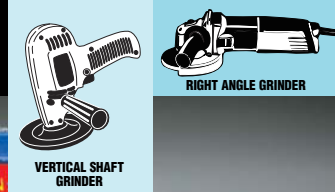


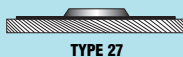
FLAP DISCS

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

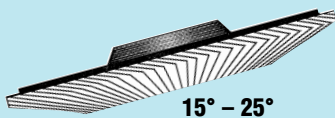
| NORTON | DEWALT | GARRYSON | GEMTEX | KLINGSPOR | PFERD | SAIT | 3M | WALTER | WEILER |
|---------------|--------|----------|--------|-----------|---------|--------------|---------------|------------|----------------|
| SG Blaze R980 | | | | | | | 947D | | |
| TwinStar | | | | | | | | Enduroflex | |
| 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

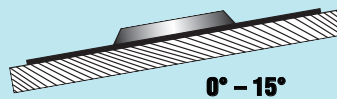


GRIND AT
STEEPER ANGLES

Norton and Merit Type 27 Flat

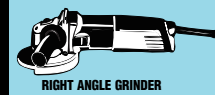
THE CHOICE FOR THE BEST FINISH

- 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



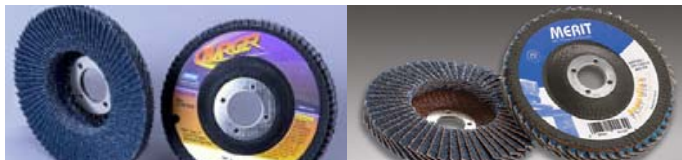
BEST T29 – SG BLAZE R980 **BEST** T29 – TWINFIBER **BETTER** T29 – CHARGER R822 **GOOD** T27C – MERIT ZA

| SIZE D X H | GRIT | MAX. RPM | T29 – SG BLAZE R980 | | T29 – TWINFIBER | | T29 – CHARGER R822 | | T27C – MERIT ZA | |
|---------------|------|-------------|---------------------|---------|-----------------|---------|--------------------|---------|-----------------|---------|
| | | | STD. PKG. | UPC NO. | STD. PKG. | UPC NO. | STD. PKG. | UPC NO. | STD. PKG. | UPC NO. |

TYPE 29 / TYPE 27C CONICAL



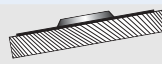
| | | | | | | | | | | |
|----------------|-----|--------|-------------|--|-------------|--|-------------|-------------|-------------|--|
| 4 x 5/8 | 36 | 13,000 | | | | | 5 | 66261119265 | | |
| | 40 | | | | | | | 66261119264 | | |
| | 60 | | | | | | | 66261119263 | | |
| | 80 | | | | | | | 66261119262 | | |
| | 120 | | | | | | | 66261119261 | | |
| 4-1/2 x 5/8-11 | 24 | 13,000 | 10 | | | | 5 | 66261121291 | 10 | |
| | 36 | | | | | | 66261121290 | | | |
| | 40 | | 66261183490 | | 63642536156 | | 66261121289 | | 08834194803 | |
| | 60 | | 66261183491 | | 63642536157 | | 66261121288 | | 08834194804 | |
| | 80 | | 66261183492 | | 63642536158 | | 66261121287 | | 08834194805 | |
| 4-1/2 x 7/8 | 24 | 13,000 | 10 | | | | 5 | 66261119271 | 10 | |
| | 36 | | | | | | 66261119270 | | | |
| | 40 | | 66261183486 | | 63642504329 | | 66261119269 | | 08834194296 | |
| | 60 | | 66261183487 | | 63642504330 | | 66261119268 | | 08834194766 | |
| | 80 | | 66261183488 | | 63642504331 | | 66261119267 | | 08834194767 | |
| 5 x 7/8 | 24 | 12,000 | 10 | | | | 5 | 66261119277 | 10 | |
| | 36 | | | | | | 66261119276 | | | |
| | 40 | | 66261190001 | | 63642541406 | | 66261119275 | | 08834193649 | |
| | 60 | | 66261190002 | | 63642541407 | | 66261119274 | | 08834193650 | |
| | 80 | | 66261190003 | | 63642541408 | | 66261119273 | | 08834193651 | |
| 6 x 7/8 | 24 | 10,200 | | | | | 5 | 66261119272 | | |
| | 36 | | | | | | 66261119271 | | | |
| | 40 | | 66261190004 | | 63642504332 | | 66261119270 | | 08834193652 | |
| | 60 | | | | | | 66261119269 | | | |
| | 80 | | | | | | 66261119268 | | | |
| 7 x 5/8-11 | 24 | 8,500 | 10 | | | | 5 | 66261119289 | 10 | |
| | 36 | | | | | | 66261119288 | | | |
| | 40 | | 66261183498 | | 63642536159 | | 66261119287 | | 08834197210 | |
| | 60 | | 66261183499 | | 63642536160 | | 66261119286 | | 08834197212 | |
| | 80 | | 66261183500 | | 63642536161 | | 66261119285 | | 08834197213 | |
| 7 x 7/8 | 24 | 8,500 | 10 | | | | 5 | 66261119283 | 10 | |
| | 36 | | | | | | 66261119282 | | | |
| | 40 | | 66261183494 | | 63642504334 | | 66261119281 | | 08834197194 | |
| | 60 | | 66261183495 | | 63642504335 | | 66261119280 | | 08834197195 | |
| | 80 | | 66261183496 | | 63642504336 | | 66261119279 | | 08834197199 | |
| 7 x 7/8 | 24 | 8,500 | | | | | 5 | 66261119278 | | |
| | 36 | | | | | | 66261119277 | | | |
| | 40 | | 66261183497 | | 63642504337 | | 66261119276 | | 08834197204 | |
| | 60 | | | | | | 66261119275 | | | |
| | 80 | | | | | | 66261119274 | | | |



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

| SIZE D X H | GRIT | MAX. RPM | T27 – JUMBO CHARGER R822 | | T27 – HIGH DENSITY MERIT ZA | |
|---------------|------|-------------|--------------------------|---------|-----------------------------|---------|
| | | | STD. PKG. | UPC NO. | STD. 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



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 | | | | | | | | | |
| 5 x 7/8 | 36 | 12,000 | 10 | 66261100009 | 10 | 63642505281 | 5 | | | |
| | 40 | | 66261100010 | | 63642505282 | | 63642503515 | | | |
| | 60 | | 66261100011 | | 63642505283 | | 63642503516 | | | |
| | 80 | | 66261100012 | | | | | | | |
| | 120 | | | | | | | | | |
| 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 | | | | | |
| | | | | | | | | | | |

FLAP DISCS

49



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

