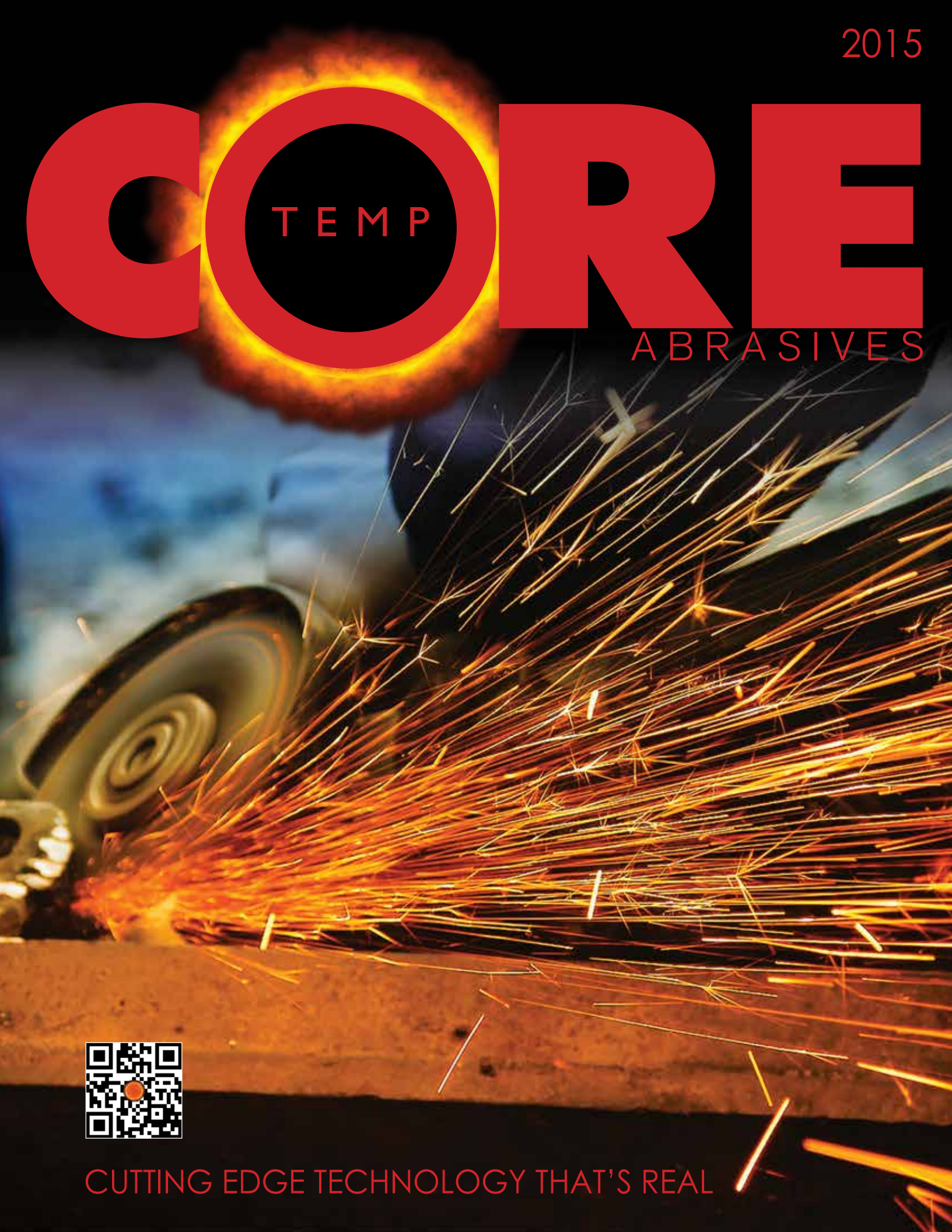
2015

TEMP CORE ABRASIVES



CUTTING EDGE TECHNOLOGY THAT'S REAL

Intro

Scan with any smart phone for a video demonstration.

Cutting Edge Technology actually means something now!

Hi and welcome to CoreTemp Abrasives. After more than 17 years in the abrasives industry as Director of Product Development, Director of Sales, Director of Training and more, I can say with 100% certainty that I understand your frustration with using grinding wheels, cutting wheels and flap discs!

They all look the same, pricing is all over the place, everyone promises their "Wheel" is the best….or cheapest. What they don't tell you is why the wheel you are using doesn't work. They don't tell you how to increase your productivity by looking at the tool, the application, and the wheel. I will tell you.

Having used these products in every type of fab shop, I thought it would be a great idea to incorporate these new QR (Quick Response) barcodes on the label of every product. You've seen these QR codes in all types of advertising. When scanned with your smart phone, your phone automatically goes to some website or video or anywhere it directs you to.

The QR barcodes on our labels link to an instructional high definition video of how to use that exact product. We have four different videos for grinding wheels, thin cutting wheels, chop saw blades and flap discs. It's so good we have a patent pending!

Resin Bonded Abrasives

ANSI Standard Marking System

The following diagrams is an example of the ANSI standard marking system for identifying grinding wheels and other bonded abrasives.

A
Primary grain used to make the wheel

A = Aluminum xide
C = Silicon Carbide
Z = Alumina Zirconium
SG = Seeded Gel

24
Size of the abrasive grain

Coarse	Medium	Fine	Very Fine
8	30	70	220
10	36	80	240
12	46	90	280
14	54	100	320
16	60	120	400
20		150	500
24		180	600

R
Hardness of the bond

Soft ← Medium → Hard

A N R T Z

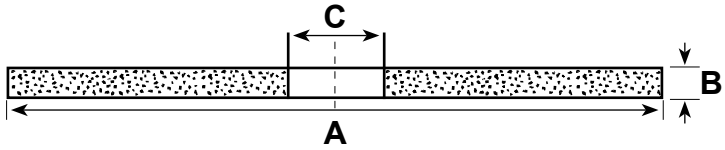
BF
Type of bond used

B	Resinoid
BF	Resiniod Reinforced
E	Shelac
O	Oxychloride
R	Rubber
RF	Rubber Reinforced
S	Silicate
V	Vitrified

Wheel Configurations

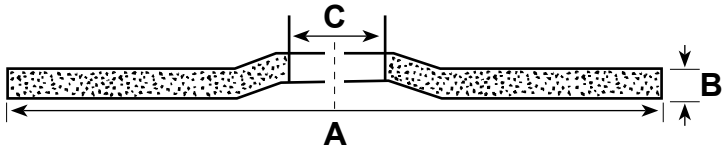
Bonded abbrasive wheels have different configurations depending upon the tool the wheel is used on and the desired end result. Below are the configurations that a wheel can have:

Type 1



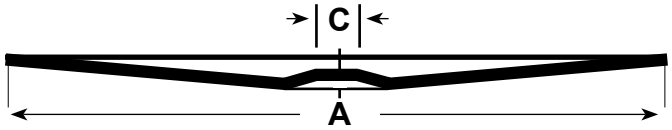
Straight Wheel

Type 27



Depressed Center Wheel

Type 29

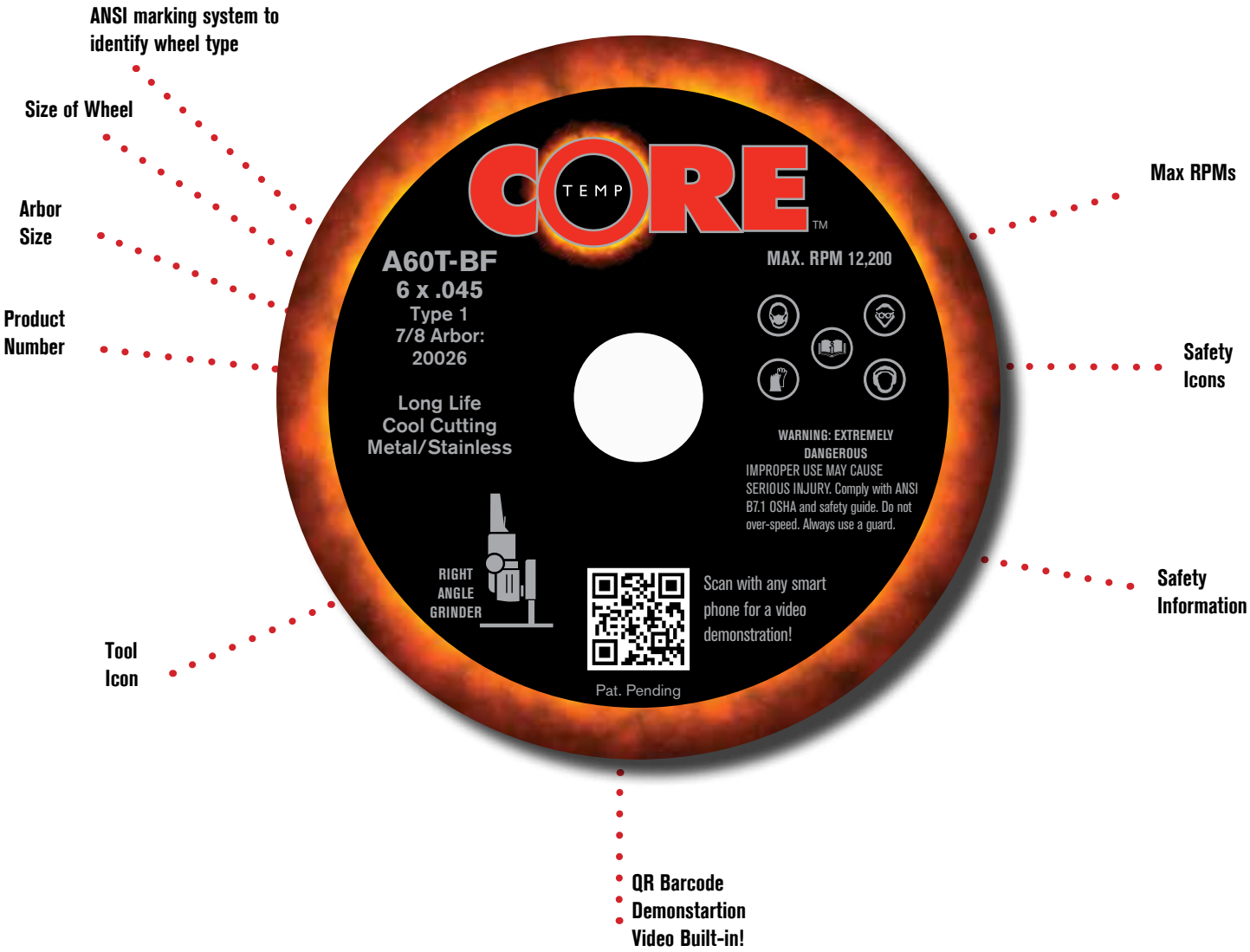


Flexible Wheel

Resin Bonded Abrasives

Sample of Wheel Label

Below is an example of a label that can be found on CORETEMPS' wheels. We feel it is important to include as much information as possible on all our labels so the end user has the pertinent information he needs to operate the wheel. All of our labels are baked on the wheels during manufacturing process, so the label remains intact throughout the life of the wheel.



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Thin Cutting Wheels

Cutting

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Flap Discs

Deburring Wheels

Quick Change Discs

Grinding Wheels

1/4" - Depressed Center Wheels

A24T - Edge Grinding

- Aluminum oxide grain
- Hard bond designed for edge and bevel grinding and other applications where a harder wheel is preferred
- Longer life for fewer wheel changes

M Ferrous Metals (iron, steel, welds, etc.)

S Low grade stainless steel

Dia.	Size Width	Bore	Max RPM	Grades Available Part Number A24T	Qty Per Box	Qty Per Ctn	Lbs Per Box
4-1/2	1/4	7/8	13,300	20145	25	100	9
4-1/2	1/4	5/8-11	13,300	20245	10	40	5
5	1/4	7/8	12,200	20155	25	100	11
5	1/4	5/8-11	12,200	20255	10	40	8
7	1/4	7/8	8,500	20175	15	60	13
7	1/4	5/8-11	8,500	20275	32	40	5
9	1/4	7/8	6,600	20195	20	40	20
9	1/4	5/8-11	6,600	20295	10	10	20

Grinding Wheels

NEW 1/8" - Pipeline Wheels

A36T - Cutting/Light Grinding

- Designed to perform both cutting and light grinding

M Ferrous Metals (iron, steel, welds, etc.)

S Low grade stainless steel

TECH-DESIGN

Pipeline .125 thickness well-suited for root passes and edge work.

Pipeline 5/32 thickness designed more for light-grinding when a heavy-duty wheel is the right choice.

NEW

Dia.	Size Width	Bore	Max RPM	Grades Available Part Number Pipeline - A36T	Qty Per Box	Qty Per Ctn	Lbs Per Box
4-1/2	1/8 (.125)	7/8	13,300	20345	50	400	8
4-1/2	1/8 (.125)	5/8-11	13,300	20445	10	40	4
4-1/2	1/8 (5/32)	7/8	13,300	21345	50	400	8
4-1/2	1/8 (5/32)	5/8-11	13,300	21445	10	40	4
5	1/8 (.125)	7/8	12,200	20355	40	240	8
5	1/8 (.125)	5/8-11	12,200	20455	10	40	5
7	1/8 (.125)	7/8	8,500	20375	30	120	12
7	1/8 (.125)	5/8-11	8,500	20475	10	40	5
7	1/8 (5/32)	7/8	8,500	21375	30	120	12
7	1/8 (5/32)	5/8-11	8,500	21475	10	40	5

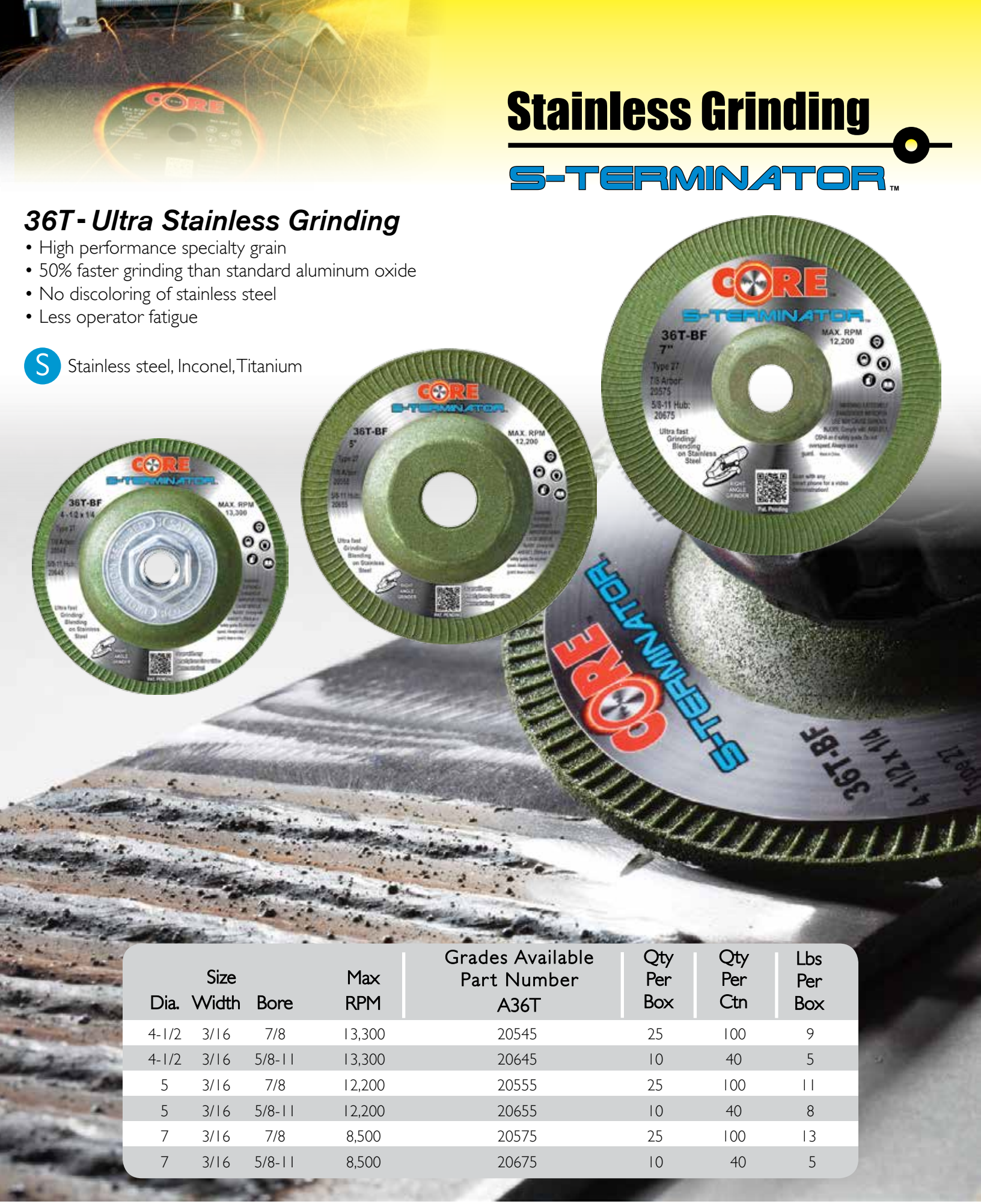
Stainless Grinding

S-TERMINATOR™

36T - Ultra Stainless Grinding

- High performance specialty grain
- 50% faster grinding than standard aluminum oxide
- No discoloring of stainless steel
- Less operator fatigue

S Stainless steel, Inconel, Titanium



Dia.	Size Width	Bore	Max RPM	Grades Available Part Number A36T	Qty Per Box	Qty Per Ctn	Lbs Per Box
4-1/2	3/16	7/8	13,300	20545	25	100	9
4-1/2	3/16	5/8-11	13,300	20645	10	40	5
5	3/16	7/8	12,200	20555	25	100	11
5	3/16	5/8-11	12,200	20655	10	40	8
7	3/16	7/8	8,500	20575	25	100	13
7	3/16	5/8-11	8,500	20675	10	40	5

Cutting

.045 Wheels

TYPE 1 FLAT

Dia.	Size Width	Bore	Max RPM	Grades Available Part Number A60T	Qty Per Box	Qty Per Ctn	Lbs Per Box
4-1/2	.045	7/8	13,300	20045	50	500	4
5	.045	7/8	12,200	20025	50	500	5
6	.045	7/8	10,200	20026	60	240	9
7	.045	7/8	8,500	20027	50	200	11

A60T

- Containment free for stainless steel
- Perfect grain to bond ratio for long life
- Outlasts competitors by up to 70%

M Ferrous Metals (iron, steel, welds, etc.)

S Low grade stainless steel

TYPE 27 DEPRESSED CENTER

Dia.	Size Width	Bore	Max RPM	Grades Available Part Number A60T	Qty Per Box	Qty Per Ctn	Lbs Per Box
4-1/2	.045	7/8	13,300	20010	50	500	4
4-1/2	.045	5/8-11	13,300	20084	10	40	2
5	.045	7/8	12,200	20015	50	500	5
5	.045	5/8-11	12,200	20085	10	40	2
6	.045	7/8	10,200	20016	60	240	9
6	.045	5/8-11	10,200	20086	10	40	3
7	.045	7/8	8,500	20017	50	200	11
7	.045	5/8-11	8,500	20087	10	40	2.5

Cutting

.045 Wheels

SUPERCORE

LONGEST LASTING .045 WHEEL IN THE UNIVERSE!!!

- Special aluminium Oxide blend
- Super Long life on Carbon steel
- Thin .045 width for precise cuts

M Ferrous Metals (iron, steel, welds, etc.)

S Low grade stainless steel

Dia.	Size Width	Bore	Max RPM	Part Number	Qty Per Box	Qty Per Ctn	Lbs Per Box
TYPE 27 DEPRESSED CENTER							
4-1/2	.045	7/8	13,300	22010	50	500	4
4-1/2	.045	5/8-11	13,300	22084	10	50	2
TYPE 1 FLAT							
4-1/2	.045	7/8	13,300	22045	50	500	4
6	.045	7/8	10,200	22026	60	240	9

Cutting

Thin High-Speed Cutting Wheels

A46T

- Aluminum oxide grain
- Hard bond for aggressive cutting on rough applications

M Ferrous Metals (iron, steel, welds, etc.)

S Low grade stainless steel

Production quality wheels tested against the best.
For Carbon steel and Stainless Steel
Burr-free cutting and smooth operating performance
Outlast the competition for 35-50% less cost

THIN HIGH-SPEED CUTTING WHEELS

Dia.	Size Width	Bore	Max RPM	Grades Available Part Number A60T	Qty Per Box	Qty Per Ctn	Lbs Per Box
3	.035	3/8	25,000	23035	85	1360	3
3	1/16	3/8	25,000	23016	85	1360	3
3	1/8	3/8	20,372	23018	50	800	3
4	1/16	3/8	19,000	23046	85	680	6
4	.1/8	3/8	15,278	23050	50	400	6

METAL CENTER!

23046
4 X 1/16 X 3/8

23050
4 X 1/8 X 3/8

23016
3 X 1/16 X 3/8

23018
3 X 1/8 X 3/8

Cutting

Chop Saws

Core Chop

- Center reinforced for burfree cutting
- Cool cutting increases wheel life
- Maximum cutting speed reduces heat and discoloration

M Ferrous Metals (iron, steel, welds, etc.)

S Low grade stainless steel

Core Stud

- Dual external reinforced for cutting thin metals
- Cuts angle iron, light gauge metals and metal studs

M Ferrous Metals (iron, steel, welds, etc.)

Size			Max	Grades Available Part Number		Qty	Qty	Lbs
Dia.	Width	Bore	RPM	Chop	STUD	Per Box	Per Ctn	Per Box
14	3/32	1	4,400	30010		25	25	35
14	3/32	1	4,400		30020	25	25	35

Cutting

Portable Saws

Metal - Long Life

- Special aluminum oxide blend
- Fast Cutting

M Ferrous Metals (iron, steel, welds, etc.)

Concrete - Long Life

- Special silicon carbide grain
- Excellent cutting section
- 25% Long Life

C Concrete, Brick, Block

Size			Max	Grades Available Part Number		Qty	Qty	Lbs
Dia.	Width	Bore	RPM	Metal	Concrete	Per Box	Per Ctn	Per Box
14	1/8	1 (20mm)*	5460	41440		10	20	17
14	1/8	1 (20mm)*	5460		41450	10	20	17

*Box quanity comes with bushings

Wire Brushes

Small Cup Brushes

- **For use on small grinders**
- Available in the following wire types
  - Knot wire for low to medium flexibility and aggressive cutting action
  - Stainless steel knot wire for use on stainless, aluminum and high strength alloys

Packaging

Industrial Packed 6/box / Clamshell Single Pack

Small Cup Brushes

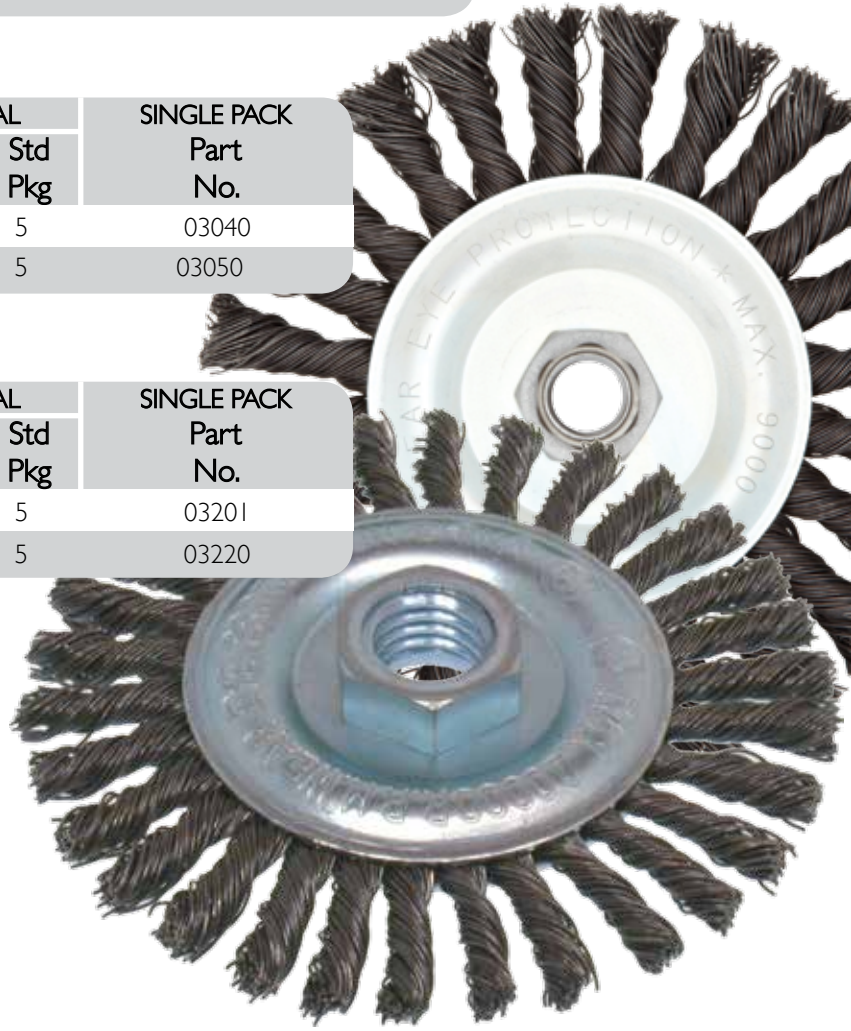
Dia.	Size Wire	Arbor	Wire Style	Matl Type	Max RPM	INDUSTRIAL Part No.	INDUSTRIAL Std Pkg	SINGLE PACK Part No.
2-3/4	.014	5/8-11	Knot	Carbon	12,500	01002	5	03002
2-3/4	.020	5/8-11	Knot	Carbon	12,500	01003	5	03003
2-3/4	.020	5/8-11	Knot	Stainless	12,500	01005	5	03005

Regular Twist / Straight or Type 1

Dia.	Size Wire	Arbor	Matl Type	Max RPM	INDUSTRIAL Part No.	INDUSTRIAL Std Pkg	SINGLE PACK Part No.
4	.020	5/8-11	Carbon	20,000	01040	5	03040
4	.020	5/8-11	Stainless	20,000	01050	5	03050

Stringer Bead / Pipeline

Dia.	Size Wire	Arbor	Matl Type	Max RPM	INDUSTRIAL Part No.	INDUSTRIAL Std Pkg	SINGLE PACK Part No.
4	.020	5/8-11	Carbon	20,000	01201	5	03201
4	.020	5/8-11	Stainless	20,000	01220	5	03220



Knot and Stringer Bead Brushes

- **For use on small grinders**
- Available in the following wire types
  - Regular twist covers more surface area in a single pass
  - Stringer bead twist excellent for welds, flux removal and where a narrow work face is required
  - Stainless steel wire for use on stainless, aluminum and high strength alloys

Packaging Industrial Packed 6/box / Clamshell Single Pack

CoreTek are in boxes of 25

CoreTek

Ceramic Fiber Discs

FIBER DISC BACKING PADS

Size Dia.	Size Arbor	Part No.
4-1/2	7/8	70004
5	7/8	70005
7	7/8	70007

All backing pads come with 5/8-11 nut

Size	Grit	Part No.
4-1/2 x 7/8	24	72424
4-1/2 x 7/8	36	72436
4-1/2 x 7/8	60	72460
4-1/2 x 7/8	80	72480
5 x 7/8	24	72524
5 x 7/8	36	72536
5 x 7/8	60	72560
5 x 7/8	80	72580
7 x 7/8	24	72724
7 x 7/8	36	72736
7 x 7/8	60	72760
7 x 7/8	80	72780

CoreTek

- 100% ceramic with top coat
- Use on Stainless steel and high tensile alloys
- Top coat eliminates bluing and burning on stainless steel
- Works great on aluminium

S Stainless, high tensile alloys

A Aluminum, non-ferrous metals

CoreTek are in boxes of 25

Zirconium

Fiber Discs

Size	Grit	Part No. Zirc	Part No. Z+
4-1/2 x 7/8	24	70424	71424
4-1/2 x 7/8	36	70436	71436
4-1/2 x 7/8	60	70460	71460
4-1/2 x 7/8	80	70480	71480
5 x 7/8	24	70524	71524
5 x 7/8	36	70536	71536
5 x 7/8	60	70560	71560
5 x 7/8	80	70580	71580
7 x 7/8	24	70724	71724
7 x 7/8	36	70736	71736
7 x 7/8	60	70760	71760
7 x 7/8	80	70780	71780

Zirconium and Z Plus are in boxes of 25

Use the Z+ Fiber Disc for aggressive stock removal on carbon steel

TEST:

6 - 5 minute tests against the leading U.S. Manufacturer. Total 30 minutes of edge grinding on carbon steel.

RESULTS:

7% More Metal Removal

Visibly Much Less Wear

36% LESS COST!

Zirconium

- Premium zirconium grain
- Aggressive stock removal and long life
- Best value and performance for production

M Ferrous Metals (iron, steel, welds, etc.)

S Low grade stainless steel

Z Plus

- Zirconium/ceramic blend
- **High Performance** best in class metal removal
- Top coat reduces heat build-up
- Outperforms all others

M Ferrous Metals (iron, steel, welds, etc.)

S Low grade stainless steel

U.S. Leading Manufacturer

Z+ Fiber Disc

Zirconium/ceramic

Ceramic Fiber Discs

Z+

DEMONSTRATED PERFORMANCE

Face view of metal before

Face view of metal before

Top view

Finished horizontal measure

Z+ Grinds 1.5" x 2" x 3/8" Carbon Steel with almost NO WEAR

Z Plus closeup before and after

Flap Discs

Blending/Finishing

TYPE 27 (FIBERGLASS-BACKED) REGULAR DENSITY

Size Dia.	Size Arbor	Grit	Part No.
4-1/2	7/8	36	80436
4-1/2	5/8-11	36	81436
4-1/2	7/8	40	80440
4-1/2	5/8-11	40	81440
4-1/2	7/8	60	80460
4-1/2	5/8-11	60	81460
4-1/2	7/8	80	80480
4-1/2	5/8-11	80	81480
4-1/2	7/8	120	80420
4-1/2	5/8-11	120	81420

Qty Per Box 10

TYPE 29 (FIBERGLASS-BACKED) REGULAR DENSITY

Size Dia.	Size Arbor	Grit	Part No.
4-1/2	7/8	36	78436
4-1/2	5/8-11	36 w/Metal Threaded Hub	79436
4-1/2	7/8	40	78440
4-1/2	5/8-11	40 w/Metal Threaded Hub	79440
4-1/2	7/8	60	78460
4-1/2	5/8-11	60 w/Metal Threaded Hub	79460
4-1/2	7/8	80	78480
4-1/2	5/8-11	80 w/Metal Threaded Hub	79480
4-1/2	7/8	120	78420
4-1/2	5/8-11	120 w/Metal Threaded Hub	79420
5	7/8	36	78536
5	5/8-11	36 w/Metal Threaded Hub	79536
5	7/8	40	78540
5	5/8-11	40 w/Metal Threaded Hub	79540
5	7/8	60	78560
5	5/8-11	60 w/Metal Threaded Hub	79560
5	7/8	80	78580
5	5/8-11	80 w/Metal Threaded Hub	79580
5	7/8	120	78520
5	5/8-11	120 w/Metal Threaded Hub	79520

Qty Per Box 10

with 5/8-11 Hub

Flap Discs

High Density

NEW

CERAMIC FLAP DISCS
REGULAR DENSITY TYPE 27

Size		Grit	Part No.
Dia.	Arbor		
4-1/2	7/8	40	83440
4-1/2	5/8-11	40 w/Metal Threaded Hub	84440

Qty Per Box 10

Ceramic Type 27 Hybrid

- Premium Ceramic
- Removes metal 50% faster than zirconium
- Adaptive Angle Technology built into the disc
- 5/8-11 style is threaded – No need for flanges

M Ferrous Metals (iron, steel, welds, etc.)

S Low grade stainless steel

Also Available With 5/8 -11 Hub

Flap Discs

CoreXL

TYPE 27 (FIBERGLASS-BACKED) REGULAR DENSITY

Size Dia.	Size Arbor	Grit	Part No.
4-1/2	7/8	40	77440
4-1/2	5/8-11	40	76440
4-1/2	7/8	60	77460
4-1/2	5/8-11	60	76460
4-1/2	7/8	80	77480
4-1/2	5/8-11	80	76480

Qty Per Box 10

NEW

CoreXL

- Made with the highest quality European material
- Out performs any wheel for the price
- Type 27 flat profile discs can be used at any angle due to their thickness
- Contaminant-free for stainless steel applications

M Ferrous Metals (iron, steel, welds, etc.)

S Low grade stainless steel

HardCore High Density (JUMBO)

- Made with the highest quality European material
- High Density style disc allows for a much greater range of stock removal and finishing
- Type 27 flat profile discs can be used at any angle due to their thickness
- Contaminant-free for stainless steel applications

M Ferrous Metals (iron, steel, welds, etc.)

S Low grade stainless steel

FLAP DISCS HIGH DENSITY (JUMBO) FIBERGLASS

Size Dia.	Size Arbor	Grit	Part No. Type 27
4-1/2	7/8	36	87436
4-1/2	5/8-11	36 w/Metal Threaded Hub	89436
4-1/2	7/8	40	87440
4-1/2	5/8-11	40 w/Metal Threaded Hub	89440
4-1/2	7/8	60	87460
4-1/2	5/8-11	60 w/Metal Threaded Hub	89460
4-1/2	7/8	80	87480
4-1/2	5/8-11	80 w/Metal Threaded Hub	89480
4-1/2	7/8	120	87420
4-1/2	5/8-11	120 w/Metal Threaded Hub	89420

Qty Per Box 10

Flap Wheels

Core A/O

- Premium Aluminum Oxide Grain
- Fast stock removal and long life
- Great for cleaning, deburring, finishing
- Will not burn or discolor metal
- Heavy duty backing

M Ferrous metals and/or non-ferrous metals (iron, steel, aluminum)

Size Dia.	Size Width	Grit	Part No.
1	1	60	61000
1	1	80	61010
1	1	120	61020
1-1/2	1	60	61500
1-1/2	1	80	61510
1-1/2	1	120	61520
2	1	60	62000
2	1	80	62010
2	1	120	62020

Qty Per Box 10

Size Dia.	Size Width	Grit	Part No.
2-1/2	1	60	62500
2-1/2	1	80	62510
2-1/2	1	120	62520
3	1	60	63000
3	1	80	63010
3	1	120	63020
3	2	60	63200
3	2	80	63210
3	2	120	63220

Qty Per Box 10

Core Flex

Core Flex

- Premium Aluminum Oxide Grain
- Cool blending and finishing without loading
- Flexible for smooth blending and finishing

S Stainless, high tensile alloys

A Aluminum, non-ferrous metals

Size Dia.	Size Bore	Max RPM	Part No. A36	Part No. A54	Qty Per Box	Lbs Per Box
4-1/2	7/8	13,300	99105	99100	10	2
4-1/2	5/8-11	13,300	99106	99200	10	2
7	7/8	8,500	99300	99305	10	5
7	5/8-11	8,500	99400	99306	10	5

Unitized Wheel

Ultra Blending/Finishing

Series 888

- Hard density, medium grade, aluminum oxide
- Use after flap disc operation
- Perfect finish without compound and buff
- Excellent operator feel

S Stainless, high tensile alloys

A Aluminum, non-ferrous metals

Size		Bond	Part No.
Dia.	Arbor		
4-1/2	7/8	Hard	90100
4-1/2	5/8-11	Hard	90101

Qty Per Box 5

Deburring Wheels

Cotton Fiber - Deburring Wheels

- Smooth control and operator feel
- Grind, debur and finish in one step
- Long life vs. standard deburring wheels

S Stainless, high tensile alloys

A Aluminum, non-ferrous metals

DEBURRING WHEELS

Size	Grit	Part No.	Qty Per Box
2 x 1/8 x 1/4	Hard-C	95210	10
2 x 1/8 x 1/4	Med-S	95220	10
3 x 1/8 x 1/4	Hard-C	95300	10
3 x 1/8 x 1/4	Med-S	95330	10

Cotton Fiber - Mounted Points

- A60M - Resin Bond light removal-blending
- A80F - Latex Bond for fine finishing

S Stainless, high tensile alloys

A Aluminum, non-ferrous metals

MOUNTED POINTS

Type	Size		Shank	Part No.		"0" = 1/2"	Qty
	Dia.	Length	Dia.	A60M	A80F	Max RPM	Per Box
A5	3/4	1-1/8	1/4	96100	97100	45,000	10
B42	1/2	3/4	1/4	96200	97200	61,120	10
B52	3/8	3/4	1/4	96300	97300	81,000	10
B121	1/2	1/2	1/4	---	97400	76,390	10
B122	3/8	3/8	1/4	---	97500	81,370	10
W163	1/4	1/2	1/4	---	97600	33,750	10
W189	1/2	2	1/4	96700	97700	24,000	10
W220	1	1	1/4	---	97800	30,000	10
W222	1	2	1/4	---	97900	20,000	5

Quick Change Discs

Cotton Fiber - Laminated Discs

- Premium Aluminum Oxide Grain
- Available in medium (36) and fine (54, 80)
- Will not burn stainless steel
- Will not clog on aluminum

S Stainless, high tensile alloys

A Aluminum, non-ferrous metals

COTTON QR DISCS CORE-LOCK-R

Size	Grit	Part No.	Qty Per Box
2"	A36F	92036	25
2"	A54F	92054	25
2"	A80F	92080	25
3"	A36F	93036	25
3"	A54F	93054	25
3"	A80F	93080	25

Zirc-Plus - Laminated Discs

- Premium Zirconium Grain with Grinding Aid
- Extremely fast stock removal and long life
- Outlast other discs 2 to 1
- Will not burn or discolor stainless steel
- Heavy duty polyester/cloth Backing

S Stainless, high tensile alloys

M Ferrous Metals (iron, steel, welds, etc.)

A Aluminum, non-ferrous metals

LAMINATED DISCS CORE-LOCK-R

Size	Grit	Part No.	Qty Per Box
2"	40	92136	100
2"	50	92154	100
2"	80	92180	100
3"	40	93136	50
3"	50	93154	50
3"	80	93180	50

BACKING PADS

Size	Part No.
2"	92000
3"	93000

Surface Condition Discs

HARDCORE TEMP

Surface Conditioning Discs

Excellent for deburring, blending, cleaning, polishing

For use in:

- Gasket Removal
- Paint and Rust Removal
- Metal Prep and Finish
- Paint Preparation

S Low grade stainless steel

M Ferrous Metals (iron, steel, welds, etc.)

W Wood

MADE IN USA

Widest Range of Grits Available!

Part #	Dia.	Color	Grit	Qty Per Box
90020	2"	Brown	Coarse	50
90021	2"	Brown	X-Tra Coarse	50
90022	2"	Burgundy	Medium	50
90023	2"	Burgundy	Heavy Duty Medium	50
90024	2"	Blue	Fine	50
90025	2"	Grey	Ultra Fine	50
90030	3"	Brown	Coarse	25
90031	3"	Brown	X-Tra Coarse	25
90032	3"	Burgundy	Medium	25
90033	3"	Burgundy	Heavy Duty Medium	25
90034	3"	Blue	Fine	25
90035	3"	Grey	Ultra Fine	25
90050	5"	Brown	Coarse	10
90051	5"	Burgundy	Medium	10
90052	5"	Blue	Fine	10
90053	5"	Grey	Ultra Fine	10
90070	7"	Brown	Coarse	10
90071	7"	Burgundy	Medium	10
90072	7"	Blue	Fine	10
90073	7"	Grey	Ultra Fine	10

Storage and Handling

All abrasive wheels are breakable and therefore care shall be exercised in handling and storage to prevent damage. The following rules, which are based on experience, should be observed:

- Handle wheel carefully to prevent dropping or bumping
- Do not roll wheels (hoop fashion)
- Use trucks or other suitable conveyances to provide support and protection in transporting all wheels which cannot be carried by hand
- Suitable racks, bins, drawers or boxes shall be provided to store the various types of wheels used
- Abrasive wheels should be stored in a dry area not subject to extreme temperature changes since some bonds may be affected by excessive humidity and temperature differentials
- Racks should be located as near as practical to the grinding location, but never where there is danger of damage from passing trucks, crane handling equipment or excessive vibration

Important:

The following information about safety should be used only as a guide. All products listed in this catalog shall be used in accordance with safety regulations set by OSHA and by the directive described by the American National Safety Institute B7.1, the Canadian Standard Association Safety Code B-173-5 and by the American Brush Manufacturers Association covering: Speed, Safety Guards, Flanges, Mounting Procedures, General Operating Rules, Handling, Storage, and Inspection of General Machine Conditions.

Warning:

Avoid inhalation of dust generated by grinding and cutting operations. Exposure to dust may cause respiratory ailments as well as irritation to eyes and skin. In most cases, a greater hazard is the exposure to the dust/fumes from the base material being ground or paint or coatings applied to it. Use approved NIOSH or MSHA respirators, safety glasses or face shields, gloves and protective clothing. Provide adequate ventilation to eliminate dust or to maintain dust levels below the permissible exposure level for nuisance dust as classified by OSHA. Refer to Material Safety Data Sheet for further information.
All operators must read and understand safety information thoroughly.

Follow Safety Instructions:

You must follow all operator and safety instructions, as well as all common safety practices which reduce the likelihood of physical injury.

Operate Wheels at Recommended Speeds:

It is imperative that abrasive wheels be operated at recommended safe speeds. For safety reasons no abrasive wheel shall be operated at a speed greater than that indicated on the blotter or wheel.

Dos and Don'ts

- **Do** always handle and store wheels in a careful manner.
- **Do** visually inspect all wheels before mounting for possible damage.
- **Do** make sure operating speed of machine does not exceed speed marked on wheel, its blotter or container.
- **Do** check mounting flanges for equal size, relieved as required & correct diameter.
- **Do** use mounting blotters as required by ANSI standards.
- **Do** be sure work rest is properly adjusted on bench, pedestal and floor stand grinders.
- **Do** always use safety guard that covers a minimum of one-half (1/2) the abrasive wheel.
- **Do** allow newly mounted wheels to run at operating speed, with guard in place, for at least one minute before grinding.
- **Do** always wear safety glasses or some type of approved eye protection while grinding or cutting.
- **Do** turn off coolant before stopping wheel to avoid creating an out of-balance condition.
- **Do** follow common sense safety considerations.
- **Do** follow federal, state and local laws and regulations.

- **Don't** use a wheel that has been dropped or appears to have been abused.
- **Don't** force a wheel onto the machine or alter the size of the mounting hole. If wheel won't fit the machine, get one that will.
- **Don't** ever exceed maximum operating speed established for the wheel.
- **Don't** use mounting flanges on which the bearing surfaces are not clean, flat and smooth.
- **Don't** tighten the mounting nut excessively.
- **Don't** grind on the side of conventional, straight or Type 1 wheels.
- **Don't** use a wheel on any machine that is not properly designed for the specific application of the wheel.
- **Don't** start the machine until the safety guard is properly and securely in place.
- **Don't** jam work into the wheel.
- **Don't** stand directly in front of a grinding/cutting wheel whenever a machine is in operation.
- **Don't** grind or cut material for which the wheel is not designed

SAFETY & SPEED CONVERSIONS

GRINDING WHEEL SAFETY GUIDE

SAFETY INFORMATION

This safety information should be used only as a guide for the CoreTemp Abrasives range of products.

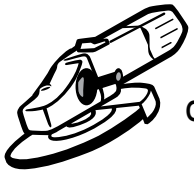
1. Check all wheels for cracks or other damage before mounting.
2. Check machine speeds against maximum operating speed of the wheel.
3. Be sure that the wheel bore, threaded or unthreaded, fits machine arbor properly ad that flanges are clean, flat, and of the proper type for the wheel you are mounting.
4. Run the wheel in a protected area at least one minute before grinding.
5. Wheels must be properly guarded.
6. Wear protective safety glasses or a proper face shield.
7. Do not use wheels which have been dropped or otherwise damaged.
8. Do not use excessive pressure when mounting wheels between flanges. Tighten nut sufficiently to hold wheel firmly.
9. Do not use heavy side grinding pressure on any type 1 straight sided wheel.
10. Do not mount more than one wheel on a single arbor.

STORAGE

CoreTemp Abrasive Wheels should be stacked flat, not on their edges. Store in a dry area.

RPM / SFPM CONVERSIONS

DIE GRINDER



ANGLE GRINDER

DEFINITIONS:

SFPM = Surface Speed in Feet per Minute
RPM = Revolutions per Minute
M/S = Meters per Second

The SFPM for most T27 bonded grinding wheels is approximately 15, 600.

Note that this is equal to the European standard of 80 M/S or 13,300 RPM for a 4-1/2" diameter wheel.

CALCULATIONS:

- to convert RPM to SPFM....SFPM = (RPMxDIA) /3.82
- to convert SFPM to RPM.....RPM = (SFPM x 3.82) / DIA
- to convert M/S to SPFM.....M/S x 197
- to convert SFPM to M/S.....SFPM x .005

For more information regarding Safe Operating Speeds. refer to ANSI B.7.1 Table 23 - "Standard maximum speeds in surface feet per minute" and Table 35 - "Conversion Table - Wheel speeds."

NOTES

Cutting Edge Technology That's Real

1-860-882-1044
www.coretempabrasives.com

Northeast Warehouse - Hartford, CT
South Central Warehouse - Houston, TX