

COMBIDISC®
The product line for many applications



TRUST BLUE

- Versatile product line for coarse machining, surface texturing and polishing
 - Optimal solutions even for complicated applications
 - High performance, quick and safe
-

COMBIDISC® quick-change discs

General information

The COMBIDISC® product range contains a wide selection of grinding products for surface finishing. From coarse machining and surface texturing to face-down mirror polishing – the range provides the best product, even for complicated applications.

Advantages:

- Reduced down time due to quick disc changes.
- Great convenience due to simple handling and low-vibration working.
- No operational disruptions caused by sticking, slipping or disengaging.

Applications:

- Roughing
- Leveling
- Deburring
- Surface work
- Work on edges
- Polishing
- Cleaning
- Sharpening
- Work on weld seams
- Structuring surfaces
- Step-by-step fine grinding

Recommendations for use:

- Use COMBIDISC® grinding discs with arbors or abrasive disc holders on flexible shaft drives with angle handpieces, compressed-air or electric angle grinders.

Compatible power tools:

- Flexible shaft drives
- Straight grinders
- Angle grinders
- Cordless angle grinders

Ordering notes:

- Please order arbors or COMBIDISC® abrasive disc holders separately. More detailed information and ordering data can be found on page 17.

Safety notes:

- The maximum permitted peripheral speed is 9,800 SFPM.
- For safety reasons, it is imperative to remain within the stated maximum permitted rotational speed at all times.



Accessories:

- Arbors for COMBIDISC® Mini-POLIFAN
- COMBIDISC® abrasive disc holders

PFERDVALUE®:

PFERDERGONOMICS recommends COMBIDISC® products as a solution to sustainably reduce vibration, noise and dust levels produced by discs and to improve working comfort.

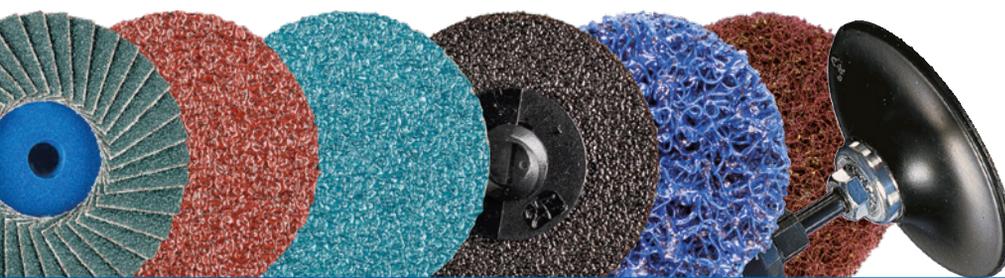


PFERDEFFICIENCY® recommends COMBIDISC® products to reduce disc change and setup times.



PFERDVIDEO:

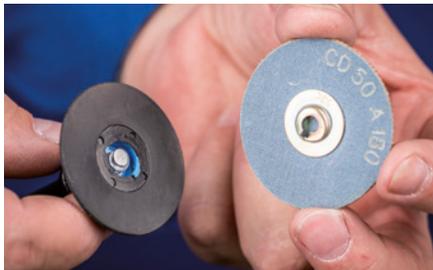
Learn more about the advantages of using COMBIDISC® products.



PFERD offers two alternative mounting systems:



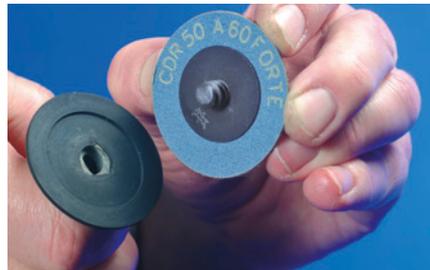
CD system



Disc side: Threaded connection with female thread (metal/plastic)



CDR system



Disc side: Threaded connection with male thread (plastic)

Overview of COMBIDISC® quick-change discs

| | | | | | |
|--|---|--------------------------|----|--------------|----|
| Mini-POLIFAN® CD, CDR | 4 | Abrasive discs – RS type | 13 | Felt discs | 17 |
| ■ Drive arbors for Mini-POLIFAN® discs | 4 | Non-woven discs | 14 | Backing pads | 17 |
| Abrasive discs | 5 | POLICLEAN® discs | 14 | Sets | 18 |
| VICTOGRAIN® | 9 | Unitized discs | 16 | | |

COMBIDISC® quick-change discs

General information



Recommended rotational speed range

Example:

EDP: 42292 2" CD CO-COOL

Application:

Grinding alloyed steel

Peripheral speed: 4,000–5,000 SFPM

Rotational speed: 7,600–9,600 RPM

| D ₁ [Inches] | Peripheral speed [SFPM] | | | | | | | | | |
|----------------------------|-------------------------|-------|--------|--------|--------|--------|--------|--------|--------|--|
| | 1,000 | 2,000 | 3,000 | 4,000 | 5,000 | 6,000 | 7,000 | 8,000 | 10,000 | |
| Rotational speeds [RPM] | | | | | | | | | | |
| 1 | 3,800 | 7,600 | 11,500 | 15,300 | 19,100 | 22,900 | 26,700 | 30,600 | 38,200 | |
| 1-1/2 | 2,500 | 5,100 | 7,600 | 10,200 | 12,700 | 15,300 | 17,800 | 20,400 | 25,500 | |
| 2 | 1,900 | 3,800 | 5,700 | 7,600 | 9,600 | 11,500 | 13,400 | 15,300 | 19,100 | |
| 3 | 1,300 | 2,500 | 3,800 | 5,100 | 6,400 | 7,600 | 8,900 | 10,200 | 12,700 | |

Quick product selection guide

| Material group ▼ | | | Abrasive ▶ | Aluminum oxide A, A-PLUS, A-CONTOUR | Aluminum oxide A Compact grain | Zirconia alumina Z | Silicon carbide SiC | Ceramic oxide CO-COOL | VICTOGRAIN® COOL | Diamond abrasive discs | POLICLEAN® discs | Non-woven discs Soft type, Hard type, Unitized |
|---------------------------|---|---|------------|-------------------------------------|--------------------------------|--------------------|---------------------|-----------------------|------------------|------------------------|------------------|--|
| Steel, cast steel | Non-hardened, non-heat-treated steels | Construction steels, carbon steels, tool steels, non-alloyed steels, cast steel | ● | | ○ | | | | ● | | ● | ● |
| | Hardened, heat-treated steels | Tool steels, tempering steels, alloyed steels, cast steel | ○ | ● | ● | | | | ● | | ○ | ○ |
| Stainless steel (INOX) | Rust- and acid-resistant steels | Austenitic and ferritic stainless steels | | ● | ○ | | | ● | ● | | ● | ● |
| Non-ferrous metals | Soft non-ferrous metals, non-ferrous metals | Soft aluminum alloys | ○ | | | | | ● | | | ● | ● |
| | | Brass, copper, zinc | ● | | ○ | | | | | | ● | ● |
| | Hard non-ferrous metals | Hard aluminum alloys | ● | | ○ | ○ | | | | | ● | ● |
| | | Bronze, titanium | | | ○ | ● | | | ● | ● | ○ | ● |
| | High-temperature-resistant materials | Nickel-based and cobalt-based alloys | | | ○ | | | ● | ● | ○ | ● | |
| Cast iron | Grey cast iron, white cast iron | Cast iron with flake graphite, with nodular graphite cast iron, white annealed cast iron, black cast iron | ● | | ○ | | | | | | ● | ● |
| Plastics, other materials | | Fibre-reinforced plastics, thermoplastics, wood, chipboard, paintwork | ● | | | | ● | | | ● | ● | ● |

● = highly recommended

○ = recommended

COMBIDISC® quick-change discs

Mini-POLIFAN® CD, CDR

Mini-POLIFAN® Aluminum oxide A

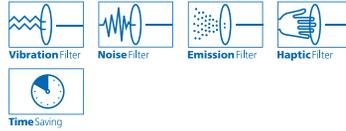
For universal coarse grinding work with high stock removal rates.
Ideal for dressing weld seams in hard-to-reach places.
Longer service life and higher stock removal rate when compared to abrasive discs.

Abrasive:
Aluminum oxide A

Ordering notes:

- Please order arbors or COMBIDISC® abrasive disc holders separately. See below and page 17.

PFERDVALUE®:



| D ₁ [Inches] | Grit and EDP number | | | | Opt. RPM | |
|----------------------------|---------------------|-------|-------|-------|---------------|----|
| | 40 | 60 | 80 | 120 | | |
| CD system | | | | | | |
| 2 | 42802 | 42803 | 42804 | 42805 | 12,000–14,000 | 10 |
| 3 | 42808 | 42809 | 42810 | 42811 | 8,000–10,000 | 10 |
| CDR system | | | | | | |
| 2 | 42912 | 42913 | 42914 | 42915 | 12,000–14,000 | 10 |
| 3 | 42918 | 42919 | 42920 | 42921 | 8,000–10,000 | 10 |

Mini-POLIFAN® Zirconia alumina Z

For coarse grinding work with a high stock removal rate and a long service life.

Abrasive:
Zirconia alumina Z

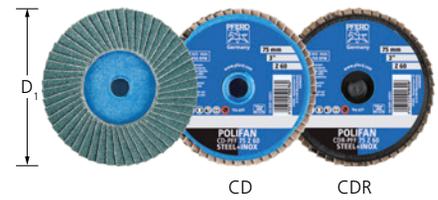
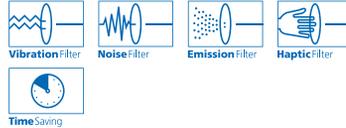
Recommendations for use:

- Use in the case of a higher contact pressure.

Ordering notes:

- Please order arbors or COMBIDISC® abrasive disc holders separately. See below and page 17.

PFERDVALUE®:

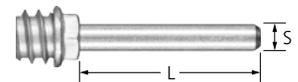


| D ₁ [Inches] | Grit and EDP number | | | | Opt. RPM | |
|----------------------------|---------------------|-------|-------|-------|---------------|----|
| | 40 | 60 | 80 | 120 | | |
| CD system | | | | | | |
| 2 | 42814 | 42815 | 42816 | 42817 | 12,000–14,000 | 10 |
| 3 | 42820 | 42821 | 42822 | 42823 | 8,000–10,000 | 10 |
| CDR system | | | | | | |
| 2 | 42924 | 42925 | 42926 | 42927 | 12,000–14,000 | 10 |
| 3 | 42930 | 42931 | 42932 | 42933 | 8,000–10,000 | 10 |

Drive arbors

Drive arbors for Mini-POLIFAN® discs

Matching arbor for use with COMBIDISC® Mini-POLIFAN® discs with CD thread.



| S [Inches] | L [Inches] | EDP number | Recommended diameters | |
|---------------|---------------|------------|-----------------------|---|
| 1/4 | 1-1/2 | 42851 | 2 | 1 |
| | | 42852 | 3 | 1 |

COMBIDISC® quick-change discs

Abrasive discs

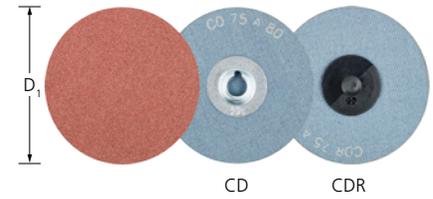
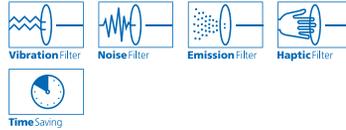
Aluminum oxide A

For universal coarse to fine grinding applications in industry and professional trades.

Abrasive:
Aluminum oxide A

Ordering notes:
■ Please order backing pad separately.
See page 17.

PFERDVALUE®:



| D ₁ [Inches] | Grit and EDP number | | | | | | | Opt. RPM |  |
|---|---------------------|-------|-------|-------|-------|-------|-------|---------------|---|
| | 36 | 50 | 60 | 80 | 120 | 180 | 320 | | |
| CD system  | | | | | | | | | |
| 1 | - | - | 42136 | 42137 | 42139 | 42141 | 42143 | 15,000–26,000 | 100 |
| 1-1/2 | 42145 | - | 42148 | 42149 | 42151 | 42153 | 42155 | 10,000–16,000 | 100 |
| 2 | 42157 | 42159 | 42160 | 42161 | 42163 | 42165 | 42167 | 8,000–13,000 | 100 |
| 3 | 42169 | 42171 | 42172 | 42173 | 42175 | 42177 | 42179 | 5,000–9,000 | 50 |
| CDR system  | | | | | | | | | |
| 1 | - | - | 42481 | 42482 | 42484 | 42486 | 42488 | 15,000–26,000 | 100 |
| 1-1/2 | 42490 | - | 42493 | 42494 | 42496 | 42498 | 42500 | 10,000–16,000 | 100 |
| 2 | 42502 | 42504 | 42505 | 42506 | 42508 | 42510 | 42512 | 8,000–13,000 | 100 |
| 3 | 42514 | 42516 | 42517 | 42518 | 42520 | 42522 | 42524 | 5,000–9,000 | 50 |

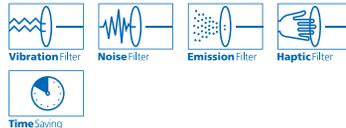
Aluminum oxide A-PLUS

For universal applications from coarse to fine grinding. Higher stock removal rate due to sturdy backing material. Recommended for use in edge grinding due to high tear strength.

Abrasive:
Aluminum oxide A-PLUS

Ordering notes:
■ Please order backing pad separately.
See page 17.

PFERDVALUE®:



| D ₁ [Inches] | Grit and EDP number | | | | Opt. RPM |  |
|---|---------------------|---------|---------|----------|--------------|---|
| | 36 PLUS | 60 PLUS | 80 PLUS | 120 PLUS | | |
| CD system  | | | | | | |
| 2 | 42330 | 42331 | 42332 | 42333 | 8,000–13,000 | 100 |
| 3 | 42335 | 42336 | 42337 | 42338 | 5,000–9,000 | 50 |
| CDR system  | | | | | | |
| 2 | 42670 | 42671 | 42672 | 42673 | 8,000–13,000 | 100 |
| 3 | 42675 | 42676 | 42677 | 42678 | 5,000–9,000 | 50 |



COMBIDISC® quick-change discs

Abrasive discs

Aluminum oxide A compact grain

Extremely well suited for fine and very fine grinding, and for step-by-step preparations for polishing.

The self-sharpening compact grain facilitates a very long service life and achieves consistent surface quality levels throughout the entire service life.

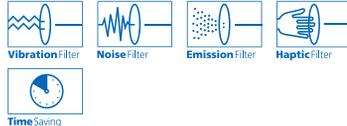
Abrasive:

Aluminum oxide A compact grain (CK)

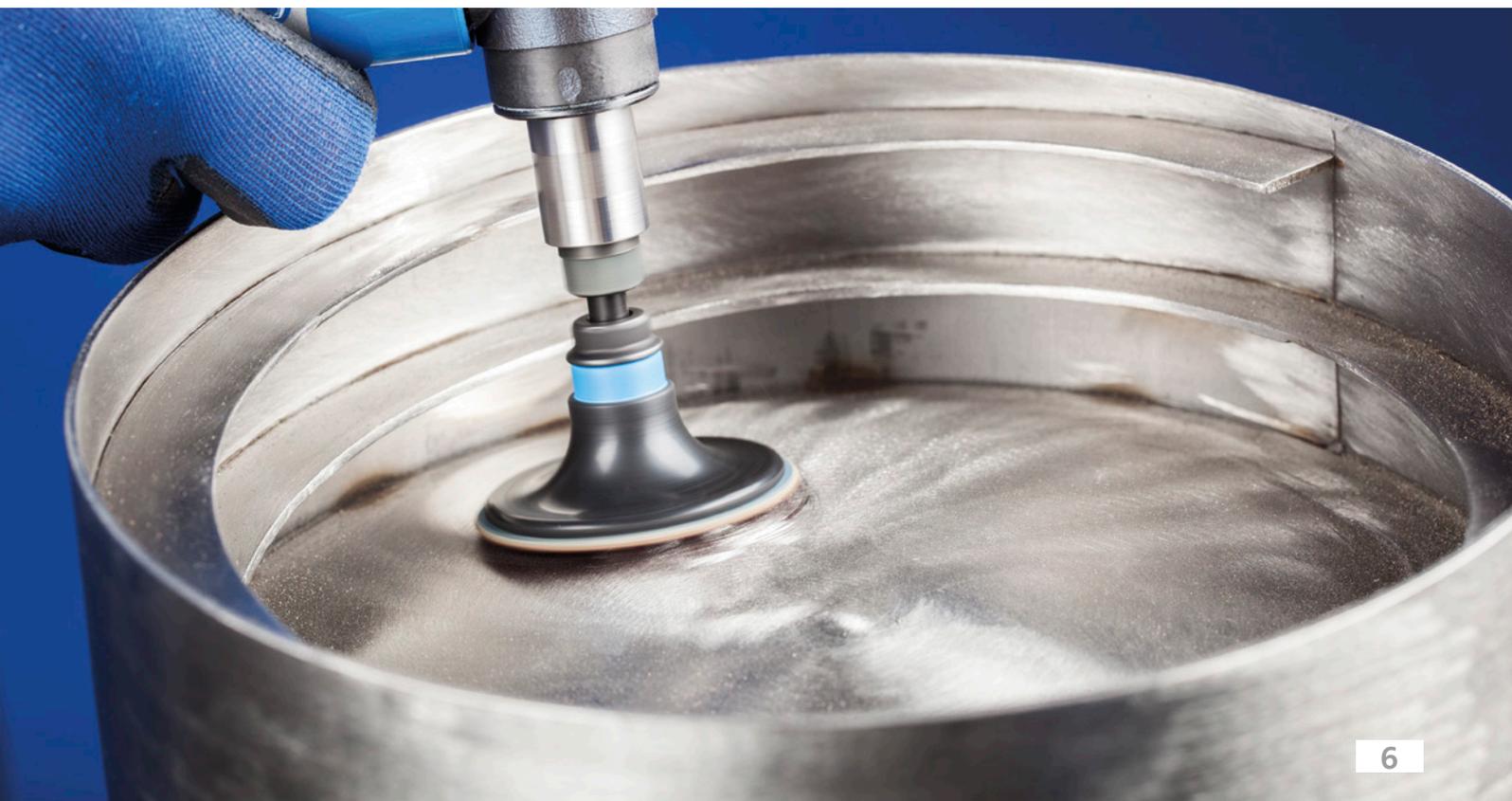
Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



| | D ₁ [Inches] | Grit and EDP number | | | | | | | | Opt. RPM |  | |
|-------------------|----------------------------|---|-------|-------|-------|-------|-------|-------|-------|-------------|---|------|
| | | 120 | 180 | 240 | 320 | 400 | 600 | 800 | 1000 | | | 1200 |
| CD system | |  | | | | | | | | | | |
| | 2 | 42936 | 42937 | 42938 | 42939 | 42940 | 42941 | 42942 | 42943 | 42944 | 3,800–13,000 | 100 |
| | 3 | 42945 | 42946 | 42947 | 42948 | 42949 | 42950 | 42951 | 42952 | 42953 | 2,500–9,000 | 50 |
| CDR system | |  | | | | | | | | | | |
| | 2 | 42954 | 42955 | 42956 | 42957 | 42958 | 42959 | 42960 | 42961 | 42962 | 3,800–13,000 | 100 |
| | 3 | 42963 | 42964 | 42965 | 42966 | 42967 | 42968 | 42969 | 42970 | 42971 | 2,500–9,000 | 50 |



COMBIDISC® quick-change discs

Abrasive discs

Zirconia alumina Z

For coarse grinding work with a high stock removal rate and a long service life.

Abrasive:

Zirconia alumina Z

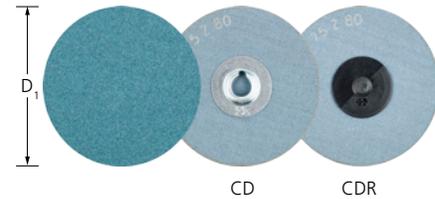
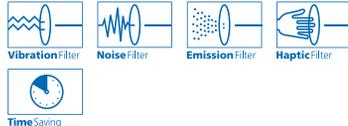
Recommendations for use:

- Use with hard or medium-hard COMBI-DISC® abrasive disc holders.

Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



| | D ₁ [Inches] | Grit and EDP number | | | | Opt. RPM |  |
|---|----------------------------|---------------------|-------|-------|-------|--------------|---|
| | | 36 | 50 | 60 | 80 | | |
| CD system  | | | | | | | |
| | 2 | 42254 | 42256 | 42257 | 42258 | 3,800–13,000 | 100 |
| | 3 | 42261 | 42263 | 42264 | 42265 | 2,500–9,000 | 50 |
| CDR system  | | | | | | | |
| | 2 | 42593 | 42595 | 42596 | 42597 | 3,800–13,000 | 100 |
| | 3 | 42600 | 42602 | 42603 | 42604 | 2,500–9,000 | 50 |



COMBIDISC® quick-change discs

Abrasive discs

Ceramic oxide CO-COOL

For aggressive grinding with maximum stock removal rate on hard materials which do not conduct heat well. Consistently high performance due to self-sharpening ceramic oxide grain.

Active grinding additives in the coating substantially improve the stock removal rate, prevent loading and result in cooler grinding.

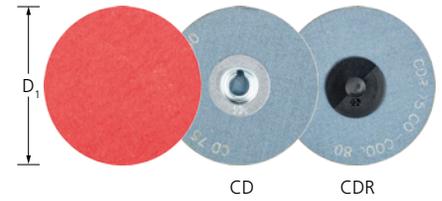
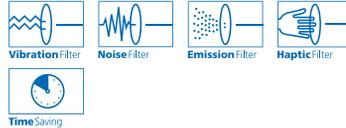
Abrasive:

Ceramic oxide CO-COOL

Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



| | D ₁ [Inches] | Grit and EDP number | | | | | Opt. RPM |  |
|---|----------------------------|---------------------|-------|-------|-------|-------|--------------|---|
| | | 24 | 36 | 60 | 80 | 120 | | |
| CD system  | | | | | | | | |
| | 2 | 42280 | 42289 | 42292 | 42293 | 42295 | 3,800–13,000 | 100 |
| | 3 | 42281 | 42296 | 42299 | 42300 | 42302 | 2,500–9,000 | 50 |
| CDR system  | | | | | | | | |
| | 2 | 42619 | 42628 | 42631 | 42632 | 42634 | 3,800–13,000 | 100 |
| | 3 | 42620 | 42635 | 42638 | 42639 | 42641 | 2,500–9,000 | 50 |

Ceramic oxide CO-COOL mini fibre discs

Exceptionally well-suited to surface and edge grinding. The fibre backing strengthens the abrasive disc and improves stock removal.

For aggressive grinding with maximum stock removal rate on hard materials which do not conduct heat well. Consistently high performance due to self-sharpening ceramic oxide grain.

Active grinding additives in the coating substantially improve the stock removal rate, prevent loading and result in cooler grinding.

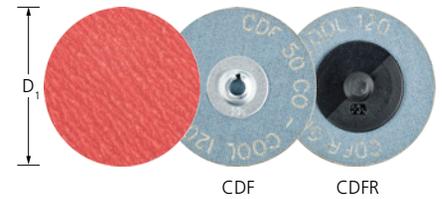
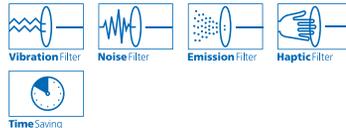
Abrasive:

Ceramic oxide CO-COOL

Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



| | D ₁ [Inches] | Grit and EDP number | | | | Opt. RPM |  |
|---|----------------------------|---------------------|-------|-------|-------|--------------|---|
| | | 36 | 50 | 80 | 120 | | |
| CD system  | | | | | | | |
| | 2 | 40492 | 40494 | 40496 | 40497 | 3,800–13,000 | 100 |
| | 3 | 40499 | 40501 | 40503 | 40504 | 2,500–9,000 | 50 |
| CDR system  | | | | | | | |
| | 2 | 40632 | 40634 | 40636 | 40637 | 3,800–13,000 | 100 |
| | 3 | 40639 | 40641 | 40643 | 40644 | 2,500–9,000 | 50 |

COMBIDISC® quick-change discs

VICTOGRAIN®

VICTOGRAIN® abrasive material is used to make some of the most effective grinding products in the world. PFERD's triangular, precision-formed grain achieves ultimate performance.



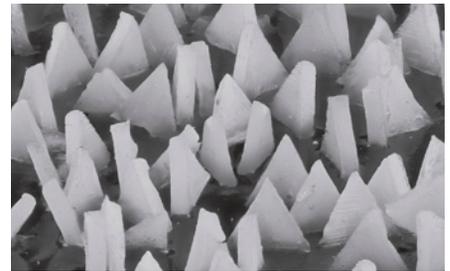
The **VICTOGRAIN®** abrasive grain triangles are identical in shape and size and their cutting edges are applied to the workpiece at the optimum angle, meaning the grain needs very little energy to penetrate the workpiece. As a result, the user experiences superior productivity due to:

- extremely high stock removal,
- a long service life,
- and reduced heat build-up in the workpiece.

Each **VICTOGRAIN®** abrasive grain triangle is firmly fixed on one of its sides to the backing material. Due to the slim design, **VICTOGRAIN®** offers an extremely large chip space for maximum cutting efficiency.

The structure of the triangular **VICTOGRAIN®** is specially engineered to maximize results. The very fine crystalline structure ensures optimal wear characteristics as sharp cutting edges are always exposed, with the minimum amount of abrasive breaking off from the triangle.

By combining all these properties together, users benefit from optimal, consistent performance, cool grinding and an extremely long service life with uniform workpiece surface roughness.



The **VICTOGRAIN®** abrasive grain is optimally aligned

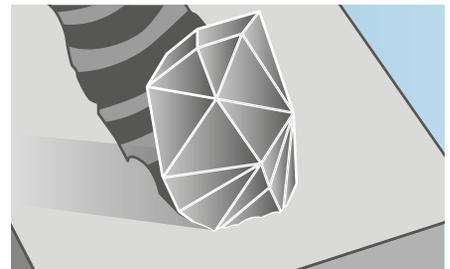


VICTOGRAIN® coated abrasive material

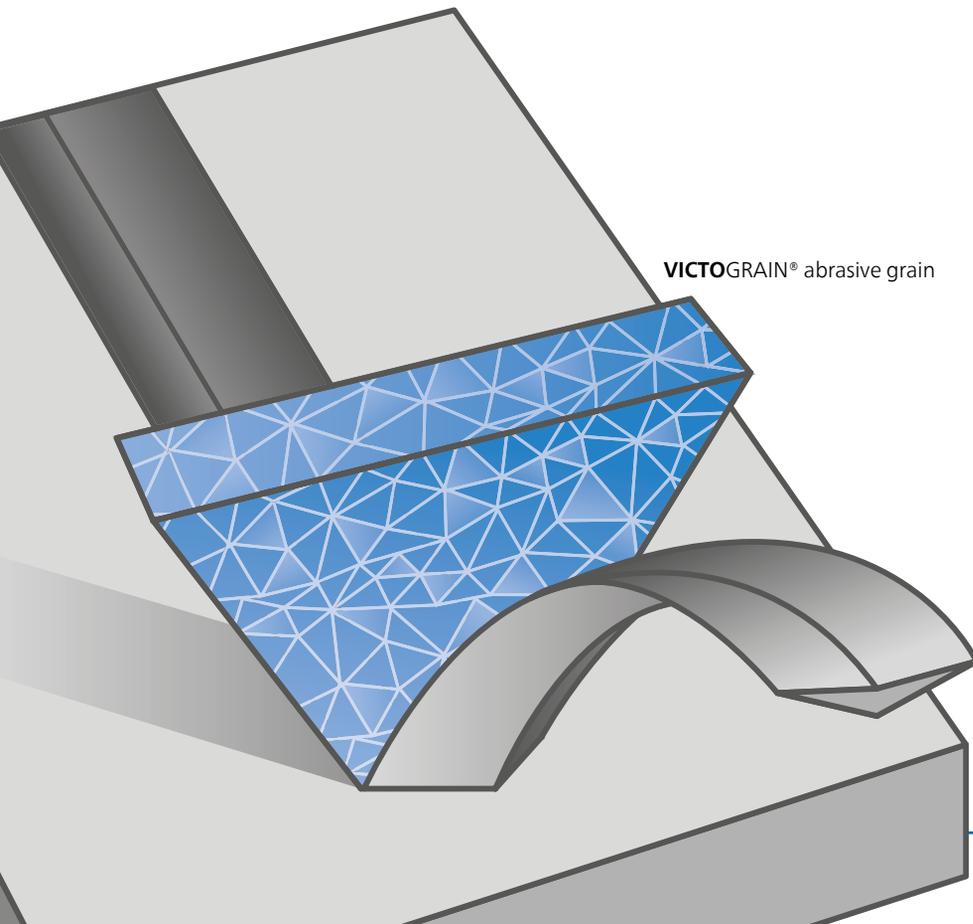


PFERDVIDEO:

Learn more about the advantages of using **VICTOGRAIN®** products.



Conventional abrasive grain



VICTOGRAIN® abrasive grain

Applications:

- Levelling
- Deburring
- Surface work
- Work on edges
- Work on weld seams

Compatible power tools:

- Angle grinders
- Cordless angle grinders
- Flexible shaft drives



For more detailed information about the **VICTOGRAIN®** products range, please refer to our brochure "**VICTOGRAIN®** – No surface is safe" at www.pferd.com.

COMBIDISC® quick-change discs

Abrasive discs

VICTOGRAIN®-COOL mini fibre discs

Well-suited for surface and edge grinding. The fibre backing considerably strengthens the abrasive disc and improves stock removal.

For maximum removal rates with an extremely long service life on steels and materials which are hard or have poor heat-conducting properties.

Outstanding, consistent high performance due to the VICTOGRAIN® abrasive grain.

Active grinding additives in the coating substantially improve the stock removal rate, prevent loading and result in cooler grinding.

Abrasive:
VICTOGRAIN®-COOL

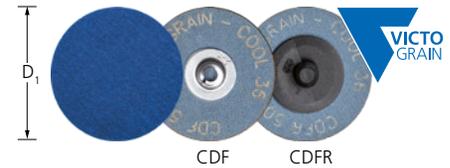
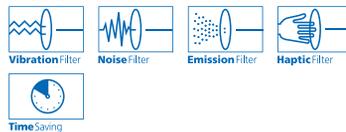
Recommendations for use:

- Use COMBIDISC® grinding products with arbors or abrasive disc holders on flexible shaft drives with angle handpieces, compressed-air or electric angle grinders.

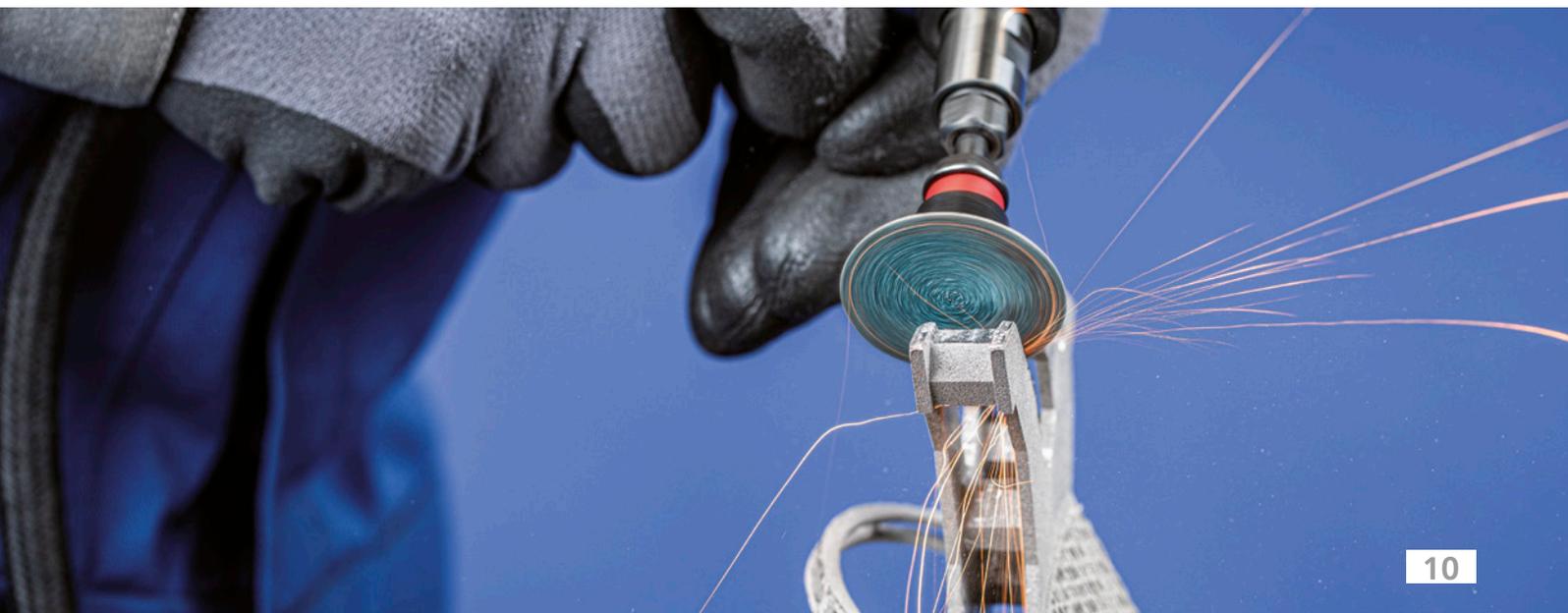
Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE:



| | D ₁ [mm] | Grit and EDP number 36 | Opt. RPM |  |
|---|------------------------|---------------------------|--------------|---|
| CD system  | 2 | 42433 | 3,800–13,000 | 100 |
| | 3 | 42434 | 2,500–9,000 | 50 |
| CDR system  | 2 | 42441 | 3,800–13,000 | 100 |
| | 3 | 42442 | 2,500–9,000 | 50 |



COMBIDISC® quick-change discs

Abrasive discs

Silicon carbide SiC

For universal grinding work on components made from aluminum, copper, bronze, titanium and fibre-reinforced plastics.

Recommended for use on titanium alloys.

Ideally suited to use in the aeronautical industry, especially where SiC is the only approved abrasive, e.g. for use on engine components.

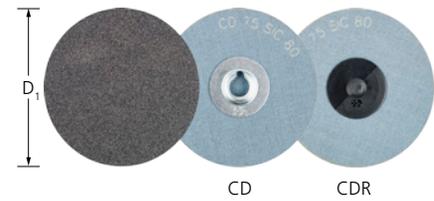
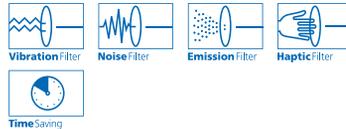
Abrasive:

Silicon carbide SiC

Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



| | D ₁ [Inches] | Grit and EDP number | | | | | Opt. RPM |  |
|---|----------------------------|---------------------|-------|-------|-------|-------|--------------|---|
| | | 36 | 60 | 80 | 120 | 240 | | |
| CD system  | | | | | | | | |
| | 2 | 42415 | 42416 | 42417 | 42418 | 42419 | 3,800–13,000 | 100 |
| | 3 | 42420 | 42421 | 42422 | 42423 | 42424 | 2,500–9,000 | 50 |
| CDR system  | | | | | | | | |
| | 2 | 42750 | 42751 | 42752 | 42753 | 42754 | 3,800–13,000 | 100 |
| | 3 | 42755 | 42756 | 42757 | 42758 | 42759 | 2,500–9,000 | 50 |

Diamond

Highly recommended for work on wear-resistant coatings and for hard facings made of tungsten carbide, chromium carbide, titanium carbide, etc. Recommended for work on materials used for aircraft engine construction, e.g. HASTELLOY®, INCONEL® and titanium/titanium alloys. Also highly recommended for work on extremely hard materials such as tungsten carbide, glass, ceramics, enamel, stone and carbon-reinforced plastic (CRP)/glass reinforced plastic (GRP).

Abrasive:

Diamond (D)

D 251 = P 60

D 126 = P 120

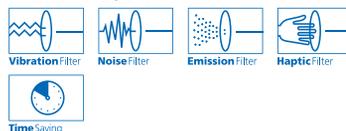
D 76 = P 220

(P = Grit size according to ISO 6344)

Ordering notes:

- Grit sizes are indicated in µm.
- Please order backing pad separately. See page 17.

PFERDVALUE®:



Recommendations for use:

- For the best results, use at a recommended peripheral speed of 2,000–4,000 SFPM.
- Use with hard or medium-hard COMBIDISC® abrasive disc holders.

| | D ₁ [Inches] | Grit and EDP number | | | Opt. RPM |  |
|---|----------------------------|---------------------|---------------|--------------|--------------|---|
| | | D 251 / P 60 | D 126 / P 120 | D 76 / P 220 | | |
| CD system  | | | | | | |
| | 1 | 40515 | 40516 | 40517 | 7,500–15,000 | 10 |
| | 1-1/2 | 40518 | 40519 | 40520 | 5,000–10,000 | 10 |
| | 2 | 40521 | 40522 | 40523 | 3,800–7,500 | 10 |
| | 3 | 40524 | 40525 | 40526 | 2,500–5,000 | 10 |
| CDR system  | | | | | | |
| | 1 | 40655 | 40656 | 40657 | 7,500–15,000 | 10 |
| | 1-1/2 | 40658 | 40659 | 40660 | 5,000–10,000 | 10 |
| | 2 | 40661 | 40662 | 40663 | 3,800–7,500 | 10 |
| | 3 | 40664 | 40665 | 40666 | 2,500–5,000 | 10 |

COMBIDISC® quick-change discs

Abrasive discs – RS type

RS type

RS type COMBIDISC® abrasive discs are outstandingly well suited for weld dressing of backwards repair welds, e.g. in cases, slots and grooves on engines and for processing welded-on combustor plates. Unlike on conventional abrasive discs, the abrasive coating is on the underside of the product, which allows backwards working.

Advantages:

- Ideal for use in extremely difficult to reach locations.
- Convenient and safe backward working.

Recommendations for use:

- Move the product to the location to be worked. To grind, do not push it onto the surface, pull it towards yourself.
- To ensure optimum utilization of the grinding surface using the abrasive disc holder EDP 42454.
- Always use the RS abrasive discs at the specified optimum rotational speed and do not adhere to the maximum permitted rotational speeds of the holder EDP 42454.



RS aluminium oxide A-PLUS

For universal applications from coarse to fine grinding, with a high stock removal rate and long service life.

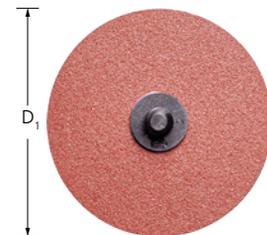
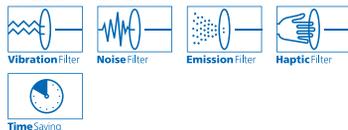
Abrasive:

Aluminium oxide A-PLUS

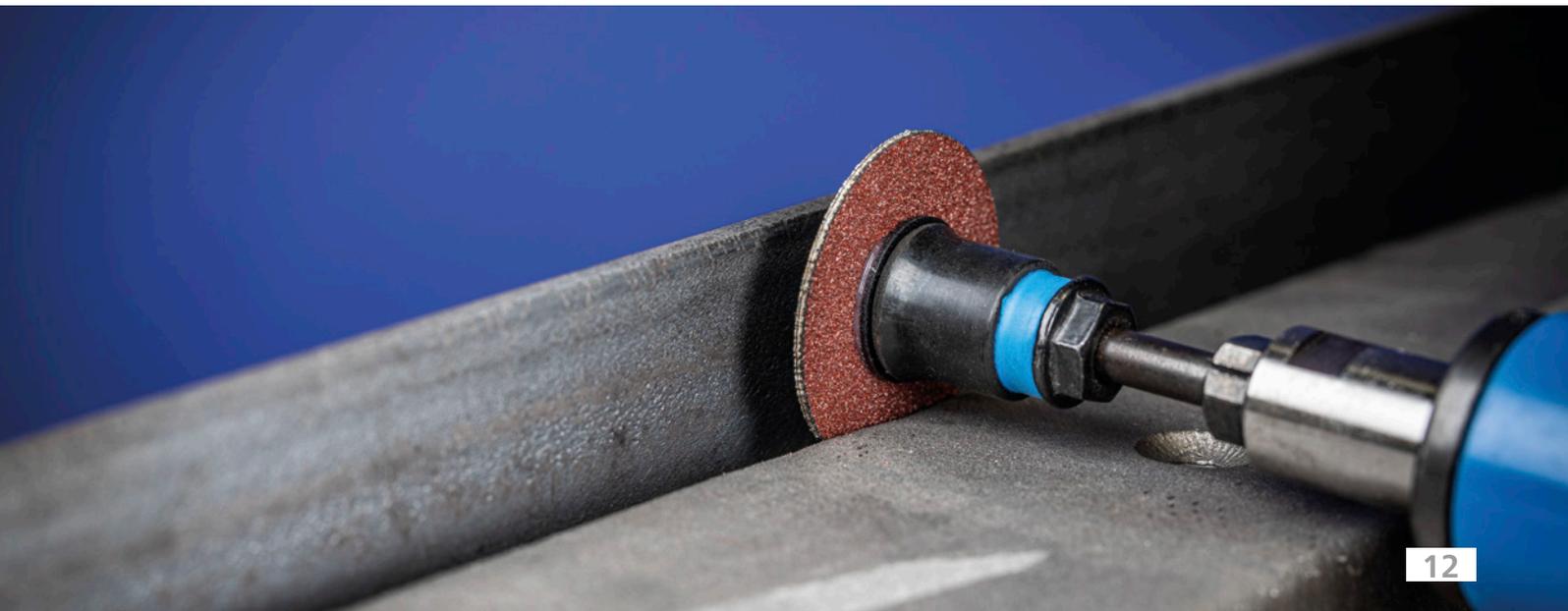
Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



| | D ₁ [Inches] | Grit and EDP number | | | Opt. RPM |  |
|-------------------|---|---------------------|---------|----------|---------------|---|
| | | 60 PLUS | 80 PLUS | 120 PLUS | | |
| CDR system |  | | | | | |
| | 1-1/2 | 40600 | 40601 | 40602 | 10,000–16,000 | 100 |
| | 2 | 40603 | 40604 | 40605 | 8,000–13,000 | 100 |
| | 3 | 40606 | 40607 | 40608 | 5,000–9,000 | 50 |



COMBIDISC® quick-change discs

Abrasive discs – RS type

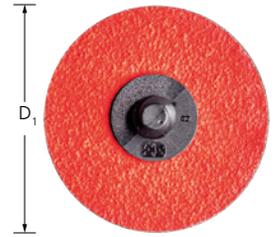
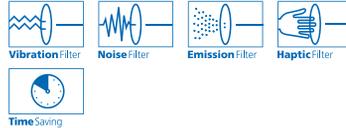
Midget fibre discs RS ceramic oxide grain CO-COOL

For aggressive grinding with maximum stock removal rate on hard materials which do not conduct heat well. Consistently high performance due to self-sharpening ceramic oxide grain.

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

Abrasive:
Ceramic oxide grain CO-COOL

PFERDVALUE®:



Ordering notes:

- Please order backing pad separately. See page 17.

| D ₁ [Inches] | Grit and EDP number | | | Opt. RPM |  |
|---|---------------------|-------|-------|---------------|---|
| | 50 | 80 | 120 | | |
| CDR system  | | | | | |
| 1-1/2 | 40570 | 40571 | 40572 | 10,000–16,000 | 100 |
| 2 | 40573 | 40574 | 40575 | 3,800–13,000 | 100 |
| 3 | 40576 | 40577 | 40578 | 2,500–9,000 | 50 |

RS silicon carbide SiC

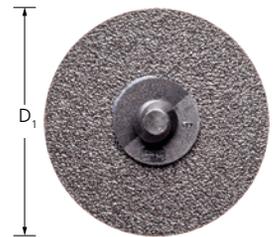
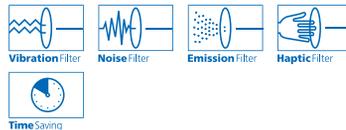
For universal grinding work on components made from aluminium, copper, bronze, titanium and fibre-reinforced plastics.

Particularly recommended for use on titanium alloys.

Ideally suited to use in the aeronautical industry, especially where SiC is the only approved abrasive, e.g. for use on engine components.

Abrasive:
Silicon carbide SiC

PFERDVALUE®:



Ordering notes:

- Please order backing pad separately. See page 17.

| D ₁ [Inches] | Grit and EDP number | | | Opt. RPM |  |
|---|---------------------|-------|-------|---------------|---|
| | 60 | 80 | 120 | | |
| CDR system  | | | | | |
| 1-1/2 | 40585 | 40586 | 40587 | 10,000–16,000 | 100 |
| 2 | 40588 | 40589 | 40590 | 3,800–13,000 | 100 |
| 3 | 40591 | 40592 | 40593 | 2,500–9,000 | 50 |



COMBIDISC® quick-change discs

Non-woven discs

POLICLEAN® PLUS discs

For coarse cleaning work such as removing paint, scale, heat discolouration, rust and adhesive residues in face-down grinding.

POLICLEAN® PLUS discs exhibit a higher stock removal rate with a very long service life.

Applications:

roughing, surface work, cleaning

Abrasive:

Aluminum oxide A

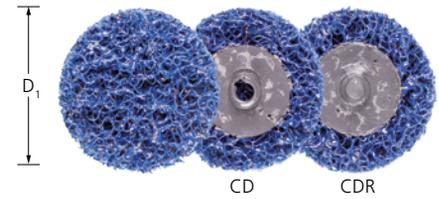
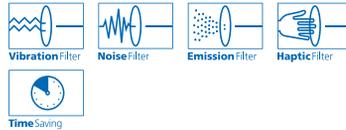
Recommendations for use:

- Use with hard or medium-hard COMBIDISC® abrasive disc holders.

Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



| | D ₁ [Inches] | EDP number | Opt. RPM |  |
|---|----------------------------|---------------|-------------|---|
| CD system  | | | | |
| | 2 | 44840 | 5,500–8,000 | 10 |
| | 3 | 44841 | 3,800–5,000 | 10 |
| CDR system  | | | | |
| | 2 | 44842 | 5,500–8,000 | 10 |
| | 3 | 44843 | 3,800–5,000 | 10 |

Surface conditioning, hard type

Recommended for universal work on small and medium-sized metal surfaces, e.g. removing rough grinding traces, removing oxidation and light deburring work. Achieve matte and satin-finished surfaces.

Applications:

roughing, deburring, surface work, cleaning, weld dressing, structuring, fine grinding in multiple steps

Abrasive:

Aluminum oxide A

Available POLIVLIES® grit sizes:

- 100 C = coarse (yellow-brown)
- 180 M = medium (red-brown)
- 240 F = fine (blue)

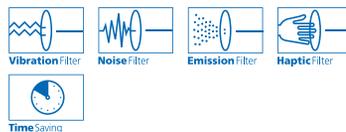
Recommendations for use:

- The addition of oil or water during grinding results in a finer finish, cooler grinding and longer service life.

Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



| | D ₁ [Inches] | Grit, type and EDP number | | | Opt. RPM |  |
|---|----------------------------|---------------------------|-------|-------|--------------|---|
| | | 100 C | 180 M | 240 F | | |
| CD system  | | | | | | |
| | 1-1/2 | 43176 | 43177 | 43179 | 7,000–10,000 | 50 |
| | 2 | 43180 | 43181 | 43183 | 5,500–7,500 | 50 |
| | 3 | 43184 | 43185 | 43187 | 3,800–5,000 | 25 |
| CDR system  | | | | | | |
| | 1-1/2 | 43234 | 43235 | 43237 | 7,000–10,000 | 50 |
| | 2 | 43238 | 43239 | 43241 | 5,500–7,500 | 50 |
| | 3 | 43242 | 43243 | 43245 | 3,800–5,000 | 25 |
| | 4 | 43246 | 43247 | 43248 | 2,850–4,000 | 25 |

COMBIDISC® quick-change discs

Non-woven discs

Finishing, soft type

Recommended for very fine grinding on small and medium-sized surfaces and contours, and for cleaning metal and painted surfaces. Achieve matte and satin-finished surfaces. Highly open structure.

Applications:

roughing, deburring, surface work, cleaning, weld dressing, structuring, fine grinding in multiple steps

Abrasive:

Aluminum oxide A
Available POLINOX® grit sizes:
100 = medium
180 = fine
280 = very fine

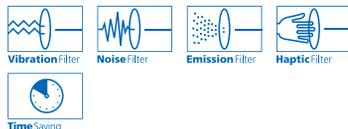
Recommendations for use:

- The addition of oil or water during grinding results in a finer finish, cooler grinding and longer service life.

Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



| D ₁ [Inches] | Grit and EDP number | | | Opt. RPM |  |
|--|---------------------|-------|-------|-------------|---|
| | 100 | 180 | 280 | | |
| CD system  | | | | | |
| 2 | 43200 | 43201 | 43203 | 5,500–7,500 | 50 |
| 3 | 43204 | 43205 | 43207 | 3,800–5,000 | 25 |
| CDR system  | | | | | |
| 2 | 43258 | 43259 | 43261 | 5,500–7,500 | 50 |
| 3 | 43262 | 43263 | 43265 | 3,800–5,000 | 25 |



COMBIDISC® quick-change discs

Non-woven discs

Unitized discs

For achieving a very fine, uniform surface finish which, depending on requirements, is a sufficient preparation for high-gloss polishing. Ideal for work on small and medium-sized surfaces of stainless steel (INOX) components.

The different thicknesses/hardnesses of the non-woven material are colour-coded:

- W (soft) = grey
- MH (medium-hard) = dark blue
- H (hard) = red

Applications:

roughing, deburring, surface work, cleaning, weld dressing, structuring, fine grinding in multiple steps

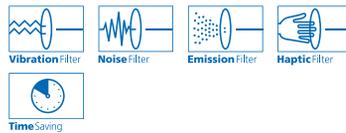
Abrasive:

Aluminum oxide A
Silicon carbide SiC

Ordering notes:

- Further information on unitized products can be found in our Tool Manual 23, catalog section 4, on page 85–86.
- Please order backing pad separately. See page 17.
- All discs have a thickness of 1/4".

PFERDVALUE®:



| D [Inches] | Abrasives | Grit size | Hardness | Spec | EDP number | Opt. RPM | Max. RPM |  |
|---|-----------|-----------|----------|------|------------|----------|----------|---|
| CD system  | | | | | | | | |
| 2 | SiC | fine | W | 2SF | 48430 | 9,500 | 19,100 | 25 |
| | A | coarse | W | 2AM | 48431 | 9,500 | 19,100 | 25 |
| | SiC | fine | MH | 6SF | 48434 | 9,500 | 19,100 | 25 |
| | A | fine | MH | 6AF | 48435 | 9,500 | 19,100 | 25 |
| | A | fine | H | 8AM | 48438 | 9,500 | 19,100 | 25 |
| | A | coarse | H | 8AC | 48439 | 9,500 | 19,100 | 25 |
| 3 | SiC | fine | W | 2SF | 48440 | 6,400 | 12,500 | 25 |
| | A | coarse | W | 2AM | 48441 | 6,400 | 12,500 | 25 |
| | SiC | fine | MH | 6SF | 48444 | 6,400 | 12,500 | 25 |
| | A | fine | MH | 6AF | 48445 | 6,400 | 12,500 | 25 |
| | A | fine | H | 8AM | 48448 | 6,400 | 12,500 | 25 |
| | A | coarse | H | 8AC | 48449 | 6,400 | 12,500 | 25 |
| CDR system  | | | | | | | | |
| 2 | SiC | fine | W | 2SF | 48450 | 9,500 | 19,100 | 25 |
| | A | coarse | W | 2AM | 48451 | 9,500 | 19,100 | 25 |
| | SiC | fine | MH | 6SF | 48454 | 9,500 | 19,100 | 25 |
| | A | fine | MH | 6AF | 48455 | 9,500 | 19,100 | 25 |
| | A | fine | H | 8AM | 48458 | 9,500 | 19,100 | 25 |
| | A | coarse | H | 8AC | 48459 | 9,500 | 19,100 | 25 |
| 3 | SiC | fine | W | 2SF | 48460 | 6,400 | 12,500 | 25 |
| | A | coarse | W | 2AM | 48461 | 6,400 | 12,500 | 25 |
| | SiC | fine | MH | 6SF | 48464 | 6,400 | 12,500 | 25 |
| | A | fine | MH | 6AF | 48465 | 6,400 | 12,500 | 25 |
| | A | fine | H | 8AM | 48468 | 6,400 | 12,500 | 25 |
| | A | coarse | H | 8AC | 48469 | 6,400 | 12,500 | 25 |

COMBIDISC® quick-change discs

Felt discs

Felt discs

Recommended for polishing with polishing paste bars, grinding pastes or diamond polishing pastes in face-down grinding on small and medium-sized surfaces.

Applications:
polishing

Recommendations for use:

- For the best results, use at a recommended speed of 1,000–2,000 SFPM. This provides an ideal compromise between polishing performance, thermal load on the work-piece and disc wear.
- When applying a different polishing paste, use a new, unused felt disc.

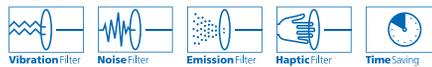
Ordering notes:

- Further information on felt products can be found in our Tool Manual 23, catalog section 4, on page 115.
- Please order backing pad and polishing paste separately. See page 17 and in our Tool Manual 23, catalog 4, page 121.

Accessories:

- Grinding and polishing pastes

PFERDVALUE®:



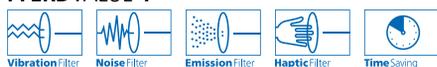
| | D ₁ [Inches] | EDP number | Opt. RPM | |
|-------------------|----------------------------|---------------|-------------|----|
| CD system | | | | |
| | 2 | 43215 | 2,000–4,000 | 10 |
| | 3 | 43216 | 1,200–2,500 | 10 |
| CDR system | | | | |
| | 2 | 43213 | 2,000–4,000 | 10 |
| | 3 | 43214 | 1,200–2,500 | 10 |

Backing pads

Backing pads

Matching backing pads for COMBIDISC® quick-change discs. Available in three different hardness grades.

PFERDVALUE®:



| D [Inches] | S [Inches] | EDP number | | Max. RPM | |
|---------------|---------------|-------------|--------------|-------------|---|
| | | Type CD | Type CDR | | |
| Soft | | | | | |
| 1-1/2 | 1/4 | 42108 | 42456 | 20,000 | 1 |
| 2 | 1/4 | 42111 | 42459 | 20,000 | 1 |
| 3 | 1/4 | 42114 | 42462 | 12,000 | 1 |
| Medium | | | | | |
| 1 | 1/4 | 42106 | 42454 | 40,000 | 1 |
| 1-1/2 | 1/4 | 42109 | 42457 | 25,000 | 1 |
| 2 | 1/4 | 42112 | 42460 | 25,000 | 1 |
| 3 | 1/4 | 42115 | 42463 | 20,000 | 1 |
| 4 | 1/4 | - | 42465 | 10,000 | 1 |
| Hard | | | | | |
| 1-1/2 | 1/4 | 42110 | 42458 | 30,000 | 1 |
| 2 | 1/4 | 42113 | 42461 | 30,000 | 1 |
| 3 | 1/4 | 42116 | 42464 | 20,000 | 1 |

COMBIDISC® quick-change discs

Sets

Advantages:

- Getting to know and testing the comprehensive system.

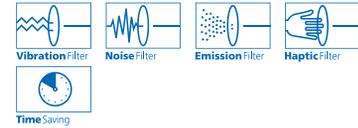
Abrasive:

- Aluminum oxide A
- Silicon carbide SiC

Recommendations for use:

- Use COMBIDISC® grinding discs with an arbor or abrasive disc holder on flexible shaft drives with an angle handpiece or small compressed-air or electric angle grinders.

PFERDVALUE®:



COMBIDISC® prep-to-paint set

Prep-to-paint set includes a selection of coated and non-woven abrasives for removal of surface imperfections such as rust, loose paint or cold drawn mill scale. Selected discs leave the proper surface finish for excellent wet and dry paint and coating adhesion.

Contents of 2" CDR prep-to-paint set

- | | |
|---|--|
| 1 pc. each of: | 4 pcs. of: |
| ■ EDP 42460 – 2" CDR backing pad – medium | ■ EDP 42506 – 2" CDR abrasive discs A/O 80 grit |
| ■ EDP 42913 – 2" CDR Mini-POLIFAN® disc A/O 60 grit | ■ EDP 43239 – 2" CDR surface conditioning discs medium |
| ■ EDP 44842 – 2" CDR POLICLEAN® PLUS disc | |



| Type | Full set EDP number |  |
|----------------------------------|---------------------|---|
| Prep-to-paint, 2" CDR attachment | 42789 | 1 |

COMBIDISC® sanitary finish set

Sanitary finish set includes a selection of coated and non-woven abrasives designed to achieve the industry standard for a sanitary finish.

Contents of 2" CDR sanitary finish set

- | | |
|---|--|
| 1 pc. each of: | 6 pcs. of: |
| ■ EDP 42460 – 2" CDR backing pad – medium | ■ EDP 42506 – 2" CDR abrasive discs A/O 80 grit |
| ■ EDP 42913 – 2" CDR Mini-POLIFAN® disc A/O 60 grit | ■ EDP 43239 – 2" CDR surface conditioning discs medium |



| Type | Full set EDP number |  |
|------------------------------------|---------------------|---|
| Sanitary finish, 2" CDR attachment | 42790 | 1 |

COMBIDISC® mirror finish set

Mirror finishing set includes the required components to proceed from raw material removal to a full reflective surface.

Contents of 2" CDR mirror finishing set

- | | |
|---|---|
| 1 pc. each of: | 2 pcs. of: |
| ■ EDP 42460 – 2" CDR backing pad – medium | ■ EDP 48454 – 2" CDR unitized disc medium hard SiC fine |
| ■ EDP 42913 – 2" CDR Mini-POLIFAN® disc A/O 60 grit | |
| ■ EDP 43213 – 2" CDR felt disc | 3 pcs. of: |
| ■ EDP 48765 – Small bar pre-polishing paste (green) | ■ EDP 43239 – 2" CDR surface conditioning discs medium |



| Type | Full set EDP number |  |
|----------------------------------|---------------------|---|
| Mirror finish, 2" CDR attachment | 42791 | 1 |