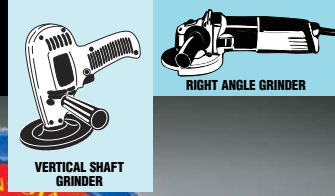


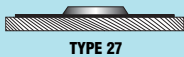
FLAP DISCS

Our flap discs are engineered for light stock removal, blending and finishing all in one application. They grind like a depressed center wheel and finish like a fiber disc to reduce process time and lower total grinding costs.



Typical Applications

- Stock removal
- Deburring
- Blending welds
- Edge chamfering
- Rust removal
- Cleaning and finishing



BEST Norton SG Blaze R980 – Longest life, coolest cut rate

FEATURES	BENEFITS
• Next generation SG ceramic abrasive grain	• Last 50% – 200% longer than any flap discs on stainless steel, cobalt, chrome, Inconel, titanium and other hard-to-grind materials
• Improved Y-wt polyester cloth	• Significantly improves life, grain retention and fray resistance
• Supersized grinding aid	• Cool, noticeably fast cut rate
• Durable fiberglass back	• Quick stock removal and long life
• Type 29 conical shape	• Maximum contact with workpiece without loading
• Type 27 flat face	• Fine finishing primarily on flat surfaces



BEST TwinFiber – Aggressive stock removal

FEATURES	BENEFITS
• Premium ceramic and zirconia alumina abrasive blend	• Excellent performance and efficiencies on stainless steel applications
• Durable, fiberglass back	• Less pressure for aggressive stock removal; long life
• Type 29 angled face, conical shape	• Maximum contact with work surface without loading
• 4-1/2" and 7" with 5/8"-11 hub	• Less downtime for disc changes
• 6" with 7/8" hole	• Support increasing volume of 6" tools



BEST TwinStar – Fine finishes

FEATURES	BENEFITS
• Premium ceramic and zirconia alumina abrasive blend	• Excellent performance and efficiencies on stainless steel applications
• Type 27 – flat face; plastic back	• Plastic wears away with abrasive – for longer life • More forgiving than Type 29 – producing smooth finishes
• 4-1/2" and 7" with 5/8"-11 hub	• Less downtime for disc changes
• 4" with 5/8" hole	• Support increasing volume of smaller tools



BETTER Charger R822 – Versatile; high performance

FEATURES	BENEFITS
• High performance zirconia alumina abrasive	• Aggressive cut and long life • Up to 30% longer life than aluminum oxide products
• Durable, fiberglass back	• Less pressure for aggressive stock removal and long life





GOOD Merit Zirconia – Ideal, general purpose flap disc

FEATURES

- Quality zirconia alumina grain with a phenolic resin back

BENEFITS

- Fast cutting; fine finishes
- Great value for MRO operations



SPECcheck



Flap Disc Starting Recommendations by Material

MATERIAL	HEAVY-DUTY / AGGRESSIVE STOCK REMOVAL	FINE FINISHING
Stainless steel and other tough applications	Type 29 SG Blaze R980, TwinFiber	Type 27 Norton SG Blaze R980 TwinStar
Other ferrous and nonferrous materials	Charger R822 Type 29	Charger R822 Type 27

Flap Disc Competitive Cross Reference

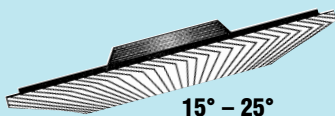
NORTON	DEWALT	GARRYSON	GEMTEX	KLINGSPOR	PFERD	SAIT	3M	WALTER	WEILER
SG Blaze R980							947D		
TwinStar								Enduroflex	
TwinFiber		Zirc +					747D Regalite		
Charger R822	Zirc	Zirc	Zirc	SMT626	Polifan	Saitlam F ZH	563D	Quick Step	Tiger, Big Cat
Merit		Zirc							Vortec

Two Basic Flap Disc Designs

Norton Type 29 Conical / Merit Type 27C Conical

THE MOST AGGRESSIVE CHOICE

- Conical flap discs have flaps angled at 10 degrees and may be used on both conical and flat surfaces
- The angle provides greater surface contact and as a result, tends to be the most aggressive choice
- The best choice when speed and stock removal are primary considerations

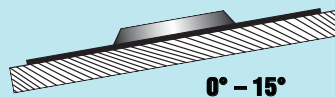


GRIND AT
STEEPER ANGLES

Norton and Merit Type 27 Flat

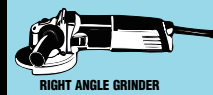
THE CHOICE FOR THE BEST FINISH

- The Type 27 flap discs have a flat design and are used primarily on flat surfaces
- The best choice for smooth finishing
- Also available in Norton Jumbo / Merit High Density sizes with extra large flaps lasting up to 40% longer than standard flap discs
- Choice will also depend on user preference of grinding angle (severe angle will weaken the edges)



GRIND AT
FLATTER ANGLES

FLAP DISCS



RIGHT ANGLE GRINDER



VERTICAL SHAFT GRINDER

FLAP DISCS

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BEST T29 – SG BLAZE R980 **BEST** T29 – TWINFIBER **BETTER** T29 – CHARGER R822 **GOOD** T27C – MERIT ZA

SIZE D X H	GRIT	MAX. RPM	STD.		STD.		STD.		STD.	
			PKG.	UPC NO.	PKG.	UPC NO.	PKG.	UPC NO.	PKG.	UPC NO.

TYPE 29 / TYPE 27C CONICAL



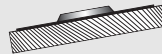
4 x 5/8	36	13,000	10			5	66261119265			
	40						66261119264			
	60						66261119263			
	80						66261119262			
	120						66261119261			
4-1/2 x 5/8-11	24	13,000	10	66261183490 66261183491 66261183492 66261183493	5	5	66261121291	08834194803 08834194804 08834194805	10	
	36						66261121290			
	40						63642536156 66261121289			
	60						63642536157 66261121288			
	80						63642536158 66261121287			
120	63642597115 66261121286									
4-1/2 x 7/8	24	13,000	10	66261183486 66261183487 66261183488 66261183489	10	5	66261119271	08834194296 08834194766 08834194767 08834194768	10	
	36						66261119270			
	40						63642504329 66261119269			
	60						63642504330 66261119268			
	80						63642504331 66261119267			
120	63642504332 66261119266									
5 x 7/8	24	12,000	10	66261190001 66261190002 66261190003 66261190004	5	10	66261119277	08834193649 08834193650 08834193651 08834193652	10	
	36						66261119276			
	40						66261119275			
	60						66261119274			
	80						66261119273			
120	66261119272									
6 x 7/8	40	10,200			10	5	63642541406			
	60						63642541407			
	80						63642541408			
7 x 5/8-11	24	8,500	10	66261183498 66261183499 66261183500 66261183501	5	5	66261119289	08834197210 08834197212 08834197213	10	
	36						66261119288			
	40						66261119287			
	60						66261119286			
	80						66261119285			
120	66261119284									
7 x 7/8	24	8,500	10	66261183494 66261183495 66261183496 66261183497	10	5	66261119283	08834197194 08834197195 08834194777 08834197199 08834197204	10	
	36						66261119282			
	40						66261119281			
	60						66261119280			
	80						66261119279			
120	63642504334 63642504335 63642504336 63642504337 63642504338									



BETTER T27 – JUMBO CHARGER R822 **GOOD** T27 – HIGH DENSITY MERIT ZA

SIZE D X H	GRIT	MAX. RPM	STD.		STD.	
			PKG.	UPC NO.	PKG.	UPC NO.

TYPE 27 JUMBO / HIGH DENSITY



4-1/2 x 5/8-11	40	13,000	5	63642503527		
	60			63642503528		
	80			63642503529		
4-1/2 x 7/8	40	13,000	5	63642503531	10	08834190172
	60			63642503532		08834190767
	80			63642503533		08834194360
7 x 5/8-11	40	8,500	5	63642503539		
	60			63642503540		
7 x 7/8	40	8,500	5	63642503535	10	08834190933
	60			63642503536		08834194514
	80			63642503537		08834194362

TECHtip

Use flap discs one grit size coarser than fiber discs, except in 36 grit.



It is the user's responsibility to refer to and comply with ANSI B7.7

FLAP DISCS



FLAP DISCS



BEST T27 – SG BLAZE R980 **BEST** T27 – TWINSTAR **BETTER** T27 – CHARGER R822 **GOOD** T27 – MERIT ZA

SIZE D X H	GRIT	MAX. RPM	BEST T27 – SG BLAZE R980		BEST T27 – TWINSTAR		BETTER T27 – CHARGER R822		GOOD T27 – MERIT ZA	
			STD. PKG.	UPC NO.	STD. PKG.	UPC NO.	STD. PKG.	UPC NO.	STD. PKG.	UPC NO.
TYPE 27 FLAT										
2" Type II Turn-on	36	24,000							10	08834195020
	40									08834195021
	60									08834195022
	80									08834195023
	120									08834195024
3" Type II Turn-on	36	20,000							10	08834195035
	40									08834195036
	60									08834195037
	80									08834195038
	120									08834195039
4 x 5/8	40	13,000			10	63642536153				
	60					63642536154				
	80					63642536155				
4-1/2 x 5/8-11	36	13,000	10	66261100005	5	63642536147	5	63642503510		
	40		66261100006		63642536148		63642503511			
	60		66261100007		63642536149		63642503512			
	80		66261100008				63642503513			
4-1/2 x 7/8	36	13,000	10	66261100001	10	63642504876	5			
	40		66261100002		63642504877		66261134069			
	60		66261100003		63642504878		66261134070			
	80		66261100004		63642504879		66261134071			
	120				63642505279					
5 x 7/8	36	12,000	10	66261100009	10	63642505281	5			
	40		66261100010		63642505282		63642503515			
	60		66261100011		63642505283		63642503516			
	80		66261100012		63642505284					
	120				63642505285					
7 x 5/8-11	36	8,500	10	66261100017	5		5	63642503518		
	40		66261100018		63642536150		63642503519			
	60		66261100019		63642536151		63642503520			
	80		66261100020		63642536152		63642503521			
7 x 7/8	36	8,500	10	66261100013	10	63642504880				
	40		66261100014		63642504881					
	60		66261100015		63642504882					
	80		66261100016		63642504883					



Mini Powerflex Holder

DESCRIPTION	STD. PKG.	UPC NO.
Mini PowerFlex Type II Holder (Norton Speed-Lok TS)	1	08834168539
Mini Powerflex Type III Holder (Norton Speed-Lok TR)	1	08834160172

FIT 2" AND 3" MERIT FLAP DISCS



TECHtips

- Operate Type 29/27C flap discs at a 15° – 25° angle; operate Type 27 (Regular and Jumbo / High Density) flap discs at an angle less than 15°; more severe angles will weaken flap edges.
- Use one grit size coarser than fiber discs, except in 36 grit.

! It is the user's responsibility to refer to and comply with ANSI B7.7

