BEAR-TEX HAND PADS

Bear-Tex Surface Finishing products are made of a non-woven nylon web impregnated with abrasive grain and resin. A variety of abrasives, grit sizes and backing materials give the user an extensive and superior product offering.

Typical Applications

- Light to heavy duty cleaning
- Deburring
- Blending
- Polishing
- Finishing

Bear-Tex Hand Pads

BEST General Purpose Hand Pads

FEATURES	*BENEFITS*
• General Purpose pads with finer grit size and improved grain adhesion	• Double the cut rate; no color bleeding when working with solvents
• 847 General Purpose pad with perforations	• Perforations allow for a smooth, shred-free split to create two smaller, easy-to-use 4-1/2" x 6" pads

GOOD Bear-Tex Hand Pads

FEATURES	*BENEFITS*
• Flexible	• Conform to work surface
• Gentle action	• Easily removes flashing or burrs without affecting dimension of workpiece
• Non-loading	• Constant supply of new cutting edges
• Non-rusting	• No workpiece contamination
• Resilient construction	• Long life, increased productivity; solvent resistant; waterproof
• Easily cut to desired size	• Reduces waste
• 696 Food Pro pad	• No color transfer, meets FDA/USDA/Canadian food industry standards
new! • 914 Gold Clear Blend Prep pad is loftier and softer than competitors'	• Conforms to contours better • Produces finest finishes; scratch pattern equal to 1,200 grit and finer
• 748 Final Shine pad **improved!** • Softer acting, more flexible, uniform abrasive dispersion	• More conformable to contours; produces finer finishes • Less aggressive; for defuzzing wood, light deburring, final rubbing • Consistent polishing action

						BEST		GOOD	
SIZE W X L	*COLOR*	*NAME*	*ABRASIVE*	*GRIT SIZE*	*STD. PKG.*	*PRODUCT NO.*	*UPC NO.*	*PRODUCT NO.*	*UPC NO.*
6 x 9	White	Light Duty Cleaning Pad	Non-Abrasive		60			456	66261045600
6 x 9	Gray	Clean & Finish Pad	Silicon Carbide	UF	60			635	66261063500
6 x 9	Lt. Green	Food Pro Pad	Aluminum Oxide	VF	2880			696	66261069600
6 x 9	Dark Tan	Heavy-Duty Pad	Aluminum Oxide	Med	40			740	66261074000
6 x 9	Gray	Metal Blend Pad	Silicon Carbide	Med	40			746	66261074600
6 x 9	Maroon	General Purpose Pad	Aluminum Oxide	VF	60	747	66261074700		
6 x 9	Gray	Final Shine Pad	Silicon Carbide	MF	60			748	66261074800
6 x 9	Maroon	Long Life Pad	Aluminum Oxide	VF	60			777	66261077700
6 x 9	Green	Scouring Pad	Aluminum Oxide	VF	60			796	66261079600
6 x 9	Maroon	General Purpose Perforated Pad	Aluminum Oxide	VF	60	847	66261084700		
6 x 9	Gray	General Purpose Pad	Silicon Carbide	VF	40			851	66261085100
6 x 9 new!	Gold	Clear Blend Prep Pad	Aluminum Oxide	MF	20			914	66261195914*
3-1/4 x 5-1/2		Hand Pad Holder			10				66261047583

* NON-STOCK; 2-WEEK LEADTIME

Bear-Tex Hand Pads

SPEC check

Hand Pad Starting Recommendations by Application

MORE AGGRESSIVE, ROUGHER FINISH ⟷ LESS AGGRESSIVE, FINER FINISH

#740 (DARK TAN) HEAVY DUTY PAD	#746 (GRAY) METAL BLEND PAD	#777 (MAROON) LONG LIFE PAD	#747/847 (MAROON) GENERAL PURPOSE PADS	#796 (GREEN) SCOURING PAD	#696 (LT. GREEN) FOOD PRO PAD	#851 (GRAY) GENERAL PURPOSE PAD	#635 (GRAY) CLEAN & FINISH PAD	#748 (GRAY) FINAL SHINE PAD	#914 (GOLD) CLEAR BLEND PREP PAD	#456 (WHITE) LIGHT DUTY CLEANING PAD
• Removing rust and oxidation • Deburring • Blending • Replaces steel wool and wire brushes in many applications	• Cleaning - aluminum - around welds - glass molds - dies • Light deburring of intricate parts	Fast initial cut rate • Cleaning • Deburring • Corrosion, oxidation and scale removal	• Cleaning and finishing machinery and tools • Cleaning solid surfaces (granite, marble, etc.) • Rust removal • Defuzzing wood • Denibbing plastic component parts • Finer than #851 • #847 is perforated	• Removing - stains - marks - rust - corrosion - oxidation • Applying finishes on non-ferrous metals	• General purpose cleaning in food processing plants • Sanitary prep of work surfaces • Light cleaning of metal surfaces • Removal of light surface stains, etc.	• Removing rust and oxidation • Blending around welds • Cleaning glass molds • Satin finishing aluminum parts	• Deburring plastic surfaces • Cleaning fiberglass partitions • Blending paint • Scuffing acrylic surfaces • Finishing aluminum doors and windows	• Light cleaning - steel - non-steel • Defuzzing wood • Final rub • Light deburring - rubber - plastics - composites - metal	• Scuffing prior to clear coat blending • Sanding base coats without removing the coat • Light cleaning • Polishing, blemish repair and finishing: - composites - marine - steel - non-steel - wood	Non-abrasive • Cleaning glass, fiberglass and porcelain fixtures • Scratch-free cleaning of stainless steel, chrome, copper and ceramic • Wood highlighting and rubbing between finish coats • Use with liquid detergents

Bear-Tex Sponge Pads

Bear-Tex material is laminated to a top quality, long-lasting sponge for the convenience of 2 pads in one.

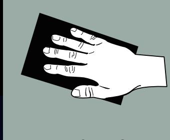
						GOOD	
SIZE W X L X T	*COLOR*	*NAME*	*ABRASIVE*	*GRIT SIZE*	*STD. PKG.*	*PRODUCT NO.*	*UPC NO.*
3-1/4 x 6-1/4 x 3/4	White/Yellow	Clean-N-Sponge Pad	Non-Abrasive	Non-Abrasive	40	875	66261059402
3-1/4 x 6-1/4 x 3/4	Green/Yellow	Scour-N-Sponge Pad	Aluminum Oxide	Very Fine	40	893	66261059403

TECHtip

Bear-Tex products are non-metallic, won't rust and are an ideal replacement for steel wool.

It is the user's responsibility to comply with safety regulations.

NORTON


HAND SANDING


JITTERBUG SANDER

Bear-Tex Rolls

Rolls may be cut for use in jitterbug sanding or on hand sanding applications. Rolls have the durability for indexing machine applications.

Typical Applications

- Light deburring
- Cleaning
- Finishing
- Applying decorative finishes

BEST Bear-Tex High Strength Rolls – For light deburring and finishing

FEATURES	*BENEFITS*
• Premium aluminum oxide grain	• Clean cutting and long lasting
• Firm, durable web; strong resin binders	• High resistance to tearing on burrs and sharp edges
• Smear-proof	• Produces light satin finishes

BETTER Bear-Tex Fast Cut Rolls – Fast initial cut, flexible

FEATURES	*BENEFITS*
• Premium aluminum oxide grain	• Clean cutting and long lasting
• Fast initial cut	• Less pressure needed
• Conformable	• Able to get into intricate shapes and follow contours, user-friendly
• Strong base adhesion	• Improved cut rate

BETTER Bear-Tex Clean & Blend Rolls – For general purpose use

FEATURES	*BENEFITS*
• High quality, aluminum oxide or silicon carbide grain	• Long product life
• Uniform web construction	• Controlled aggressiveness
• Can be cut to exact sizes needed	• Economical; minimal waste

						BEST	BETTER
SIZE (W X L)	*COLOR*	*NAME*	*ABRASIVE*	*GRIT*	*STD. PKG.*	*UPC NO.*	*UPC NO.*
4" x 30 Ft.	Maroon	High Strength	A/O	Medium	3	66261006358	
	Dark Tan	Fast Cut	A/O	Medium	3		66261010081
	Maroon	Clean & Blend	A/O	Fine	4		66261058364
	Maroon	Clean & Blend	A/O	Very Fine	4		66261058361
	Maroon	Fast Cut GP	A/O	Very Fine	4		66261051701
	Maroon	High Strength	A/O	Very Fine	4	66261006373	
	Gray	Clean & Blend GP	S/C	Very Fine	4		66261058360
	Gray	Clean & Blend	S/C	Ultra Fine	5		66261058357
	White	T- Polishing	None	Non-Abrasive	3		66261052235
6" x 30 Ft.	Maroon	High Strength	A/O	Medium	2	66261005182	
	Maroon	Clean & Blend	A/O	Very Fine	3		66261058376
	Maroon	Fast Cut GP	A/O	Very Fine	3		66261016430
	Maroon	High Strength	A/O	Very Fine	3	66261004281	
	Gray	Clean & Blend GP	S/C	Very Fine	3		66261058377

NORTON


HAND SANDING


JITTERBUG SANDER

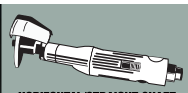
Bear-Tex Roll Assortment

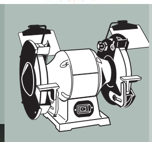
Bear-Tex rolls may be cut for use in jitterbug sanding or on hand sanding applications. This convenient dispenser box contains three 2 inch wide x 15 foot long rolls. Each roll is a different grit.

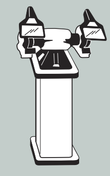
SIZE W X L	ABRASIVE	GRIT	STD. PKG.	BETTER UPC NO.
Three Rolls 2" x 15 ft. (One of Each Specification)	Aluminum Oxide Aluminum Oxide Silicon Carbide	Fine Very Fine Micro Fine	1	66261008108

Bear-Tex High Strength and FastCut Discs

Made of non-woven nylon web impregnated with abrasive grain and resin for use in a variety of deburring and finishing applications.


HORIZONTAL/STRAIGHT SHAFT GRINDER


BENCH GRINDER


PEDESTAL GRINDER

Typical Applications

- Rust/oxide or coating removal
- Pipe ID and OD polishing
- Casting cleaning
- Highlighting (antiquing)
- Contaminant removal
- Removal of handling marks
- Gasket removal
- Cleaning and blending of surface imperfections
- Prepping prior to soldering
- Removal of filling materials
- Cleaning angles and odd shapes

BEST	Bear-Tex High Strength and FastCut Discs – For light deburring and finishing
FEATURES	**BENEFITS**
• Premium aluminum oxide grain	• Clean cutting and long lasting
• Firm, durable web	• High resistance to tearing on burrs and sharp edges
• Tough, yet conformable	• Can be “ganged” together and used as a wheel
• Strong resin binders	• Highly smear-resistant
• Smear-proof	• Produces light satin finishes
• 2" and 3" with Speed-Lok TR fastener	• Quick, tool-free disc changes allow for more grinding time
• FastCut discs	• Fast initial cut; more flexible than High Strength discs

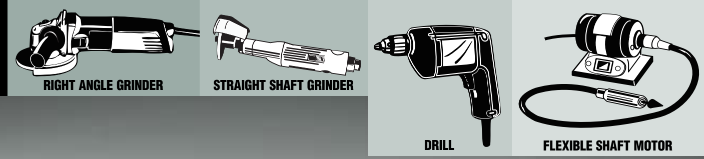
SIZE D X H	ABRASIVE	MAX. RPM	STD. PKG.	BEST UPC NO.
BEAR-TEX HIGH STRENGTH AND FASTCUT DISCS				
2" Speed-Lok TR	A/O Medium High Strength	12,000	160	66261014792
3" Speed-Lok TR	A/O Medium High Strength	12,000	80	66261014793
6 x 1/4	A/O Very Fine High Strength	4,000	70	66261007628
6 x 1/2	A/O Medium High Strength A/O Very Fine High Strength A/O Very Fine FastCut	4,000	70	66261005073 66261004980 66261000601
8 x 1/2	A/O Medium High Strength A/O Very Fine High Strength	3,000	50	66261005491 66261004506
12 x 1-1/4	A/O Very Fine High Strength	1,900	25	66261008723

TECHtips

Use 2" back-up pad with 3" Speed-Loc TR High Strength discs to work on edge for added flexibility.

It is the user's responsibility to comply with safety regulations.

See “Mandrel Assemblies” on page 109 when using these discs on edge.



Bear-Tex Rapid Finish Depressed Center Wheels, Rapid Strip Discs and Depressed Center Wheels

A web of strong synthetic fibers and quality abrasive, bonded together by a smear-resistant adhesive for cleaning, conditioning, and finishing a multitude of materials, quickly and easily with little loading.

Typical Applications

Rapid Strip

- Removal of paint and epoxy coating, surface rust and residue, corrosion, light weld splatter, dirt, mill scale and other similar surface contaminants
- Surface prep before coatings are applied
- Surface prep before welding; cleaning and conditioning afterwards
- Applying fine finishes

Rapid Finish

- Prepping surfaces
- Removing light scale on electrical power generation components, composite and fiberglass resins, surface impurities from aluminum tubing, weld discoloration, and overspray from powercoating or painting
- Cleaning and polishing stainless steel, ferrous and nonferrous metal surfaces, injection molds, and paper mill rolls

BEST Bear-Tex Rapid Strip Discs and Depressed Center Wheels

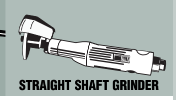
FEATURES	BENEFITS
• Open web construction	• Fast cutting action with very little loading
• Conformable	• Follow difficult part profiles • Easy cleaning of uneven surfaces
• Thick, strong, synthetic fibers and extra coarse grit	• Quick cleaning and conditioning of surfaces
• Used with portable tools	• Easy and safe to use especially in difficult to reach areas
• 2" and 3" discs with Speed-Loc TR fastener	• Quick, tool-free disc changes allow for more grinding time
• 4" TR+ discs	• Quick-change replacement; can be used on face and edge

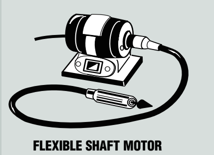
BEST Bear-Tex Rapid Finish Depressed Center Wheels

new!

FEATURES	BENEFITS
• Fine grain particle concentration cleans and polishes while imparting final finishes on a variety of materials	• Increases productivity and reduces total abrasive costs by eliminating a grinding step
• Advanced resin system	• Resists loading; smear-free, clean, fine finishes
• Low density	• Conformable and flexible
• Undersized backing	• Maximizes grinding area and usage for longer life
• NEX 2AM	• Most aggressive
• NEX 2AF	• Multi-purpose
• NEX 2SF	• Polishing
• A/O Medium High Strength	• Less aggressive, most conformable

NORTON





Bear-Tex Rapid Strip Discs

See page 113 for Speed-Lok back-up pads.

SIZE D X H	ABRASIVE	GRIT SIZE	MAX. RPM	STD. PKG.	BEST UPC NO.
2" Speed-Lok TR	Silicon Carbide	Extra Coarse	15,500	10	66261013402
3" Speed-Lok TR	Silicon Carbide	Extra Coarse	12,000	10	66261013403
4" Speed-Lok TR+	Silicon Carbide	Extra Coarse	8,000	10	66261016580
4 x 1/4	Silicon Carbide	Extra Coarse	8,000	25	66261008008
4 x 1/2	Silicon Carbide	Extra Coarse	8,000	25	66261007916
6 x 1/2	Silicon Carbide	Extra Coarse	5,500	15	66261008051

Mandrel Assemblies for Rapid Strip Discs and Discs-On-Edge

FITS HOLE	FOR DISC WIDTH	FOR DISC DIAMETER	SHANK DIAMETER	OVERALL LENGTH	WASHER DIAMETER	STD. PKG.	UPC NO.
1/4"	1/2” (Standard)	up to 6"	1/4"	2-1/2"	1-1/2"	1	66261009502
1/2"	1/2” (Standard)	Up to 8"	1/4"	3-1/8"	2-1/4"	1	66261059420

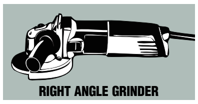
Bear-Tex Rapid Strip and Rapid Finish Depressed Center Wheels

Rapid Finish depressed center wheels will work anywhere Rapid Strip products work. Use Rapid Finish when a less aggressive product is needed.

SIZE D X H	MAX. RPM	STD. PKG.	BEST RAPID STRIP UPC NO.	BEST new! RAPID FINISH UPC NO.	
4-1/2 x 5/8-11	12,000	10	S/C ExC 66261009585	NEX-2AM NEX-2AF NEX-2SF A/O Medium High Strength	66261023947 66261023946 66261023943 66261023949
4-1/2 x 7/8	12,000	10	S/C ExC 66261009649	NEX-2AM NEX-2AF NEX-2SF A/O Medium High Strength	66261020548 66261020547 66261020546 66261020549
7 x 5/8-11	8,000	10	S/C ExC 66261009650		
7 x 7/8	8,000	10	S/C ExC 66261009586		

Bear-Tex Abrasive Brushes

Tough, flexible nylon filaments embedded with abrasive grain form the bristles of these brushes. Use Bear-Tex abrasive brushes where maximum conformability is needed.

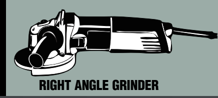


SIZE D X R X H*	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	GOOD UPC NO.
7 x 1 x 7/8	Silicon Carbide Silicon Carbide	80 120	6,000	5	66261058830 66261058834

*DIAMETER X RIM WIDTH X HOLE

Air-Cooled Rubber Back-up Pad and Retainer Nut for Abrasive Brushes

DESCRIPTION	MAX. RPM	STD. PKG.	UPC NO.
7" Firm Pad	6,000	5	63642543425
#103 Retainer Nut	—	10	63642543463



AVOS Edger Speed-Lok Bear-Tex Discs

Made of non-woven nylon web impregnated with abrasive grain and resin for use in a variety of applications. Choose one of three grit specifications to achieve the best results for your application.

Typical Applications

- Light deburring
- Cleaning and rust removal
- Finishing, polishing and paint preparation

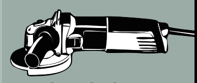
BETTER **AVOS – Allows View Of Surface – Edger Speed-Lok Bear-Tex Discs**

FEATURES	*BENEFITS*
• Patented hole design	• Allows interrupted cut which reduces heat up to 30% over standard round discs • Cool cutting results in longer disc life • Provides complete vision into the grinding zone • Operators can grind more accurately with less re-work
• Scooped holes	• Create air flow to pull loose abrasive and swarf away from work surface grinding zone – resulting in extended disc life
• 15 degree angle back-up pad	• Grinding at 5°-15° angle allows greater utilization of disc surface • Eliminates gouging of workpiece
• Coarse removes 60 – 120 grit grindlines	• For light deburring
• Medium removes 120 – 180 grit grindlines	• For cleaning and rust removal
• Very Fine removes 180 – 320 grit grindlines	• For finishing, polishing and paint preparation

SIZE	*ABRASIVE/ GRIT*	*STD. PKG.*	BETTER *UPC NO.*
AVOS EDGER SPEED-LOK BEAR-TEX DISCS			
4-1/2 Edger Speed-Lok	A/O Coarse A/O Medium A/O Very Fine	40	66261010447 66261010448 66261010449
5 Edger Speed-Lok	A/O Coarse A/O Medium A/O Very Fine	40	66261009427 66261009428 66261009429
7 Edger Speed-Lok	A/O Coarse A/O Medium A/O Very Fine	40	66261009430 66261009431 66261009432

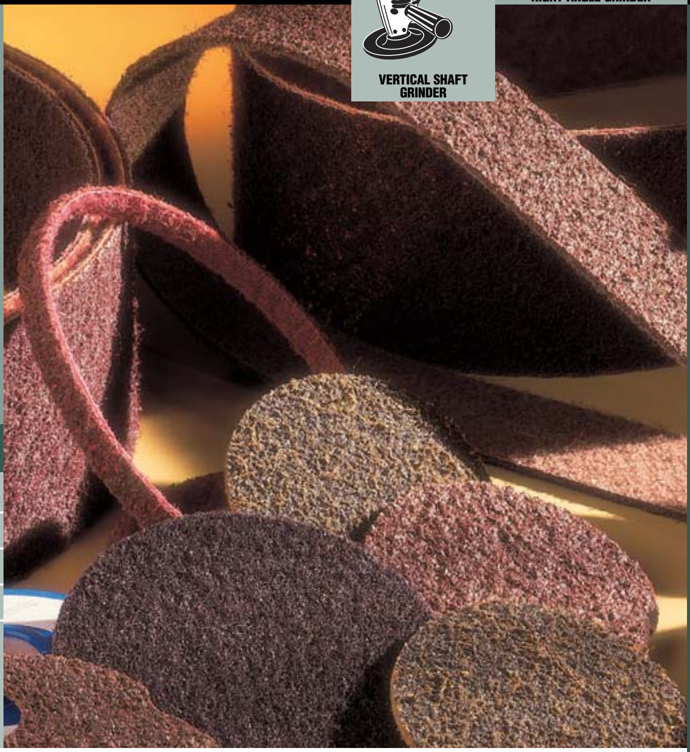
See page 54 for AVOS back-up pads.

NORTON



Bear-Tex Surface Blending STE Discs and Belts

Norton Bear-Tex surface blending material is available in all three tiers. With three different stock product lines, and grit sizes of extra coarse to very fine, STE discs and belts perform well under a wide range of applications: from removing engine gaskets, and deburring of aluminum and steel, to finishing nickel alloy turbine blades.



Typical Applications

- Removing surface defects
- Removing light edge burrs, parting lines or flashing
- Removing rust, oxides, corrosion, paints and scale
- Cleaning molds
- Blending mill marks, tool marks, uneven edges and coated abrasive finish

Bear-Tex STE Discs and Belts

FEATURES	*BENEFITS*
• Color-coded grit sizes	• Easy identification and matching of product with application and finish requirement
• Conformable	• Conform to workpiece; forgiving
• Uniform, thorough abrasive coating	• Consistent finish
• Disc configurations: Hook and Loop; TR and TS Speed-Lok	• Can be used on a wide variety of industrial and commercial tools • Speed-Lok provides quick and easy on and off
• Belt configurations: up to 37" width; Plyweld, butt joint; low stretch backing available	

BEST **Bear-Tex STE-CS Discs – Work best on harder materials**

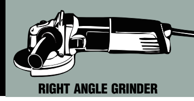
FEATURES	*BENEFITS*
• Closed structure	• Long lasting
• Very sharp abrasive grain	• High, continuous cut rate
• Rigid, low stretch backing	• Excellent performance on hard materials (steels, nickel, alloys, etc.)
• Extra Coarse and Medium stock grit sizes	• Two degrees of aggressiveness and surface finishing

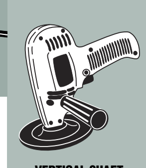
BETTER **Bear-Tex STE-VS Discs and Belts – Great multi-purpose product**

FEATURES	*BENEFITS*
• Slightly open structure	• Resists loading and chunking
• High abrasive content	• Continuous cut rate on soft (e.g. aluminum) and hard materials (e.g. steels and nickel alloys)
• Firm backing	• Low stretch
• Coarse, Medium and Very Fine stock grit sizes	• Three degrees of aggressiveness and surface finishing

GOOD **Bear-Tex STE Discs and Belts – Ideal for soft materials and low force applications**

FEATURES	*BENEFITS*
• Open structure	• Resists loading on softer materials (aluminum, gaskets, etc.)
• High abrasive content	• Fast initial cut rate
• Flexible backing	• Conformable
• Coarse, Medium and Very Fine stock grit sizes	• Three degrees of aggressiveness and surface finishing





Bear-Tex Surface Blending STE Discs

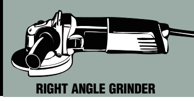
SIZE	ABRASIVE	GRIT SIZE	STD. PKG.	BETTER STE-VS UPC NO.	GOOD STE UPC NO.
WITH HOOK AND LOOP FASTENING SYSTEM					
2" Blank	A/O	Coarse	80	66261004431	
	A/O	Medium		66261004441	
	A/O	Very Fine		66261004451	
3" Blank	A/O	Coarse	60	66261004432	
	A/O	Medium		66261004442	
	A/O	Very Fine		66261004452	
4" Blank	A/O	Coarse	40	66261004433	66261055018
	A/O	Medium		66261004443	66261055019
	A/O	Very Fine		66261004453	
4-1/2" Blank	A/O	Coarse	40	66261004434	66261017806
	A/O	Medium		66261004444	66261017807
	A/O	Very Fine		66261004454	
5" Blank	A/O	Coarse	40	66261004435	66261055021
	A/O	Medium		66261004445	66261055022
	A/O	Very Fine		66261004455	
6" Blank	A/O	Coarse	30	66261006910	
	A/O	Medium		66261006911	
	A/O	Very Fine		66261006912	
7" Blank	A/O	Coarse	25	66261004436	66261055027
	A/O	Medium		66261004446	66261055028
	A/O	Very Fine		66261004456	
8" Blank	A/O	Coarse	20	66261006913	
	A/O	Medium		66261006914	
	A/O	Very Fine		66261006915	

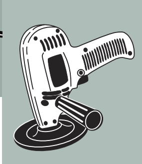
SIZE	ABRASIVE	GRIT SIZE	STD. PKG.	BEST STE-CS UPC NO.	BETTER STE-VS UPC NO.	GOOD STE UPC NO.
WITH SPEED-LOK TS FASTENING SYSTEM						
2" Speed-Lok	A/O	Extra Coarse	50	66261017819		
	A/O	Coarse			66261004439	66261009183
	A/O	Medium		66261017528	66261004449	66261009182
	A/O	Very Fine			66261004459	66261009181
3" Speed-Lok	A/O	Extra Coarse	25	66261017818		
	A/O	Coarse			66261004440	66261009186
	A/O	Medium		66261017817	66261004450	66261009185
	A/O	Very Fine			66261004460	66261009184
4" Speed-Lok	A/O	Coarse	25		66261055349	
	A/O	Medium			66261055350	
WITH SPEED-LOK TR FASTENING SYSTEM						
2" Speed-Lok	A/O	Extra Coarse	50	66261016373		
	A/O	Coarse			66261004437	66261009191•
	A/O	Medium		66261016763	66261004447	66261009190•
	A/O	Very Fine			66261004457	66261009189•
3" Speed-Lok	A/O	Extra Coarse	25	66261016994		
	A/O	Coarse			66261004438	66261009194
	A/O	Medium		66261016995	66261004448	66261009193
	A/O	Very Fine			66261004458	66261009192
4" Speed-Lok	A/O	Coarse	25		66261008822	
	A/O	Medium			66261008821	
	A/O	Very Fine			66261008820	

• PACKAGING STANDARDS: 2" STE TR DISCS STD. PKG. = 25

If you do not see the STE disc you need in our stock offering, call your local Norton distributor to check for made-to-order availability.

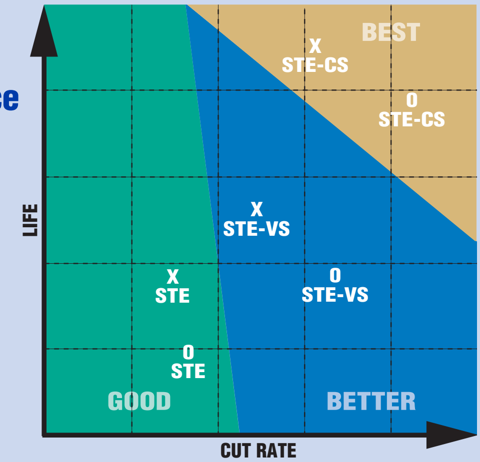
NORTON





SPEC check

STE Disc and Belt Performance



O = HIGH FORCE APPLICATIONS
X = LOW FORCE APPLICATIONS

STE-CS – aggressive, closed structure, very sharp; works best on harder materials, low- and high-force applications.

STE-VS – great multi-purpose, works great for a variety of materials

STE – more open structure; excellent on soft materials and low force applications.

Surface Finish

COARSEST	(SAME GRIT SIZE)	FINEST
STE-CS	STE-VS	STE

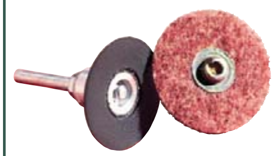
Back-up Pads for Bear-Tex Discs

PAD DIAMETER	*SPINDLE OR HOLE SIZE*	*MAX. RPM*	*3M EQUIVALENT*	*STD. PKG.*	*UPC NO.*
BACK-UP PADS FOR HOOK & LOOP DISCS					
2	1/4 Steel Shank	23,000	922	5	66261059352
3	1/4 Steel Shank	20,000	923	5	66261059354
4	1/4 Steel Shank 1/2-13 5/8-11 M10 x 1.250	18,000 13,000	924 914 914	5	66261059356 66261059303 66261059304 66261059305
4-1/2	5/8-11	10,000	9145	5	66261006948
5	5/16-24 Male 3/8-24 Male 5/8-11	10,000	905 905 915	5	66261059360 66261059308 66261059310
6	5/8-11	8,000	916	5	66261059312
7	5/8-11	6,000	917	5	66261059368
8	5/8-11	4,500	918	5	66261059372

PAD DIAMETER	*DESCRIPTION*	*MAX. RPM*	*STD. PKG.*	*UPC NO.*
BACK-UP PADS FOR SPEED-LOK DISCS				
2	Hard Speed-Lok TS Back-up Pad Medium Speed-Lok TS Back-up Pad Medium Speed-Lok TR Back-up Pad	30,000 25,000 25,000	10 10 10	63642543205 63642543210 66261055103
3	Hard Speed-Lok TS Back-up Pad Medium Speed-Lok TS Back-up Pad Hard Speed-Lok TR Back-Up Pad Medium Speed-Lok TR Back-up Pad	20,000 20,000 20,000 20,000	10 10 10 10	63642543220 63642543225 63642504900 66261055105
4	Medium Speed-Lok TS Back-up Pad Hard Speed-Lok TR Back-up Pad Medium Speed-Lok TR Back-Up Pad Speed-Lok TR+ Back-up Pad	12,000 12,000 12,000 8,000	10 10 10 1	66261043232 63642502912 66261047581 66261016581

BEAR-TEX DISC ATTACHMENT SYSTEMS

SURFACE BLENDING STE DISCS FEATURE A HOOK & LOOP FASTENING SYSTEM.

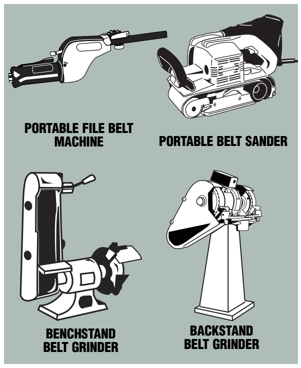


SPEED-LOK TS DISCS ARE COMPATIBLE WITH THE NORTON SPEED-LOK TS AND STANDARD® ABRASIVES QUICK CHANGE FASTENING SYSTEMS.

SPEED-LOK TR DISCS ARE COMPATIBLE WITH THE NORTON SPEED-LOK TR AND 3M ROLOC® FASTENING SYSTEMS.

Bear-Tex Surface Blending STE Belts

SIZE	ABR.	GRIT SIZE	STD. PKG.	BETTER STE-VS UPC NO.	GOOD STE UPC NO.
1/2 x 18	A/O	Coarse	24	66261009048	66261055309
	A/O	Medium		66261008814	66261055310
	A/O	Very Fine		66261006762	66261055311
1/2 x 24	A/O	Coarse	24		66261055312
	A/O	Medium		66261008972	66261055313
	A/O	Very Fine			66261055314
3/4 x 18	A/O	Coarse	12	66261008813	
	A/O	Medium		66261006546	
3-1/2 x 15-1/2	A/O	Coarse	8		66261055324
	A/O	Medium			66261055325
	A/O	Very Fine			66261055326
6 x 48	A/O	Coarse	4		66261055330
	A/O	Medium			66261055331
	A/O	Very Fine			66261055332
2 x 132	A/O	Coarse	6	66261017512	
	A/O	Medium		66261008492	



If you do not see the STE and STE-VS belts you need in our stock offering, call your local Norton distributor to check for made-to-order availability.

SPEC check

Starting Recommendations

HEAVY-DUTY CLEANING/ BLENDING	DEBURRING	CLEANING/ BLENDING	FINISHING
Extra Coarse (Brown)	Coarse (Brown)	Medium (Maroon)	Very Fine (Blue)

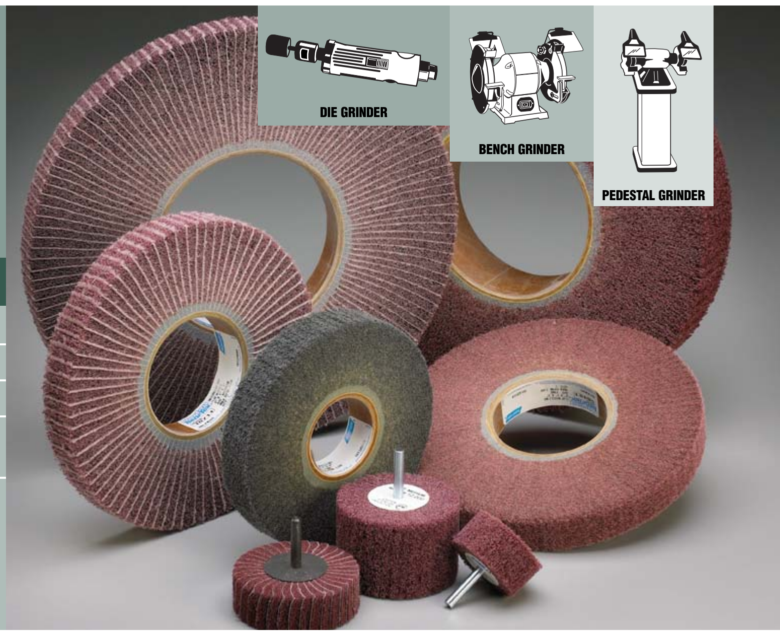
TECHtips

- For removing 60 to 120 grit grindlines – use coarse grit (brown)
- For removing 120 to 180 grit grindlines – use medium grit (maroon)
- For removing 180 to 320 grit grindlines – use very fine grit (blue)

It is the user's responsibility to comply with safety regulations.

Bear-Tex Flap Wheels

A very conformable Bear-Tex product, flap wheels provide a cushioning action which is ideal for use on uneven or irregular surfaces as well as flat areas.



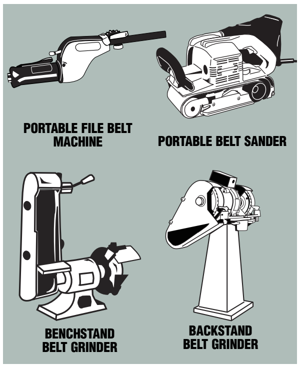
Typical Applications

- Cleaning threaded parts
- Removing oxide from printed circuit boards
- De-glossing plastic parts
- Producing uniform finishes on aluminum, brass and stainless steel
- Can be used on automatic and robotic equipment

NORTON

Bear-Tex Surface Blending STE Belts

SIZE	ABR.	GRIT SIZE	STD. PKG.	BETTER STE-VS UPC NO.	GOOD STE UPC NO.
1/2 x 18	A/O	Coarse	24	66261009048	66261055309
	A/O	Medium		66261008814	66261055310
	A/O	Very Fine		66261006762	66261055311
1/2 x 24	A/O	Coarse	24		66261055312
	A/O	Medium		66261008972	66261055313
	A/O	Very Fine			66261055314
3/4 x 18	A/O	Coarse	12	66261008813	
	A/O	Medium		66261006546	
3-1/2 x 15-1/2	A/O	Coarse	8		66261055324
	A/O	Medium			66261055325
	A/O	Very Fine			66261055326
6 x 48	A/O	Coarse	4		66261055330
	A/O	Medium			66261055331
	A/O	Very Fine			66261055332
2 x 132	A/O	Coarse	6	66261017512	
	A/O	Medium		66261008492	



If you do not see the STE and STE-VS belts you need in our stock offering, call your local Norton distributor to check for made-to-order availability.

SPEC check

Starting Recommendations

HEAVY-DUTY CLEANING/ BLENDING	DEBURRING	CLEANING/ BLENDING	FINISHING
Extra Coarse (Brown)	Coarse (Brown)	Medium (Maroon)	Very Fine (Blue)

TECHtips

- For removing 60 to 120 grit grindlines – use coarse grit (brown)
- For removing 120 to 180 grit grindlines – use medium grit (maroon)
- For removing 180 to 320 grit grindlines – use very fine grit (blue)

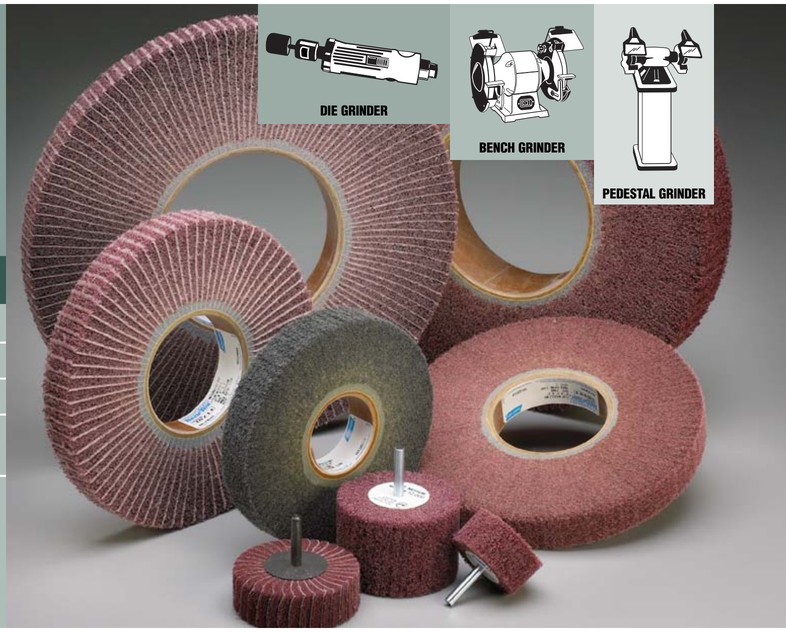
It is the user's responsibility to comply with safety regulations.

Bear-Tex Flap Wheels

A very conformable Bear-Tex product, flap wheels provide a cushioning action which is ideal for use on uneven or irregular surfaces as well as flat areas.

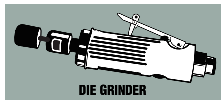
Typical Applications

- Cleaning threaded parts
- Removing oxide from printed circuit boards
- De-glossing plastic parts
- Producing uniform finishes on aluminum, brass and stainless steel
- Can be used on automatic and robotic equipment



Bear-Tex Spindle-Mounted Flap Wheels

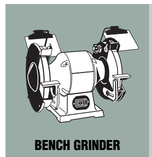
Interleaf flap wheels consist of alternating flaps of aluminum oxide coated abrasive cloth and medium grit Bear-Tex material. The interleaf product is less conformable than a standard Bear-Tex flap wheel and will remove more material.

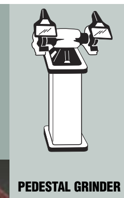


SIZE D X T X SPINDLE	BEAR-TEX ABRASIVE/ GRIT	MAX. RPM	STD. PKG.	BETTER UPC NO.
BEAR-TEX FLAP WHEELS – SPINDLE-MOUNTED				
2 x 1 x 1/4" Spindle	A/O Medium A/O Very Fine	12,000	20	66261051716 66261051717
3 x 1 x 1/4" Spindle	A/O Medium A/O Very Fine	12,000	20	66261051718 66261051719
3 x 2 x 1/4" Spindle	A/O Medium	8,000	10	66261058474

SIZE D X T X SPINDLE	COATED ABRASIVE/ GRIT	MAX. RPM	STD. PKG.	BETTER UPC NO.
BEAR-TEX INTERLEAF FLAP WHEELS – SPINDLE-MOUNTED				
2 x 1 x 1/4" Spindle	A/O 60 A/O 80 A/O 120	12,000	20	66261051720 66261051721 66261051722
3 x 1 x 1/4" Spindle	A/O 120	12,000	20	66261051725

Bear-Tex Flap Wheels





SIZE D X T X H	BEAR-TEX ABRASIVE/ GRIT	DENSITY	MAX. RPM	STD. PKG.	BETTER UPC NO.
BEAR-TEX FLAP WHEELS					
6 x 1 x 2	A/O Medium A/O Fine S/C Fine S/C Very Fine	Medium Medium Medium Medium	3,000	4	66261058456 66261058487 66261058451 66261058450
8 x 1 x 3	A/O Fine	Medium	2,500	3	66261058491
8 x 2 x 3	A/O Medium A/O Fine	Hard Medium	2,500	2	66261000889 66261058493
12 x 2 x 5	A/O Med. High Strength	Medium	1,900	1	66261005070

SIZE D X T X H	COATED ABRASIVE/ GRIT	DENSITY	MAX. RPM	STD. PKG.	BETTER UPC NO.
BEAR-TEX INTERLEAF FLAP WHEELS					
6 x 1 x 2	A/O 80 A/O 120 A/O 180	Medium Medium Medium	3,000	4	66261004418 66261007678 66261005387
8 x 1 x 3	A/O 120	Medium	2,500	3	66261010711
12 x 1 x 5	A/O 80 A/O 120	Medium Medium	1,900	2	66261010712 66261004667

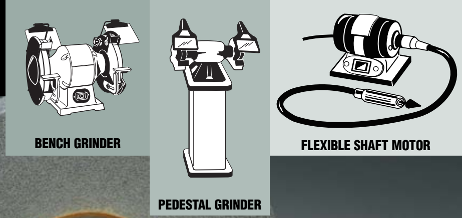
Refer to "Bear-Tex Convolute Wheels" section, for flap wheel reducing bushings.

TECHtips

Interleaf flap wheels must always be run in the direction indicated by the arrow printed on the product.

It is the user's responsibility to comply with all safety regulations.

BEAR-TEX CONVOLUTE WHEELS



Bear-Tex Convolute Wheels

Formed by wrapping and bonding web material impregnated with abrasive grain and resin around a center core. Convolute wheels offer a wide range of uses from heavy burr removal to cleaning rust and oxides.

Typical Applications

- Burr and flashing removal
- Surface roughness reduction
- Blending weld areas on stainless steel
- Blending scratch patterns
- Weld polishing
- Removing rust and oxides
- Applying decorative finishes including antique patterns

BEST Bear-Tex Clean & Finish Wheels – Fine finish with light pressure

FEATURES	*BENEFITS*
• Silicon carbide grain	• Good for blending, rust removal, applying decorative, contrast finishes and low- to moderate-speed applications • Not used for deburring
• Open mesh construction	• Used with light to moderate pressure, low speed

BEST Bear-Tex Surface Finishing Wheels – Uniform finish with moderate pressure

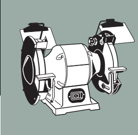
FEATURES	*BENEFITS*
• Stronger web	• More aggressive cutting action and more durability than Clean & Finish wheels • Ideal for rust and paint removal, coarse, decorative finishes and blending

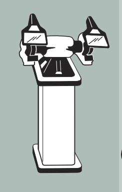
BEST Bear-Tex Metal Finishing Wheels – Decorative finishing, blending, final finishing

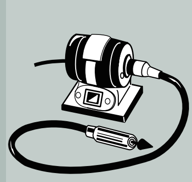
FEATURES	*BENEFITS*
• Premium, medium grit aluminum oxide grain	• Generates uniform distinct satin and antique finishes
• Dense, very durable web	• Can be used for blending applications
• Strongest resin binders	• Resilient, long life construction
• Uniform grain dispersion and coating	• Clean and condition without gouging or changing dimensions of workpiece
• Available in 5 and 6 densities	• Ideal for blending and matching #3 and 4 mil. finishes, and surface prep for buffing, polishing and applying decorative finishes

BEST Bear-Tex Series 1000 Long Life Wheels – General deburring, blending, finishing

FEATURES	*BENEFITS*
• Smear and heat-resistant formula	• Consistent, high quality results
• Dense web construction (9 density)	• Starting point for deburring, blending, polishing and finishing applications
• More open web construction (7 density)	• Smear-proof and cool cutting on light deburring applications
• Waterproof	• Use dry, wet or with oil
• Non-metallic	• No contamination of workpiece
• Optimum grain/resin formulation	• Durable, long life construction with versatile application range and improved cut rate and shed resistance
• Conformable and flexible	• Less operator fatigue


BENCH GRINDER


PEDESTAL GRINDER


FLEXIBLE SHAFT MOTOR

Bear-Tex Convolute Wheels (CONTINUED)

BEST | **Bear-Tex Series 4000 Wheels – Ideal for heavy deburring applications**

FEATURES	*BENEFITS*
• Advanced resin bond system	• Free cutting
• High quality synthetic web	• Use both wet and dry • Long life for heavy deburring, edge breaking and removing parting lines on exotic metals

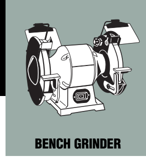
SIZE D X T X H	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	BEST UPC NO.
BEAR-TEX CLEAN & FINISH CONVOLUTE WHEELS					
4 x 1 x 1	Silicon Carbide Silicon Carbide	Medium Fine	4,000	10	66261058502 66261058501
6 x 1 x 1	Silicon Carbide Silicon Carbide	Medium Fine	3,000	4	66261058507 66261058506
6 x 2 x 1	Silicon Carbide Silicon Carbide	Medium Fine	3,000	2	66261058510 66261058509
6 x 3 x 1	Silicon Carbide	Medium	3,000	1	66261058512
6 x 4 x 1	Silicon Carbide	Medium	3,000	1	66261058514
8 x 1 x 3	Silicon Carbide	Medium	2,500	3	66261058518
8 x 2 x 3	Silicon Carbide	Medium	2,500	2	66261058521
8 x 3 x 3	Silicon Carbide	Medium	2,500	1	66261058524
8 x 4 x 3	Silicon Carbide	Medium	2,500	1	66261058526
BEAR-TEX SURFACE FINISHING CONVOLUTE WHEELS					
6 x 1 x 1	Aluminum Oxide Silicon Carbide	Medium Coarse	4,500	4	66261058550 66261058553
6 x 2 x 1	Silicon Carbide	Medium	4,500	2	66261058560
12 x 2 x 5	Silicon Carbide	Coarse	2,500	1	66261058574
BEAR-TEX METAL FINISHING CONVOLUTE WHEELS					
6 x 1 x 1	Aluminum Oxide	5AM 6AM	6,000	3	66261007936 66261010148
6 x 2 x 1	Aluminum Oxide	5AM 6AM	6,000	2	66261007957 66261009635
8 x 1 x 3	Aluminum Oxide	5AM	4,500	3	66261007831
8 x 2 x 3	Aluminum Oxide	5AM 6AM	4,500	2	66261007904 66261012971
12 x 1 x 5	Aluminum Oxide	5AM 6AM	3,000	2	66261007434 66261009481
12 x 2 x 5	Aluminum Oxide	5AM	3,000	1	66261007212
14 x 2 x 8	Aluminum Oxide	5AM 6AM	2,550	1	66261007817 66261012041

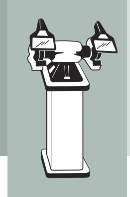
If you do not see the stock Convolute Wheel needed, call your local Norton distributor to check our made-to-order availability.

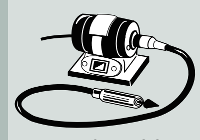
TECHtips

- Convolute wheels must always run in the direction indicated by the arrow printed on the side of each wheel.
- Light to medium pressure is recommended. Excessive pressure may result in part damage.
- Lubricants such as water-soluble oil and straight oil will decrease the heat and improve the surface finish and lustre.

⚠ It is the user's responsibility to comply with all safety regulations.


BENCH GRINDER


PEDESTAL GRINDER


FLEXIBLE SHAFT MOTOR

Bear-Tex Convolute Wheels (CONTINUED)

					BEST SERIES 1000 LONG LIFE		
SIZE D X T X H	***ABRASIVE***	***GRIT***	***MAX. RPM***	***STD. PKG.***	***7 DENSITY UPC NO.***	***8 DENSITY UPC NO.***	***9 DENSITY UPC NO.***
BEAR-TEX SERIES 1000 LONG LIFE CONVOLUTE WHEELS							
6 x 1/2 x 1	Aluminum Oxide	Medium	6,000	4	66261018857	66261018789	66261018650
	Silicon Carbide	Medium					66261019540
	Silicon Carbide	Fine			66261018628		66261018629
6 x 1 x 1	Aluminum Oxide	Medium	6,000	3	69957397884	66261018636	66261019337
	Silicon Carbide	Medium			69957397882	69957397883	66261018630
	Silicon Carbide	Fine			66261018631	66261018774	66261018632
8 x 1 x 3	Aluminum Oxide	Medium	4,500	3	69957397885	66261018855	66261018633
	Silicon Carbide	Medium			69957394610	66261018673	66261018997
	Silicon Carbide	Fine			66261018639	66261018640	66261018641
12 x 1 x 5	Aluminum Oxide	Medium	3,000	2	69957397887		66261018896
	Silicon Carbide	Medium				66261018786	66261018908
	Silicon Carbide	Fine					66261018626

					BEST	
SIZE D X T X H	***ABRASIVE***	***GRIT***	***MAX. RPM***	***STD. PKG.***	***8 DENSITY UPC NO.***	***9 DENSITY UPC NO.***
BEAR-TEX SERIES 4000 CONVOLUTE WHEELS						
6 x 1/2 x 1	Silicon Carbide	Fine	6,000	4		66261004021
6 x 1 x 1	Aluminum Oxide	Medium	6,000	3	66261004208	
	Silicon Carbide	Fine			66261004142	66261004141
8 x 1 x 3	Aluminum Oxide	Medium	4,500	3	66261004165	
	Silicon Carbide	Fine			66261004123	66261004135
12 x 1 x 5	Silicon Carbide	Fine	3,000	2	66261004284	66261004148
12 x 2 x 5	Silicon Carbide	Fine	3,000	1		66261004011

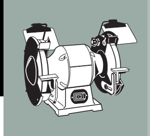
If you do not see the Convolute Wheel needed in stock, call your local Norton distributor to check our made-to-order availability.

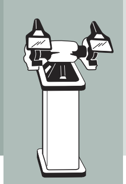
Aluminum Reducing Bushings for Flap and Convolute Wheels

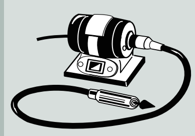
- Durable, aluminum one-piece design flanges with integrated “contact washer”
- Snug fit; extended useable life
- Available in stock and non-stock sizes: 3" up to 10" in many combinations of ID hole reduction

WHEEL CENTER HOLE	***BUSHING REDUCES HOLE SIZE TO***	***FOR WHEEL DIAMETER***	***STD. PKG.***	***UPC NO.***
1"	3/8"	4" - 6"	1 Pair	66261080522
	1/2"			66261080523
	5/8"			66261080524
	3/4"			66261080525
	7/8"			66261080526
2"	1/2"	6"	1 Pair	66261080527
	5/8"			66261080528
	1"			66261080529
	1-1/4"			66261080530
3"	1"	8"	1 Pair	66261080531
	1-1/4"			66261080532
	1-1/2"			66261080383
	1-3/4"			66261080384
	2"			66261080514
5"	1"	10" and 12"	1 Pair	66261080533
	1-1/4"			66261080534
	3"			66261080535
8"	1-1/4"	14"	1 Pair	66261080536
	3"			66261080512
10"	1-1/4"	16"	1 Pair	66261080520

NORTON


BENCH GRINDER


PEDESTAL GRINDER


FLEXIBLE SHAFT MOTOR

Bear-Tex Convolute Wheels (CONTINUED)

SPEC check

Troubleshooting Guide

PROBLEM	CORRECTION
Slow cut rate	Increase density Decrease wheel speed Use coarser grit
Low conformability	Decrease density Reduce pressure
Poor form holding	Increase density Decrease wheel speed Reduce pressure
Poor finish	Increase density Increase oscillation Use lubricant: - Water – fine - Water soluble – finer - Oil – finest Increase wheel speed (observe MAX. RPM)

Bear-Tex Metal Finishing, Series 1000 Long Life and 4000 Marking System

BOND SYSTEM	DENSITY	ABRASIVE	GRIT SIZE
1 = Series 1000 Long Life 4 = Series 4000	7 = Open/Conformable 8 9 = Dense/Durable	A = Aluminum Oxide S = Silicon Carbide	M = Medium F = Fine

Series 1000 Long Life Wheel Starting Recommendations by Application

We recommend starting these applications with a Series 1000 Long Life Wheel.

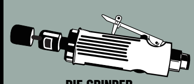
	APPLICATIONS / RECOMMENDED STARTING POINT			
TOOL/EQUIPMENT	CLEANING	DEBURRING	BLENDING	FINISHING
	1-6AM, 1-7AM	1-9SF	1-7SF	1-7SF
PORTABLE STRAIGHT SHAFT/ STATIONARY	• General purpose cleaning • Removing rust, oxidation, corrosion, discoloration	• Removing medium to heavy burrs • Deburring die cast flashings, pipe threads, machine parts, plastic molded parts	• Smoothing parting lines • Polishing welds, machine parts • Smoothing radii on metal parts • Blending coated abrasive scratch pattern	• Satin finish • Cosmetic finish • Brush finish

Convolute Wheel Starting Recommendations

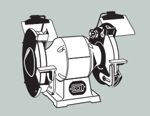
DEBURRING/BLENDING/POLISHING ← → CLEANING AND FINISHING

DEBURRING	MEDIUM GRAIN FINISHING	FINE GRAIN FINISHING
Series 1000 Long Life Wheels Series 4000 Wheels	Surface Finishing Wheels Metal Finishing Wheels	Clean & Finish Wheels

BEAR-TEX UNIFIED WHEELS


DIE GRINDER


HORIZONTAL/STRAIGHT SHAFT GRINDER


BENCH GRINDER

Bear-Tex Unified Wheels

Designed for maintenance operations needing an efficient and cost-effective method of deburring, polishing, cleaning or finishing metals and composites.

Typical Applications

- Deburring flashings, threads, sharp edges
- Removing excessive bonding agents after curing
- Blending alloys
- Polishing sheet metal and stainless steel
- Polishing precision metal pieces and welds

Bear-Tex Unified Wheels	
FEATURES	***BENEFITS***
• Easily preformed	• Usable on a wide variety of shapes/contours
• Hold shape well	• Less wheel dressing
• Non-metallic	• No contamination of workpiece
• Uniform construction	• Maintains part tolerance; prevents cutting or gouging

BEST Bear-Tex NEX Unified Wheels	
FEATURES	***BENEFITS***
• Uniform construction	• Extra long life
• High quality, virgin nylon fiber and unique resin formulation	• Optimal combination of cut rate, life, finish and hardness/flexibility
• Smear-resistant formula	• Excellent, consistent, smear-free finishes

BETTER Bear-Tex Deburring Unified Wheels	
FEATURES	***BENEFITS***
• Controlled density range	• More durable than General Duty wheels • Good starting point for high speed deburring applications

GOOD Bear-Tex General Duty Unified Wheels	
FEATURES	***BENEFITS***
• Outstanding resistance to snagging	• For general purpose light deburring applications

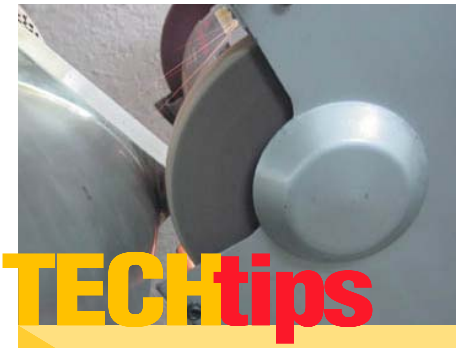
SPEC check

NEX Unified Wheel Marking System

SPECIFICATION	DENSITY	ABRASIVE	GRIT SIZE
NEX	2 – softer	A = Aluminum Oxide	XC = Extra Coarse
Unified	3		C = Coarse
Wheel	4		M = Medium
	6	S = Silicon Carbide	F = Fine
	7		
	8 – Harder		

Unified Wheel Starting Recommendations

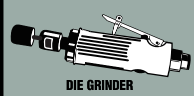
APPLICATION	SPECIFICATION
Heavy Deburring	NEX-8AM or NEX 8SM
Medium Deburring	NEX-6AM or NEX-6AF
Light Deburring	NEX-2SF or NEX-2AM
Medium Grain Finishing	150 grit S/C Medium Density General Duty Wheel or NEX-8AC
Fine Grain Finishing	220 grit S/C Medium Density General Duty Wheel or NEX-6AF



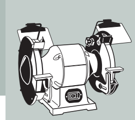
TECHtips

Unified wheels can be run in either direction.

It is the user's responsibility to comply with all safety regulations.

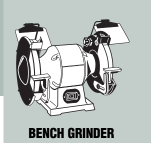

DIE GRINDER


HORIZONTAL/STRAIGHT SHAFT GRINDER


BENCH GRINDER

Bear-Tex Unified Wheels (CONTINUED)

SIZE D X T X H	SPEC.	MAX RPM	STD. PKG.	BEST NEX 2 DENSITY UPC NO.	3 DENSITY UPC NO.	4 DENSITY UPC NO.	6 DENSITY UPC NO.	7 DENSITY UPC NO.	8 DENSITY UPC NO.
BEAR-TEX NEX UNIFIED WHEELS									
1 x 1 x 3/16	A/O Crse	35,100	50						66261014915
	A/O Med			66261014891			66261014908		66261014924
	A/O Fine						66261014900		
	S/C Fine			66261014883			66261014904		
2" Speed-Lok TR	A/O Crse	22,100	60						66261014921
	A/O Med			66261014897			66261014911		66261014935
	S/C Fine			66261014889	66261017306		66261014906		
2 x 1/8 x 1/4	A/O Med	22,100	60						66261014927
2 x 1/4 x 1/4	A/O Crse	22,100	60						66261014916
	A/O Med	18,000		66261014892					
	A/O Med	22,100							66261014926
	A/O Fine	22,100					66261014901		
	S/C Med	22,100							66261014964
	S/C Fine	18,100		66261014884					
2 x 1/2 x 1/4	A/O Med	22,100	30						66261014925
3" Speed-Lok TR	A/O Crse	15,100	40						66261014922
	A/O Med			66261014898			66261014912		66261014936
	A/O Fine					66261015419			
	S/C Med								
	S/C Fine			66261014890	66261016005				
3 x 1/8 x 1/4	A/O Med	18,100	40						66261014934
3 x 1/4 x 1/4	A/O Crse	18,100	40						66261014919
	A/O Med	12,100		66261014894					
	A/O Med	18,100					66261014909		66261014930
	A/O Fine	18,100				66261015565	66261014902		
	S/C Med	18,100							66261014937
	S/C Fine	12,100		66261014886	66261016392				
3 x 1/4 x 3/8	A/O Crse	18,100	40						66261014920
	A/O Med	12,100		66261014895					
	A/O Med	18,100					66261014910		66261014933
	A/O Fine	18,100				66261014899			
	S/C Med	18,100							66261014965
	S/C Fine	12,100		66261014887	66261016006				
	S/C Fine	18,100					66261014905		
3 x 1/2 x 1/4	A/O Crse	18,100	20						66261014917
	A/O Med	12,100		66261014893					
	A/O Med	18,100					66261014928		
	S/C Fine	12,100		66261014885					
3 x 1/2 x 3/8	A/O Crse	18,100	20						66261014918
	A/O Med	18,100							66261014929
	S/C ExCrse	14,100						66261014913	
3 x 1 x 3/8	S/C ExCrse	14,100	10					66261014914	
6 x 1/2 x 1	A/O Med	7,500	4						66261014931
6 x 1 x 1	A/O Med	5,000	2	66261014896					
6 x 1 x 1	S/C Fine			66261014888					



Bear-Tex Unified Wheels (CONTINUED)

SIZE D X T X H	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	BETTER UPC NO.
BEAR-TEX DEBURRING UNIFIED WHEELS					
2 x 1/4 x 1/4	Aluminum Oxide	220	20,000	60	66261052200
2 x 1/2 x 1/4	Aluminum Oxide	120	20,000	40	66261058876
	Silicon Carbide	220			66261058782
3 x 1/4 x 1/4	Aluminum Oxide	220	18,000	40	66261058877
	Silicon Carbide	220			66261058854
3 x 1/2 x 1/4	Silicon Carbide	220	18,000	20	66261058859
3 x 3/4 x 1/4	Aluminum Oxide	220	18,000	20	66261058881

SIZE D X T X H	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	GOOD UPC NO.
BEAR-TEX GENERAL DUTY UNIFIED WHEELS						
1 x 1 x 3/16	Aluminum Oxide	80	Hard	15,000	50	66261000938
2 x 1/4 x 1/4	Aluminum Oxide	80	Hard	11,000	60	66261052275
2 x 1/2 x 1/4	Aluminum Oxide	220	Medium	11,000	40	66261058764
3 x 1/4 x 1/4	Aluminum Oxide	80	Hard	8,000	40	66261052276
	Aluminum Oxide	220	Medium			66261058816
	Silicon Carbide	220	Medium			66261000745
3 x 1/2 x 1/4	Aluminum Oxide	220	Medium	8,000	20	66261054046
	Silicon Carbide	220	Medium			66261054048
3 x 3/4 x 1/4	Aluminum Oxide	220	Medium	8,000	20	66261058769
	Silicon Carbide	150	Medium			66261058773
	Silicon Carbide	220	Medium			66261058771
6 x 1/2 x 1/2	Silicon Carbide	150	Medium	4,800	8	66261058779
6 x 1 x 1/2	Silicon Carbide	150	Medium	4,800	4	66261058792
	Silicon Carbide	220	Medium			66261058790
6 x 1 x 1	Silicon Carbide	220	Medium	4,800	4	66261058797

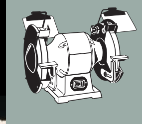
Mandrel Assemblies for Unified Wheels and Discs on Edge

FITS WHEEL CENTER HOLE	FOR WHEEL WIDTHS	FOR WHEEL DIAMETER	SHANK DIAMETER	OVERALL LENGTH	WASHER DIAMETER	3M EQUIVALENT	STD. PKG.	UPC NO.
1/8" – 3/16"	Up to 1/2"	Up to 2"	1/8"	1-3/4"	7/16"	931	1	66261009849
3/16"	1/8" – 1/2"	1" – 2"	1/4"	2"	7/16"	994	1	66261009852
1/4" – 5/16"	Up to 1/2"	Up to 2"	1/4"	2"	5/8"	932	1	66261015146
1/4" – 5/16"	Up to 1"	Up to 2"	1/4"	2-1/2"	5/8"	932	1	66261059422
	Up to 1"	2" – 3"	1/4"	2-1/2"	1"	933	1	66261059421
3/8"	Up to 1/2"	2" – 4"	1/4"	2-1/2"	1"	990	1	66261009851
1/2"	Up to 1"	3" – 6"	1/4"	3-1/8"	1-5/8"	934	1	66261009850

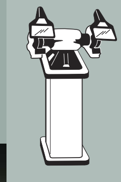
Threaded Mandrel for Unified Wheels

SHANK LENGTH	SHANK DIAMETER	FOR CENTER HOLE	USE WITH UNIFIED WHEEL	3M EQUIVALENT	STD. PKG.	UPC NO.
1-3/4"	1/4"	3/16	1 X 1 X 3/16	948	5	66261047584

NORTON



BENCH GRINDER



PEDESTAL GRINDER

Bear-Tex Polybond Wheels

Polybond wheels are manufactured by bonding abrasive grain into a foamed polyurethane matrix, similar to bonded grinding wheels, yet flexible and conformable.

Typical Applications

Metal Conditioning Wheels
- Heavy-duty deburring applications
- High surface temperature applications
- Replacing wire brushes
- Finishing applications

Wood Finishing Wheels
- Wood mold profile sanding

BEAR-TEX METAL CONDITIONING POLYBOND WHEELS

SIZE D X T X H	*SPECIFICATION*	*MAX. RPM*	*STD. PKG.*	BETTER *UPC NO.*
6 x 1/2 x 1-1/4	C150-H10BTM	3,600	8	66261010696
6 x 1 x 1-1/4	A40-H10BTM	3,600	4	66261006117
6 x 1 x 1-1/4	C80-F7BTM	3,600	4	66261010698
6 x 1 x 1-1/4	C240-D4BTM	2,200	4	66261010695

BEAR-TEX WOOD FINISHING POLYBOND WHEELS

SIZE D X T X H	*SPECIFICATION*	*MAX. RPM*	*STD. PKG.*	BETTER *UPC NO.*
6 x 2 x 1-1/4	G60-H9BTW C80-F7BTW	3,600	2	66261003833 66261009750
8 x 2 x 1-1/4	C80-F7BTW G100-D7BTW	2,600	2	66261004579 66261009846
8 x 2 x 3	G60-F7BTW G120-D7BTW	2,600 1,750	2	66261017833 66261017763

SPEC check

Bear-Tex Polybond Wheel Starting Recommendations

Metal Conditioning

APPLICATION	SPEC
General deburring – nonferrous and coarse finishing	A40-H10BTM
General deburring – nonferrous materials	C80-F7BTM
All purpose finishing and polishing	C240-D4BTM
General deburring and finishing	C150-H10BTM

Wood Finishing

APPLICATION	SPEC
Knife mark removal on solid wood molding	G60-F7BTW
Intermediate sanding of solid woods	G60-H9BTW
Finish sanding of solid woods	C60-H9BTW
Finish sanding of synthetic board products	C80-F7BTW
Sealer sanding	G100-D7BTW
Final finishing of solid wood molding	G120-D7BTW

Bear-Tex Wood Finishing Polybond Wheel Speed Recommendation Chart

Polybond polyurethane foam wood finishing wheels provide the ideal balance between long life and profile edge holding ability – matched with fast cut rates and uncompromised finishing capability.

WHEEL DIAMETER	SOFT MAPLE, POPLAR, MAHOGANY, PINE, GUM SUGGESTED SFPM: 1500 – 2000	OAK, WALNUT, ROCK MAPLE, PECAN, CHERRY SUGGESTED SFPM: 900 – 1400	SYNTHETIC BOARD PRODUCTS SUGGESTED SFPM: 2000 – 2500
6"	900 – 1250 RPM	550 – 850 RPM	1300 – 1600 RPM
8"	650 – 900 RPM	400 – 600 RPM	950 – 1200 RPM

Contact your Norton representative for additional non-stock Polybond wheels.

SPEC check

Bear-Tex Competitive Cross Reference Charts

Bear-Tex Hand Pads

NORTON (BEAR-TEX)	3M (SCOTCH-BRITE)	STANDARD ABRASIVES (BRITE-RITE)
456 Light Duty Cleaning Pad (White)	7445 (White)	Brite-Rite Cleaning
635 Clean & Finish Pad (Gray)	6448 (Brown)	
740 Heavy Duty Pad (Brown)	7440 (Tan)	Brite-Rite Heavy Duty
746 Metal Blend Pad (Gray)	7446 (Gray)	
747 General Purpose Pad (Maroon)	7447 (Maroon)	Brite-Rite General Purpose
748 Final Shine Pad (Gray)	7448 (Gray)	Brite-Rite Ultra-Fine S/C
777 Long Life Pad (Maroon)		
796 Scouring Pad (Green)	96 (Green)	Brite-Rite Industrial

Bear-Tex Discs

NORTON (BEAR-TEX)	3M (SCOTCH-BRITE)	STANDARD ABRASIVES (BRITE-RITE)
Bear-Tex High Strength Discs	High Strength	High Strength
Rear-Tex Rapid Strip Discs	Clean & Strip	Britestrip

Bear-Tex Surface Blending STE Discs and Belts

NORTON (BEAR-TEX)	3M (SCOTCH-BRITE)	STANDARD ABRASIVES (BRITE-RITE)
A/O Very Fine (Blue)	Surface Conditioning A VFN	Surface Conditioning FE Very Fine
A/O Medium (Maroon)	Surface Conditioning A MED	Surface Conditioning FE Maroon
A/O Coarse (Brown)	Surface Conditioning A CRS	Surface Conditioning FE Coarse
STE-CS (EXCRS, MED)	SE Surface Conditioning, SE Purple (CRS, MED)	Surface Conditioning FE, Rapid Cut (CRS, MED)
STE-VS, STE (CRS, MED, VFINE)	Surface Conditioning (CRS, MED, VFINE)	Surface Conditioning FE, Rapid Cut (CRS, MED, VFINE)

Bear-Tex Flap Wheels and Interleaf Flap Wheels

NORTON (BEAR-TEX)	3M (SCOTCH-BRITE)	STANDARD ABRASIVES (BRITE-RITE)
Medium Density Flap Wheel	Finishing Flap Brush 5 Density	Buff & Blend Flap Brushes – Medium
Hard Density Flap Wheel	Finishing Flap Brush 7 Density	Buff & Blend Flap Brushes – Hard
Flap Wheel with 1/4 Spindle A/O VF	CFFB-S S FIN	
Flap Wheel with 1/4 Spindle A/O Med	CFFB-S A CRS	Mandrel Mounted Flap Brushes – A/O Med
Interleaf Flap Wheel with 1/4 Spindle A/O 60	COMBI-S A 80	Mandrel Mounted Combi-wheels – A/O 60
Interleaf Flap Wheel with 1/4 Spindle A/O 80	COMBI-S A P120	Mandrel Mounted Combi-wheels – A/O 80
Interleaf Flap Wheel with 1/4 Spindle A/O 120	COMBI-S A P180	Mandrel Mounted Combi-wheels – A/O 120

Bear-Tex Convolute Wheels

NORTON (BEAR-TEX)	3M (SCOTCH-BRITE)	STANDARD ABRASIVES (BRITE-RITE)
Series 1000 Long Life 7 Density S/C	SST Deburring 7 Density S/C	Brite-Rite General Purpose 7 Density S/C
Series 1000 Long Life 7 Density A/O	Cut & Polish 7 Density A/O	Brite-Rite General Purpose 7 Density A/O
Series 1000 Long Life 8 Density S/C	SST Deburring 8 Density S/C	Brite-Rite Deburring 8 Density S/C
Series 1000 Long Life 8 Density A/O	Cut & Polish 8 Density A/O	Brite-Rite Deburring 8 Density A/O
Series 1000 Long Life 9 Density S/C F	EXL Deburring	Brite-Rite Deburring 9 Density
Series 4000	EXL, EX2 & EX3 Deburring	Brite-Rite HP
Metal Finishing 5AM	Metal Finishing 4AM & 5AM	Metal Finishing
Clean & Finish/Surface Finishing	Multi-Finishing	Brite-Rite Final Finishing

Bear-Tex Unified Wheels

NORTON (BEAR-TEX)	3M (SCOTCH-BRITE)	STANDARD ABRASIVES (BRITE-RITE)
NEX	EXL, SST, Cut & Polish Unitized	Brite-Rite Unitized
General Duty Unified and Deburring Unified	General Purpose	

BEAR-TEX SURFACE FINISHING PRODUCTS

Introduction

Most Bear-Tex products consist of a non-woven web of nylon fibers impregnated throughout with abrasive grain and bonded with synthetic resins. This design produces a cushioned, three-dimensional material that is extremely pliable and long lasting. The uniform dispersion of abrasive throughout the web provides a continuous supply of new grain as the old grain and fibers wear away during use.

Bear-Tex products, with their open mesh construction, are waterproof, washable, resilient, conformable, non-loading, non-conductive, non-metallic and non-rusting. Bear-Tex wheels are easily pre-formed to conform to special-shaped work pieces.

Since Bear-Tex products are designed for use where stock removal is not required, they begin where other abrasives leave off. The relatively non-aggressive nature of nylon and grit inherent in the Bear-Tex material makes it ideal as a finishing tool. While 60 to 80 grit are considered intermediate sizes in other products, they are considered coarse for Bear-Tex items.

Used wet or dry, Bear-Tex products offer the following advantages: controlled cut (with little or no stock removal) allows for increased productivity, consistent, uniform finish, ability to automate operations, minimized smearing and reduced operator training. These advantages make Bear-Tex products an excellent alternative to bristle brushes, set-up wheels, greaseless compounds and steel wool.

Product Identification System

8 A M

A/O MED

DENSITY	
Open /	**- 2**
Conformable	**3**
	4
	6
	7
Dense /	**8**
More Durable	**- 9**

ABRASIVE
A, A/O Aluminum Oxide
S, S/C Silicon Carbide

GRIT SIZE	
Extra Coarse	**- XC**
Coarse	**- C**
Medium	**- M, Med**
Fine	**- F**
Very Fine	**- VF**
Ultra Fine	**- UF**
Micro Fine	**- MF**

Abrasives

Silicon carbide and aluminum oxide abrasives are offered. Silicon carbide is sharper, cuts faster, and produces finer scratch patterns on most surfaces. Aluminum oxide is more durable and tends to last longer. It causes less discoloration on aluminum, and is more aggressive on certain applications such as hardened steel parts. Bear-Tex hand pads and rolls are also available in a non-abrasive material.

Grits

Grit refers to the size of the abrasive grain impregnated into the nylon web. The coarser the grit, the more aggressive the cut, the rougher the finish. The finer the grit, the less aggressive the cut and the resulting surface finish will be finer, if all other conditions are equal.

GRIT DESIGNATIONS	GRIT SIZE
Extra Coarse (XC)	**24 – 36**
Coarse (C)	**50 – 80**
Medium (M)	**100 – 150**
Fine (F)	**180 – 220**
Very Fine (VF)	**240 – 360**
Super Fine (SF)	**400**
Ultra Fine (UF)	**600**
Micro Fine (MF)	**800 – 1200**

Densities

The product "density"refers to the number of fibers which have been compressed into the nylon web material. Under identical conditions, harder density wheels cut faster, last longer and produce finer finishes than softer density wheels. Softer density wheels offer greater conformability and have less tendency to load or burn the work piece.

Fiber Sizing

Several nylon fiber sizes are used in the manufacture of Bear-Tex web material because the fiber size is a significant factor in the coating process, as each produces distinct cutting characteristics.

Bonding Agents

Waterproof resins are used in the manufacture of Bear-Tex web material to bond the nylon fibers together and to firmly anchor the abrasive grains throughout the web.

Conventional Finishing Methods Versus Bear-Tex Products

The following chart outlines the advantages achievable when using Bear-Tex products as alternatives to other cleaning, blending, deburring and finishing methods. Bear-Tex products are listed in the sequence of normal preference for the application stated. However, because of the numerous variables, only testing can ensure selection of the most cost-effective product.

CONVENTIONAL FINISHING METHOD	KEY APPLICATION	BEAR-TEX PRODUCT AS AN ALTERNATIVE	ADVANTAGES OF BEAR-TEX PRODUCT VERSUS ALTERNATE FINISHING METHODS
Bristle Brushes	Cleaning	Clean & Finish Wheels Metal Finishing Wheels Flap Wheels	Superior cleaning performance Higher productivity No slurry or compound required More consistent finish Eliminate compound dust and flying bristles
Greaseless Compounds	Finishing	Flap Wheels Convolute Wheels Unified Wheels	Reduced maintenance No compound, instant set-up Elimination of compound dust More uniform finish More consistent work rate
Set-up Wheels	Blending/ Deburring	Convolute Wheels Unified Wheels	No break-in time required More consistent cut More uniform finish Maintains geometry Safer, no flying wheel pieces
Steel Wool	Cleaning	Rolls Discs Hand Pads	Faster, longer life Less pressure required Non-rusting, cleaner Safer, no splinters

BEAR-TEX SURFACE FINISHING PRODUCTS

Getting the Most Out of Bear-Tex Wheels

Maximum wheel life and best surface conditioning results can be achieved by closely adhering to the following recommendations.

1) Wheel Direction

Convolute wheels and interleaf flap wheels must always run in the direction indicated by the arrow printed on the side of each wheel. Conventional flap wheels and unified wheels can be run in either direction.

2) Wheel Speed

Wheel speed is an important factor in that it affects product finish, rate of cut, and wheel life. In general, fast wheel speeds give harder action and a finer finish; whereas, slower speeds give a softer action and a coarser finish for the same wheel density.

The following are recommended operating speeds for the most common applications.

APPLICATION	RECOMMENDED SPEED
Cleaning and upgrading of surface conditions	2200 to 6000 SFPM
Cut-buffing on metal surfaces	6500 to 8000 SFPM
Deburring	5500 to 8000 SFPM
Decorative finishing	500 to 3000 SFPM
Imparting decorative finishes	900 to 3000 SFPM
Oxide removal	3500 to 6500 SFPM

TESTING MAY SHOW THAT A SLOWER OR FASTER SPEED IS DESIRABLE FOR SPECIFIC OPERATIONS. NEVER EXCEED THE MAXIMUM RPM RATING OF THE WHEEL.

3) Pressure

Light to medium pressure is recommended for most operations. Flap wheels require much lighter pressure to perform properly than other Bear-Tex wheels; unified wheels can withstand much higher pressures in order to perform deburring jobs. In all cases, avoid excessive pressure which may result in wheel deformation and damage to the work surface.

4) Feed Speed

Low feed speed reduces the number of workpieces completed, while producing a shorter scratch pattern. Slow feed speed allows for longer dwell time and permits more work to be done on each piece. Conversely, a fast feed speed increases the number of workpieces completed, while producing a longer scratch pattern.

5) Oscillation

Oscillation may be used to break up scratch lines and produce a more uniform finish. Additionally, an increase in cut may be experienced. A general starting point for oscillation is 3/8" amplitude at 200 cycles per minute.

6) Lubricants

Lubricants, such as water, water soluble oil and straight oil, will decrease the heat generated while running, improve the luster, and reduce the surface finish. The higher the viscosity of the lubricant, the lower the surface finish (RMS value) produced.

Factors in Wheel Choice

This chart provides a relative comparison of other Bear-Tex wheel variables. It can serve as a useful guide in choosing the most suitable product for a given application. However, as many other factors affect wheel performance, this chart can only be general in nature. The most cost-effective results can always be obtained by wheel testing on the application.

1. Wheel Conformability	MOST CONFORMABLE (SOFT) ↔ LEAST CONFORMABLE (HARD)	Flap Wheel	Clean & Finish	Metal Finishing	Series 1000 Long Life 7 Density	Series 1000 Long Life 8 & 9 Density	Series 4000
2. Wheel Openness	OPEN MESH ↔ CLOSED MESH		Clean & Finish	Metal Finishing	Series 1000 Long Life 7 Density	Series 1000 Long Life 8 & 9 Density	Series 4000
3. Wheel Aggressiveness	MOST AGGRESSIVE ↔ LEAST AGGRESSIVE		Metal Finishing		Clean & Finish	Series 1000 Long Life	Flap Wheels
4. Finishing Action*	COARSER ↔ FINER		Metal Finishing	Clean & Finish	Series 4000	Series 1000 Long Life Series 4000	Flap Wheels
5. Pressure for Best Results	LIGHTER ↔ HIGHER		Flap Wheels	Clean & Finish	Metal Finishing Series 1000 Long Life 7 Density	Series 1000 Long Life 8 & 9 Density	Series 4000

*** ON STEEL SURFACES, SILICON CARBIDE WHEELS WILL PRODUCE A BRIGHTER FINISH THAN ALUMINUM OXIDE WHEELS.**

Surface Finish Variables

Changes in any one of many factors can affect the surface finish on the work piece. This chart shows the effect on surface finish by changes in single factors of product specifications. Arrows have been used to signify the trend direction. The arrow length does not signify that the effect of each factor is equal.

VARIABLE FACTOR	ROUGH FINISH HIGH RMS READING			SMOOTH SURFACE LOWER RMS READING
1. GRIT SIZE	COARSE ↔			VERY FINE
2. WHEEL GRADE	SOFT ↔			HARD
3. WHEEL SPEED	SLOW ↔			FAST
4. FEED SPEED	FASTER (LONG SCRATCH) ↔			SLOWER (SHORT SCRATCH)
5. OSCILLATION	NO OSCILLATION ↔			OSCILLATION
6. LUBRICANTS and COMPOUNDS	DRY ↔	WATER ↔	SOLUBLE OIL ↔	STRAIGHT OIL
		↔	COMPOUNDS	↔

NORTON