

HERMES COATED ABRASIVES

Program brochure





HERMES ABRASIVES -MORE THAN GRINDING TOOLS!



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

HERMES CCNNECT

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



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**

you can find with just a few clicks the right contact person responsible for you.

Abrasive cloth Abrasive cloth				king	ding	2	16 20 24	200	40	00	900	120	8 8 8	240	280	360	200	800	1200	2000	4000					
A/O RE 306 J-1lex 30860	Abra	asive cloth																								
NSB			30660	J-flex	R	Р					•	• •	•	•								9		ı	9	
RB 348 MU 34802 J 1 R P P		HSB	32220	Χ	R	Р		П	•	•	• •	• •	•	•			П			П				1	9	
R8 346 J-flox		FW 340 X	34000	Χ	R	Р		П	•	•	•	•	•		•	П	Ħ			т			#			
RB 377YX		RB 346 MJ	34602	J	R	Р		П		•	• •	• •	•	• •	• •	•	•	•		П)	9	
RE 406J-flex		RB 346 J-flex	34660	J-flex	R	Р		П	•	•	• •	• •	•	• •	• •	•				П				1	9	
RB 346 23 MX		RB 377 YX	37710	YX_{W}	R	+		П	••	•	• •	• •	•	• •	• •		•					9		1	\$	•
Remesiries 535		RB 406 J-flex	40660	J-flex	RPC	Р		П		•	• •	• •	•	• •	• •							9		1	9	
HERMESIT'RB 530		RB 346 23 MX	34623	Χ	R	Р	•		• • •	•	• •	• •	•	• •	• •									9	\$	1 0
HEMMESIT'RB 535		Cork RB 525 X **	52522	Xw	R	Р									•									1	\$	1
HERMESIT'RB 535 Y 5930 7% R P 1 1 1 1 1 1 1 1 1		HERMESIT®RB 530 X	53021	Χ	R	Р						•	•	• •	• •									1	\$	1
MERCURIT'RB 591Y 59130 Yw R P R P R R P R R R		HERMESIT® RB 535 X	53521	Xw	R	Р		П		П		•	•	• •	• •									1	\$	9
MERCURIT' RB 591Y o 5913		HERMESIT® RB 535 Y	53530	Yw	R	Р		П		•	• •	•	•	•	•									1	\$	9
MRCURIT' RB 591 Y o		MERCURIT® RB 590 Y	59030	Yw	R	Р					•	•	•	•	•									1	\$	9
No.		MERCURIT® RB 591 Y	59130	Yw	R	Р							•	•	•									1	9	9
RB319J 3190 J 3190 J R P		MERCURIT® RB 591 Y op	59131	Yw	R	Р					•	•												1	9	
ProBoard RB 374 92 ZZ	S/C	RB 315 YX	31510	$YX_{W} \\$	R	Р	•	•	• •	•	• •	• •	•	• •	• •									1	\$	9 /
Cork RB 515 X **** 51522 Xw R P		RB 319 J	31900	J	R	Р					• •	• •		• •	•		П							1	9	
Cork RB 515 Y *** 51530		ProBoard® RB 374 92 ZZ	37492	ZZw	RAS	Р	•		• •	•	• •	• •	•												(9
HERMESIT RB 540 X 54020 X R P		Cork RB 515 X ***	51522	χ_{w}	R	Р						•		•	•			• • •						1	\$	9
HERMESIT'RB 545 X 54521 Xw R P P HERMESIT'RB 545 Y 54530 Yw R P P HERMESIT'RB 545 Y 54530 Yw R P P HERMESIT'RB 595 Y 59530 Yw R P P MERCURIT'RB 598 Y 59830 Yw R P P P P P P P P P P P P P P P P P P		Cork RB 515 Y ***	51530	Y_{W}	R	Р						•		•	•			• •	•					1	\$	9 /
HERMESIT*RB545Y 59530 Yw R P P P P P P P P P P P P P P P P P P		HERMESIT®RB 540 X	54020	Χ	R	Р								•										1	\$	1
MERCURIT' RB 598 Y 59830		HERMESIT° RB 545 X	54521	X_W	R	Р						•	•	• •	• •			•						1	9	1
MERCURIT' RB 598 Y 59830 Yw R P		HERMESIT°RB 545 Y	54530	Yw	R	Р			•	•	• •	•	•											١	\$	9
RB 480 24 YX		MERCURIT® RB 595 Y	59530	Yw	R	Р		Ш			•	•	•	•										١	\$	9
RB 480 X-flex		MERCURIT® RB 598 Y	59830	Yw	R	Р								•	•			• •	•					1	\$	9 /
RB 484 44 Z	Z/0	RB 480 24 YX	48024	$YX_{W} \\$	R	+	•		• •	•	• •	•											Ŕ		\$	9
RB 485 Z		RB 480 X-flex	48070	X-flex	R	+		Ш			•	•														
RB 486 24 YX		RB 484 44 Z	48444	Zw	R	+	•		• •	•	• •	•												١	\$	9
RB 486 44 Z		RB 485 Z	48544	Zw	R	+		H	• •	•	• •													١	\$	9
ZIRCONIT ZR 494 Z		RB 486 24 YX	48624	$YX_{\text{W}} \\$	RPC	+		Ш	•	•	•	•					Ш						Ŕ		\$	9
ZIRCONIT ZR 496 Z		RB 486 44 Z	48644	Zw	RPC	+		H	• •	•	•													١	9	
CER CERAMIT° CR 454 Z 45440 Zw R + Image: Composition of the composition of th		ZIRCONIT ZR 494 Z	49440	Zw	R	#	•	H	•••	•	• •	•												١	\$	9
CERAMIT° CR 456 Z 45640 Zw RPC + CERAMIT° CR 456 J-flex 45660 J-flex RPC + CERAMIT° CN 464 Z 46440 Zw R + CERAMIT° CN 466 Z 46640 Zw RPC + CERAMIT° CN 466 X-flex 46670 X-flex RPC + CERAMIT° CR 476 J 47600 Jw RPC + CERAMIT° CR 476 Z 47640 Zw RPC +		ZIRCONIT ZR 496 Z	49640	Zw	RPC	+	•	H	•••	•	•	•												١	\$	9
CERAMIT° CR 456 J-flex 45660 J-flex RPC + CERAMIT° CN 464 Z 46440 Zw R + CERAMIT° CN 466 Z 46640 Zw RPC + CERAMIT° CN 466 X-flex 46670 X-flex RPC + CERAMIT° CR 476 J 47600 Jw RPC + CERAMIT° CR 476 Z 47640 Zw RPC +	CER	CERAMIT° CR 454 Z	45440	Zw	R	+		Ш		•	•													١	\$	9
CERAMIT° CN 464 Z 46440 Zw R + • • • • • • • • • • • • • • • • • • •		CERAMIT° CR 456 Z	45640	Zw	RPC	+		Ŀ	• • •	•	• •	•					Ц			Щ				١	9	1
CERAMIT° CN 466 Z 46640 Zw RPC + • • • • • • • • • • • • • • • • • • •		CERAMIT® CR 456 J-flex	45660	J-flex	RPC	+		Ш			• •	• •		•			Ш		Ш	Щ						
CERAMIT° CN 466 X-flex 46670 X-flex RPC + •••••• ••••• \$ CERAMIT° CR 476 J 47640 Jw RPC + •••• ••• \$ CERAMIT° CR 476 Z 47640 Zw RPC + ••• ••• \$		CERAMIT° CN 464 Z	46440	Zw	R	+		Ц	•	•	•						Ц			Щ)	\$	9
CERAMIT® CR 476 J 47600 Jw RPC + • • • • • • • \$		CERAMIT° CN 466 Z	46640	Zw	RPC	+	•		•••	•	•						Ц						Ŕ			9
CERAMIT® CR 476 Z 47640 Zw RPC + ● ● ● ● ● ● ● ● ● ● ● ● ● ● ● ● ● ●		CERAMIT° CN 466 X-flex	46670	X-flex	RPC	+				•	• •	•	•	• •			Ц									
		CERAMIT° CR 476 J	47600	Jw	RPC	+					• •	•	•	• •			Ц					-				
Cork Cork RB 555 X **** 55522 Xw R -			47640	Zw	RPC	+	•		• • •	•	• •	•							IJ							
	Cork	Cork RB 555 X ****	55522	Xw	R	-																		1	\$	9

Delivery forms

Code Bak- Bon- Grit range

A/0:	Aluminum	oxide;	S/C:	Silicon	carbide;	Z/0:	Zirconia	alumina;	CER:	Ceramic	grain;	R:	Resin;	RAS:	Resin,	antistatic;
RPC:	Resin, Proc	ut: Size	coat	with ab	rasive add	litives;	RPL: Res	in, Prolub	: Addit	ional stea	rate co	atino	to pre	vent p	remature	e clogging;
PES:	Polyester; In	dex w: v	vaterp	roof; * A	/0 + CER; *	* A/0 +	Cork; *** S	S/C + Cork;	**** No	grain						

	Туре	Code	Bak-	Bon-			nge															Deli	very	/ foi	ms	
			king	ding	12	16	24	36	20	80	120	180	240	280	360	500	800	1200	2000	3000	5000 5000					
Abra	asive cloth, velour-b	acke	d																							
A/0	RB 346 87 MX VEL*	34687	Χ	R	Р			•	•		•	• •	•	•								•	•			
	HERMESIT° RB 530 J VEL	53067	J	R	Р				П		•	• •				П			П							
Z/0	RB 480 24 YX VEL	48027	YX	R	+			•	•	•	•					П		П	П	П						
CER	CERAMIT° CR 456 Z VEL	45647	Zw	RPC	+			• •	•	•	•															
\bra	asive cloth, self-stic	k																								
A/0	RB 346 23 MX SK*	34625	Χ	R	Р					•	1		•			П						•				
bra	asive stitch-bonded	cloth																								
1/0	SB 388 23 Y*	38823	Yw	R	Р			•	•	•	•					П				П					\$	1
Z/0	SB 488 Y	48830	Yw	R	+			•	•																\$	1
bra	asive fiber																									
1/0	RB 314 fibre	31444	X/J	R	Р		•	• •	•	•	•															
Z/O	RB 414 X-Procut	41450	Χ	RPC	+			• •	•	•	•															
CER	CERAMIT® CR 456 fiber-Procut	45650	X/J	RPC	+			•	• •	•	•															
bra	asive film																									
4/0	FB 637	63700	PESw	R	Р	П	П		П		•	•	•	•	• •		• • •	•		•		9				9
bra	asive film, velour-ba	acked																								
4/0	ProTec Film FC 161-Longlife VEL	16177	PES	R	Р		П			•	•	• •	•			П									•	9
	Brilliance Film FC 164-Longlife VEL	16477	PES	R	Р				П				•	•		•	•	•	•	I						9
bra	Brilliance Film FC 164-Longlife VEL		PES	R	Р								•	•	•	•	• •		•							\$
				R R	P P								•	•										•		\$
۸/0	asive film, self-stick	63708	PES										•	•										•		
oar	asive film, self-stick	63708	PES	R									•													
oar oar	asive film, self-stick FB 637 08 SK m with net, velour-b	63708 acked	PU foam+	R									•		•											S
oar s/c	asive film, self-stick FB 637 08 SK m with net, velour-b FineNet FN 915 VEL	63708 acked	PES PUfoam+ net	R									•		•									•		5
oar s/c Net	asive film, self-stick FB 637 08 SK m with net, velour-b FineNet FN 915 VEL cloth	63708 acked 91527	PES PUfoam+ net	R	P +								•		•							9,		•		
A/O Foar S/C Net (A/O	rasive film, self-stick FB 637 08 SK m with net, velour-b FineNet FN 915 VEL cloth	63708 acked 91527	PUfoam+ net	R	P +								•		•							9,		•		
oar s/c let	asive film, self-stick FB 637 08 SK m with net, velour-b FineNet FN 915 VEL cloth GA 924 cloth, velour-backe	63708 eacked 91527 92400	PUfoam+ Net Net	R R	P + +								•		•							9,		•		
A/O Foar S/C Net A/O	rasive film, self-stick FB 637 08 SK m with net, velour-b FineNet FN 915 VEL cloth GA 924 cloth, velour-backe	91527 92400 d	PUfoam+ Net Net Net	R R R	P + + P							•	•									9		•		
oar oar let (rasive film, self-stick FB 637 08 SK m with net, velour-b FineNet FN 915 VEL cloth GA 924 cloth, velour-backe MultiNet MN 921 VEL MultiNet MN 922 VEL	91527 92400 d 92177 92277	PUfoam+ Net Net Net	R R R	P + + P							•	•									9,		•		
A/O Foar S/C Net (A/O Net (A/O	rasive film, self-stick FB 637 08 SK m with net, velour-b FineNet FN 915 VEL cloth GA 924 cloth, velour-backe MultiNet MN 921 VEL MultiNet MN 922 VEL GA 924 VEL	91527 92400 d 92177 92277 92407	PUfoam+ Net Net Net	R R R R	P + + P								•									9		•		
A/O Foar S/C Net A/O Net A/O	asive film, self-stick FB 637 08 SK m with net, velour-b FineNet FN 915 VEL cloth GA 924 cloth, velour-backe MultiNet MN 921 VEL MultiNet MN 922 VEL GA 924 VEL nges	91527 92400 d 92177 92277 92407	PUfoam+ net Net Net Net Net	R R R R R R	P + + P P + +							•	•											•		

Grain Type

Grain	Туре	Code	Bak-		Grit range	Delivery forms
			king	ding	12 24 24 33 33 33 33 33 33 33 34 110 110 110 110 110 110 110 110 110 11	

Abrasive paper

1010	asive paper												_					_								
A/0	BW 114	11400	F	RAS	B P			•	•	•		•	•	•	• •	•	•	•						9	90	7
	BW 115	11500	F	R	Р			•		•	•	•	•	•	• •		•							9	9	1
	BW 116	11600	F	RPC	; P					•	•	•	•	•	• •		•								\$	1
	VC 152	15200	D	R	Р			•		•	П													₽ ■ ■	ð	
			С	R	Р				П	•	•	•	•	•	•		•				П			~ -	7	
	VC 154-Longlife	15470	С	RPL	. Р				П			•	•	•	•	•	•				П			₽, = =	9	
	MERCURIT® BW 590	59010	F	R	Р				П		П		•	•	•		•	•			П				\$	1
	WA flex 28 B	62820	Bw	R	Р				П		П					П		•			П					
S/C	BS 118	11800	G	RAS	S P	•	•		П		П										П			8	\$	*
			F	RAS	B P			• •	•	•		• •	• •	•	• •	•	• •	•	•	•						
	BS 119-Longlife	11970	D	RAS/RPL	l P				П					•	• •	•	•	•							\$	1
	SF 168	16810	А	RPL	. Р				П	•		•	•	•	•		•			Ì	П					
	ProBoard® BS 179	17900	G	RAS	P					•		•	•							Ì	П				\$	1
	HERMESIT® BS 540	54010	F	R	Р				П		П	•	•		•					Ì	П				\$	1
	WS flex 14 C film	61814	Cw	R	+				П	•		•	•		•		•		•	•	•					
	WS flex 16	61601	Bw	R	P/ ₊					•		•	•	•	•	•	•	•	•	• •	•	•	•			
	WS flex 18 C	61810	Cw	R	Р					•	•	•	•	•	• •		•	•	•	•						
	WS flex 18 C film	61814	Cw	R	+				П	•		•	•	•	• •		•	•	•	•						
	WS flex 18 C micro	61820	Cw	R	+																		•			
	WS flex 18 C micro film	61824	Cw	R	+																		•			
Z/0	BW 184	18400	G	R	+			• •		•														8	80	7
CER	CERAMIT° CR 116	11623	F	RPC	; +			•		•	•	•	•	•	• •		•								8	*
	CERAMIT° CR 176	17600	F	RPC	; +			•		•															9	7

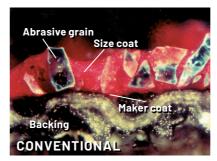
Abrasive paper, velour-backed

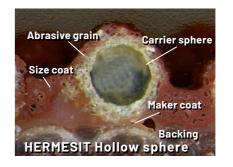
A/0	BW 114 VEL	11407	F	RAS	Р		П	•	•	• •	•	• •	• •			Т			П				_	/ <u>/ </u>	7 () (•
	BW 115 VEL	11507	F	RAS	Р			•	•	• •	•	•	•) <u>A</u>) (
	VC 151-Longlife VEL	15177	С	RPL	Р				•	• •	•	•	• •		•	•	•							<i>_</i>		(
	VC 152 VEL	15207	D	R	Р			•	•															<i>[</i>		•	
			С	R	Р					• •	•	•	• •			•								<i>[</i>		•	
	VC 154-Longlife VEL	15477	В	RPL	Р					• •	•	•	• •	•	•	•	•	•	•	•				<i>[</i>		•	
S/C	BS 118 VEL	11807	G	RAS	Р	•	•																	<u> </u>		(
			F	RAS	Р			• •	• •	• •	•	•	•			•	•	•	•								
Z/0	BW 184 VEL	18407	G	R	+		•	• •	•	• •	•	•														(
CER	CERAMIT° CR 116 VEL	11627	F	RPC	+				•	• •	•	•														(

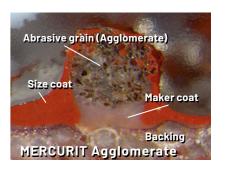
Abrasive paper, self-stick

A/0	VC 152 SK	15205	D	R	Р	• •		П								•
			С	R	Р		• •	•	•	• •						
S/C	SF 168 SK	16815	А	RPL	Р		•	•	•	• •	•	••		<u> </u>	7	
	WS flex 18 C SK	61815	Cw	R	Р	•	•	•	•	•	•	••••	•			
	WS flex 18 C micro SK	61825	Cw	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; **** No grain







Key to kind of tool



Key to backings

Cloth Type	Property	Backing material	Paper	Weight g/m²	webrax non-woven abrasive Type
J-flex-w J-flex J X-flex(Xw-flex) X(Xw) Y(Yw) YX Z	Light, highly flexible Light, very flexible Light, flexiblel Heavy, flexible Heavy, semi flexible Very heavy, semi stiff Very heavy, semi stiff Very heavy, semi stiff	Cotton cloth Cotton cloth Synthetic cloth Cotton cloth Cotton cloth Synthetic cloth Synthetic cloth Polyester/cotton mixed cloth Synthetic cloth	Type A(Aw) B(Bw) C(Cw) D E F	, ,	Non-woven Non-woven, high-density Non-woven, on Xw cloth Non-woven, reinforced with cloth Non-woven, reinforced on vulcanized fiber
Stitch-bonded Type	cloth Property	Backing material	Fiber Type	Average thickness	Film Type
Y	Very heavy, semi stiff	Synthetic stitch-bonded cloth	J-flex J	0.40 - 0.55 mm 0.60 - 0.65 mm	PES = Polyester
			X	0.80 - 0.85 mm	Indexw = waterproof

Key to bonding

Key to bond	ling		Abrasive grain material a	nd grain standards
Туре	Bonding	Description	Grain	Grain standard
R RAS RPC	Resin Resin, antistatic Resin, Procut	Size coat with abrasive additives	Aluminum oxide (A/O) Silicon carbide (S/C) Zirconia alumina (Z/A) Ceramic grain (CER)	P = FEPA - DIN ISO 6344 P = FEPA - DIN ISO 6344 # = ANSI - B74.18-1996 # = ANSI - B74.18-1996 + = Standard Hermes
RPL	Resin, Prolub	Additional stearate coating to prevent premature clogging	webrax non-woven abrasive Aluminum oxide (A/0) Silicon carbide (S/C) Sponges Aluminum oxide (A/0) Silicon carbide (S/C)	+ = Standard Hermes + = Standard Hermes F = FEPA - DIN ISO 8486 F = FEPA - DIN ISO 8486

Grit size comparison (Abrasive paper, film, cloth, stitch-bonded cloth and fiber)

d _{k50} (µm) Average grain diameter	750	630	525	400	325	260	200	160	125	93	76	68	58	52	46	39	35	30	26	22	18	14	12	10	8
FEPA 43-D-1984 R 1993 DIN ISO 6344	P24	P30	P36	P 40	P50	P60	P80	P 100	P 120	P 150	P 180	P 220	P 240	P280	P 320	P 360	P 400	P 500	P 600	P 800	P 1000	P 1200	P 1500	P 2000	P 2500
ANSI B 74.18-1996	24	30	36	40	50	60	80	100	120	150	180	220		240	2	80	320		360	400	500	600			



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 //

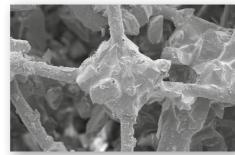
Non-woven, reinforced with cloth // non-woven, reinforced on vulcanized fiber

2. Types of grain

We use the following types of grain in grit range 80 to 1500: A/O(Al $_2$ 0 $_3$) 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.



pen 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	med	lium	fi	ne		very	fine	supe	r 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 vo 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 701 50, 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	Туре	Code	Backing	Grit range	Delivery forms
				80 100 120 120 150 220 220 220 240 240 320 350 600 600 600 1000 1200	

webrax non-woven abrasive

A/0	MAG	70000	Non-woven on XXw cloth	+ • •
	AN 70150	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 70150	70150	Non-woven, reinforced with cloth	
	MSG	70500	Non-woven on Xw cloth	+• • • • • •
	OS 709	70900	Non-woven	+ • • • • • • • •
	OS 709 flex	70970	Non-woven	+
	08715	71502	Non-woven	+ • • • • • • • • • • • • • • • • • • •
	OS 716	71600	Non-woven, high-density	+

webrax non-woven abrasive, velour-backed

A/0	0A 708 VEL	70807	Non-woven	+			•		•		
	0A 710 VEL	71007	Non-woven	+	•						
	0A 713 VEL	71307	Non-woven, high-density	+			•				
S/C	OS 709 VEL	70907	Non-woven	+		П				•	

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/0	GP 70604 Olive	70604	Non-woven	+	
S/C	Multiclean	70650	lon-woven, high-density		
None	GP 70600 White	70600	Non-woven	-	
	PN 721	72100	Non-woven, reinforced with cloth	-	

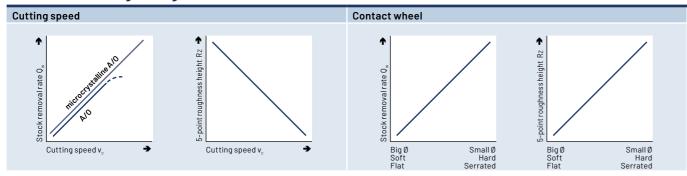
webrax-CW, convoluted wheels

A/0	CW 8A-MED DE	74800	Non-woven, high-density		•			6
S/C	CW 7S-FIN DE	74720	Non-woven, high-density	+			•	0
	CW 9S-FIN-X2 DE	74921	Non-woven, high-density	+			•	0

webrax-UW, unitized wheels

A/0	UW 2A-MED DF	75200	Non-woven, high-density	+	•		0
	UW 3A-MED DF	75300	Non-woven, high-density	+	•		•
	UW 6A-MED DF	75600	on-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	+	П	•	•
	UW 6S-FIN DF	75620	Non-woven, high-density	+	П	•	•

Parameter of belt grinding

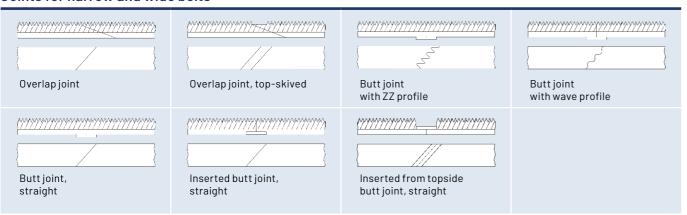


Cutting speed recommendations

Metal				Glass, china, ceramics, leather, rubber, cork, felt, plastic							
Narrow belts	C	utting speed v _c (m/s	s)	Narrow belts	(Cutting speed v _c (m/s)					
and Wide belts	min	Recommendation	max	and Wide belts		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				

Titan (wet grinding)	10	12	15	- Plastic (wet grinding)	8	15	18
Wood, lacqer, processed wood boards	s, mine	ral fiber boards an	d mela	mine			
Narrow belts	C	Cutting speed v _c (m/s	s)	Wide belts	C	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
Lacqer, 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				

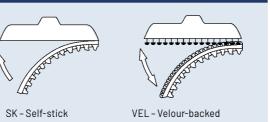
Joints for narrow and wide belts



Triangulars, punched

EB	System	Dimension velour-ba	
021	6x/Ø52	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	6x/Ø52	Kress	100 x 105
023	2 x 2 + 2 x 1	Flex Porter Cable	68 x 121
			Ø = Bolt circle

Fastening systems



Strips, punched

	o, pariorica			
EB	System		limensions in m velour-backed	ım self-stick
		for clamps	velour-backed	Sell-Stick
001	•••• 2x5	115 x 280	115 x 230	115 x 230
			115 x 240	115 x 240
002	2x5/2x2	115 x 280	115 x 230	115 x 230
	··		115 x 240	115 x 240
007	2 x 4	07 070	07 170	07 170
003	2 × 4	93 x 230	93 x 178 93 x 184	93 x 178 93 x 184
			93 x 104 93 x 195	93 x 104 93 x 195
007	2 x 4	01 100		
004	2 × 4	81 x 166	81 x 153 80 x 133	81 x 153 80 x 133
			00 X 133	00 X 133
005	2x3/2x1	93 x 230		
006	2x2/1x3	93 x 230		
000	1	33 X 230		
008	8x/Ø87		115 x 115	
009	2 x 3	115 x 140	100 x 115	
010	2 x 5	07 070		
010	2 X 5	93 x 230		
011	4x2/1x2		100 x 237	
012	2×7		70 x 420	
UIZ	•••••• 2 A /		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 3x/070 mm+ 3x/086 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		125 mm		150 mm		150 x 10 mm		185 x 18 mm	
	EB 150 MULTIHOLE		EB 033 5 x / Ø 72 mm		EB 026 8 x / Ø 65 mm		EB 237 48 x / Ø 123-39 mm with center hole		EB 136 8 x / Ø 160 mm + 8 x / Ø 120 mm with center hole
115 mm		125 mm		150 mm		150 x 16.5 m	m	200 mm	
	EB 026 8 x / Ø 65 mm		EB 034 4x/042mm+ 4x/064mm		EB 027 6x/Ø80 mm		EB 151 MULTIHOLE with center hole		EB 028 8 x / Ø 127 mm
125 mm		125 mm		150 mm		150 x 18 mm		200 mm	
	EB 026 8x/Ø65 mm		EB 150 MULTIHOLE		EB 037 8x/Ø116 mm + 8x/Ø65 mm		EB 036 8 x / Ø 120 mm with center hole		EB 031 8 x / Ø 151 mm + 8 x / Ø 103 mm
125 mm		125 x 18 mm		150 mm		150 x 18 mm		225 mm	
\bigcirc	EB 030 4 x / Ø 41 mm		EB 019 8 x / Ø 65 mm with center hole		EB 150 MULTIHOLE		EB 127 6 x / Ø 80 mm with center hole		EB 122 8 x / Ø 70 mm
									Ø = Bolt circle

Kind of tools and grinding methods

	and grinding methods			
Narrow belts	Y WE TO THE TOTAL THE TOTA	Y X	<u>Y</u>	
	Backstand belt grinder	Horizontal platen grinder	Vertical platen grinder	Stack of belt grinder
	Conveyorized through feed belt grinder	Centerless grinder	Double side flat grinder (single belt)	
	l v	(F)\(\(\rangle\)	for interior	A
	Stationary platen grinder	Y X Plunge grinder - heavy stock removal	Swing frame grinding machine	for cylindrical workpieces workpieces Swing frame grinding machine
	z	iX	, Y	
	X		1) + ×	
	Edge sander	Drawer sander	Profile sander	tu.
	X O O O O O O O O O O O O O O O O O O O	<u>x</u> + <u>+</u> +	iv	+
	Lever stroke sander with roller	Lever stroke sander with pad	Lever stroke sander with contact bar	Lever stroke sander with hand block
Wide belts	with contact roller \underline{x}	with contact roller and shoe	with contact shoe	
Discs	Portable disc grinder	Random orbital sander		
Flap discs	Portable disc grinder			
Sheets, strips	X X	Y (⊚) (⊗) X Orbital sander		
Rolls	Trailu sanuing ↓Z	Y		
	× Williams			
	Hand sanding	Orbital sander		

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.











instructions in



backing pad grinding with an offset angle >10°.





Wear safety

Wear safety











wet grinding

Further instructions for the correct use of abrasive tools can be foand 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 humidityt 45 65 %
- Store in original packaging if at all possible, and on shelves or pallets/racksn
- 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



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