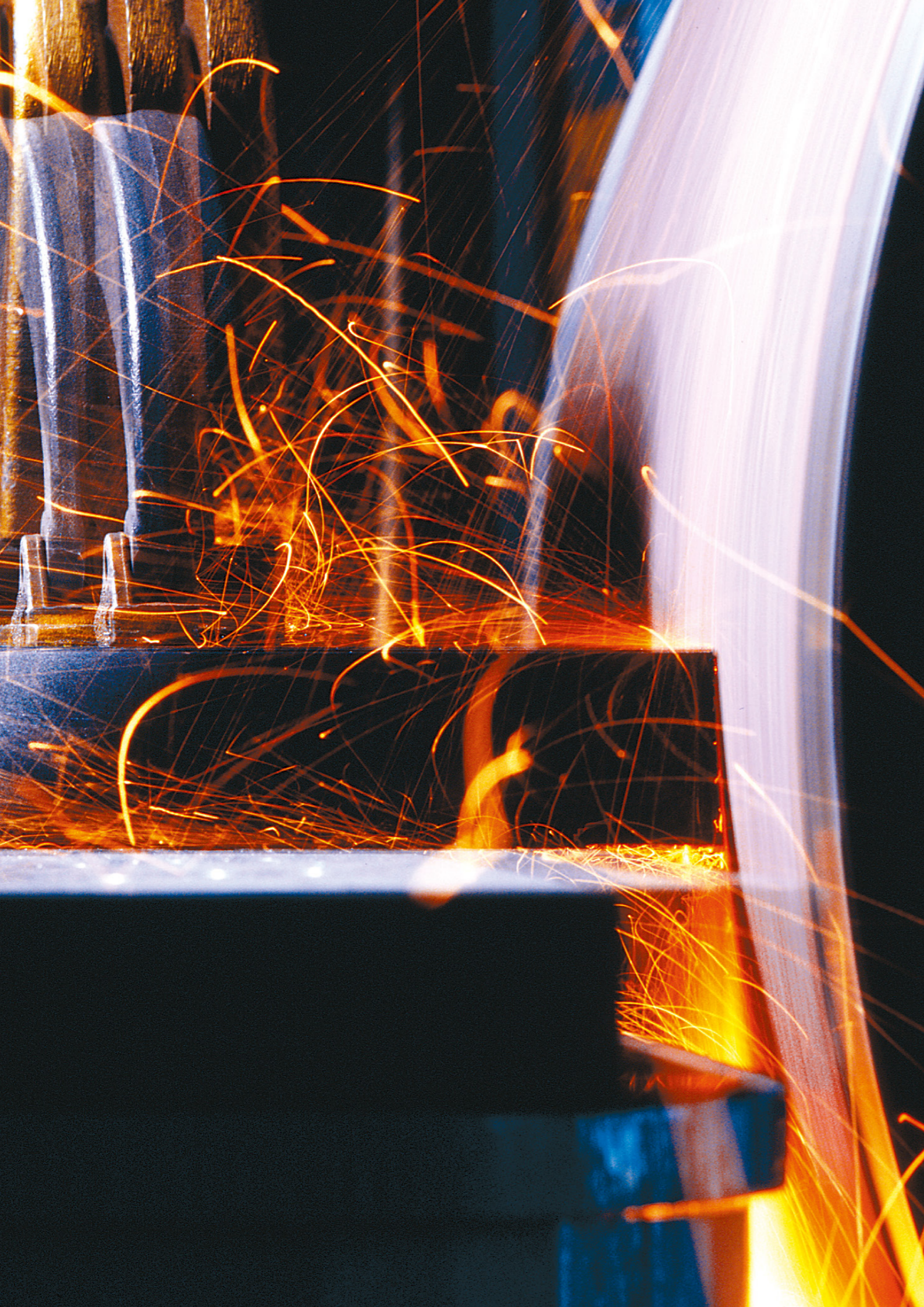
Ø	Hole system	Ø	Hole system	Ø	Hole system	Ø	Hole system	Ø	Hole system
73 mm	EB 130 6 x / Ø 41 mm	125 mm	EB 032 3 x / Ø 70 mm + 3 x / Ø 86 mm	125 x 18 mm	EB 119 8 x / Ø 90 mm with center hole	150 x 10 mm	EB 137 8 x / Ø 120 mm + 8 x / Ø 65 mm with center hole	150 x 18 mm	EB 135 8 x / Ø 120 mm + 6 x / Ø 80 mm with center hole
75 mm	EB 150 MULTI HOLE	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 MULTI HOLE 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 MULTI HOLE	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 MULTI HOLE	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

Kind of tools and grinding methods

Narrow belts	 <p>Backstand belt grinder</p>	 <p>Horizontal platen grinder</p>	 <p>Vertical platen grinder</p>	 <p>Stack of belt grinder</p>		
	 <p>Conveyorized through feed belt grinder</p>	 <p>Centerless grinder</p>	 <p>Double side flat grinder (single belt)</p>			
	 <p>Stationary platen grinder</p>	 <p>Plunge grinder - heavy stock removal</p>	 <p>Swing frame grinding machine</p>	 <p>Swing frame grinding machine for cylindrical workpieces</p>		
	 <p>Edge sander</p>	 <p>Drawer sander</p>	 <p>Profile sander</p>			
	 <p>Lever stroke sander with roller</p>	 <p>Lever stroke sander with pad</p>	 <p>Lever stroke sander with contact bar</p>	 <p>Lever stroke sander with hand block</p>		
	Wide belts	 <p>Wide belt machine with contact roller</p>	 <p>Wide belt machine with contact roller and shoe</p>	 <p>Wide belt machine with contact shoe</p>		
		Discs	 <p>Portable disc grinder</p>	 <p>Random orbital sander</p>		
			Flap discs	 <p>Portable disc grinder</p>		
Sheets, strips	 <p>Hand sanding</p>	 <p>Orbital sander</p>				
	Rolls	 <p>Hand sanding</p>	 <p>Orbital sander</p>			

Notices



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.

Tools that have been stored for longer than 3 years or have demonstrably have not been stored in accordance with the following storage regulations may no longer be used.



- 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



- Close to radiators
- Extreme temperature fluctuations (cold/hot)
- Store directly on concrete or stone floors
- Store in unheated rooms in winter



THE SYMBOL OF SAFETY



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Safety first
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