

ROUGH GRINDING WHEELS FOR ANGLE GRINDERS

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TYROLIT



27



ROUGH GRINDING WHEELS

APPLICATIONS

Grinding of welds, trimming off, for example, cast workpieces. Grinding of large, heavy machine parts with portable angle grinders.

CONSUMER GROUPS

- Steel construction (boiler construction, industrial, shop, waterway and bridge construction)
- Construction of overhead lines, cranes, containers, scaffolding and roofs
- Terotechnology and machine construction, foundries

The Product

STRUCTURE

The quality of the raw materials (abrasive, bond, fibreglass reinforcement) and the arrangement of the reinforcement determine the efficiency of rough grinding wheels. The patented grinding wheel structure comprising a coarse grain layer (= grinding layer for high stock removal) and fine grain layer (= support layer with optimum embedding of the glass fabrics), as well as the use of special aluminium oxides, ensure a long lifetime.

- Resinoid bond
- Fibre reinforcement
- A = regular aluminium oxide
- ZA = zirconium aluminium oxide
- C = silicon carbide

STANDARD SEGMENTATION (shapes, dimensions)

Shape:	D [mm]	U [mm]	H [mm]	Grain size 30
27E	100	4, 6	16.00	Differentiation in the specifications primarily according to the material to be processed (material, workpiece)
	115	4, 6, 7	22.23	
	125	4, 6, 7	22.23	
	150	4, 7	22.23	
	178	4, 7, 8, 10	22.23	
	230	4, 7, 8	22.23	

REQUIREMENTS

Rough grinding wheels should allow maximum economic efficiency (stock removal rate/time unit and reduction of the total costs of the process), and should also be suitable for machining special materials such as nonferrous metals or cast iron.

Quality

- Considerably longer lifetime with the LONG LIFE type compared with other commercially available rough grinding wheels
- High stock removal values
- Cost reduction due to long lifetime
- No clogging (blunting) of the wheel when using the ALU type

Application Tips

- High-performance LONG LIFE wheel for maximum economic efficiency in edge grinding or welding-seam machining using powerful angle grinders (>2KW)
- High stock removal rate with type 2in1
- For rust and acid-resistant steels - INOX
- For materials that are difficult to machine such as brass, copper, bronze, use the ALU type

MATERIALS, WORKPIECES



LONG LIFE

- Steel/cast steel



- Nonferrous metals



2in1

- Steel/stainless steel



- Cast iron



- Stainless steel



- Stone, concrete



- Cast iron, Steel, Stainless steel

Machine

Single-handed angle grinder: Ø 100,115,125 mm; 500-1400 Watt
 Double-handed angle grinder: Ø 150,180,230 mm; up to 2500 Watt
 Pneumatic grinder



Environment, Ergonomics, Comfort

- Minimum downtime when wheels are replaced
- Low production of waste and therefore a reduction in disposal costs
- Specifications have Fe, S, Cl content $\leq 0.1\%$

Safety Information

























































- $V_s = 80\text{m/s}$ maximum operating speed
- Optimum rough grinding wheel utilisation at angles of 20-30°
- Maximum product safety thanks to special production technology and patented wheel structure

Summary





























The wide spectrum of materials that can be machined and the fulfilment of customer requirements in terms of economic efficiency and environmental compatibility make TYROLIT rough grinding wheels unique.

Application Table: Rough Grinding Wheels





























Premium ★★





MATERIAL							
	Steel materials	Stainless steel	Aluminium	Brass/bronze	Cast materials	Plastics	Stone
A30R-BFX							
A30S-BFX							
A30Q-BFX							
A36N-BFX							
ZA24N-BFX							
ZA24P-BFX							
ZZA24R-BFX							

Standard ★

MATERIAL							
	Steel materials	Stainless steel	Aluminium	Brass/bronze	Cast materials	Plastics	Stone
A30-BF INOX							
A24-BF							
C30-BF							

Basic ★

MATERIAL							
	Steel materials	Stainless steel	Aluminium	Brass/bronze	Cast materials	Plastics	Stone
A30-BF							
WA46-BF							
C30-BF							

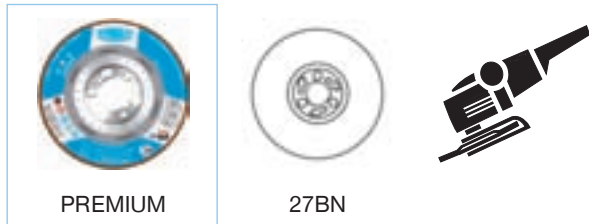
	Extremely suitable	Long lifetime combined with maximum cutting ability
	Suitable	Long lifetime and good cutting ability
	Limited suitability	When used exclusively on these materials, a reduced lifetime or reduced cutting ability (overheating) can be expected
	Not suitable	When used on these materials, this will result in either extremely high layer wear or blunting and overheating of the layer

PREMIUM ★★★ Rough grinding wheels

To ensure work is done without vibration and health risks, all TYROLIT rough grinding wheels are manufactured and tested in accordance with the requirements of EN12413.

A thorough colour guidance system ensures that when it comes to rough grinding wheels too, users can always find the right product for the material to be machined.

The ★★★ range fulfils today's demands of cost-effective working, high stock removal performance and above-average wheel life.



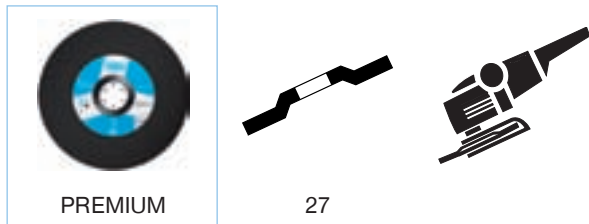
Type No.	Shape	Dimensions	Specification	PU	Comments
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170801	27BN	100x4x22,2	A30Q-BFX *	10	These aggressive, fast rough grinding wheels enable steel and stainless steel (INOX) to be machined.
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*Fe, S, Cl content ≤ 0.1%



2 in 1



Type No.	Shape	Dimensions	Specification	PU	Comments
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5279	27	100x6x16	A30S-BFX	10	High performance rough grinding wheels especially steel, for quick, convenient work.
5288	27	115x4x22,2	A30S-BFX	10	
5294	27	115x7x22,2	A30S-BFX	10	
5306	27	125x4x22,2	A30S-BFX	10	
5314	27	125x7x22,2	A30S-BFX	10	
5331	27	150x7x22,2	A30S-BFX	10	
5350	27	178x4x22,2	A30S-BFX	10	
5363	27	178x7x22,2	A30S-BFX	10	
5384	27	178x8x22,2	A30S-BFX	10	
5396	27	178x10x22,2	A30S-BFX	10	
5407	27	230x4x22,2	A30S-BFX	10	
5413	27	230x7x22,2	A30S-BFX	10	
5429	27	230x8x22,2	A30S-BFX	10	



LONG LIFE

- $v_s = 80$ m/s
- Resinoid bond
- Fibre reinforcement
- Very easy cutting and low vibration
- High product safety

- Patented grinding wheel design
- Grinding angle from 20-30°



PREMIUM



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Type No.	Shape	Dimensions	Specification	PU	Comments	
5270	27	75x6x9,5	A30Q-BFX *	10	High performance rough grinding wheels especially steel and INOX, for quick, convenient work.	
5287	27	115x4x22,2	A30Q-BFX *	10		
5293	27	115x7x22,2	A30Q-BFX *	10		
5308	27	125x4x22,2	A30Q-BFX *	10		
5313	27	125x7x22,2	A30Q-BFX *	10		
5330	27	150x7x22,2	A30Q-BFX *	10		
5349	27	178x4x22,2	A30Q-BFX *	10		
1421	27	178x7x22,2	A30Q-BFX *	10		
5382	27	178x8x22,2	A30Q-BFX *	10		
5406	27	230x4x22,2	A30Q-BFX *	10		
5412	27	230x7x22,2	A30Q-BFX *	10		
5428	27	230x8x22,2	A30Q-BFX *	10		
117058	27	100x6x16	A30R-BFX *	10		The professional rough grinding wheel for machining stainless and acid resistant steel (INOX).
117064	27	115x4x22,2	A30R-BFX *	10		
117065	27	115x7x22,2	A30R-BFX *	10		
117068	27	125x4x22,2	A30R-BFX *	10		
117070	27	125x7x22,2	A30R-BFX *	10		
117071	27	178x4x22,2	A30R-BFX *	10		
117072	27	178x7x22,2	A30R-BFX *	10		
117073	27	230x4x22,2	A30R-BFX *	10		
117074	27	230x7x22,2	A30R-BFX *	10		
5289	27	115x4x22,2	A36N-BFX *	10	High performance rough grinding wheels for grinding non-ferrous metals (NF metals), no smearing or blunting of wheel. For surface and edge grinding.	
5295	27	115x7x22,2	A36N-BFX *	10		
636789	27	125x4x22,2	A36N-BFX *	10		
5316	27	125x7x22,2	A36N-BFX *	10		
5365	27	178x7x22,2	A36N-BFX *	10		
46586	27	230x4x22,2	A36N-BFX *	10		
5416	27	230x7x22,2	A36N-BFX *	10		
466744	27	115x7x22,23	ZA30Q-BFR *	10	High performance rough grinding wheels especially steel, INOX and cast for quick, convenient work.	
466749	27	125x7x22,23	ZA30Q-BFR *	10		
466754	27	178x7x22,23	ZA30Q-BFR *	10		
466762	27	230x7x22,23	ZA30Q-BFR *	10		
458874	42	125x3,5x22,23	TA30P-BFXA	10	Depressed center combination wheels: Aggressive grinding/cutting - longest life. Ideal for most metals, including stainless and other hard alloys, for jobs that require alternating between cutting and weld grinding.	



2 in 1



3 in 1

*Fe, S, Cl content ≤ 0.1%

- $v_s = 80$ m/s
- Resinoid bond
- Fibre reinforcement
- Very easy cutting and low vibration
- High product safety

- Patented grinding wheel design
- Grinding angle from 20-30°

PREMIUM ★★★ EASY CUT Rough grinding wheels

Revolutionary metal removal combined with ultimate wheel life and low vibration made possible due to best running properties.

Innovative machining technology, new wheel structure and a new bond system combined with high quality zirconia alumina abrasives enable unprecedented wheel life and stock removal performance.




PREMIUM Focur extra



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Type No.	Shape	Dimensions	Specification	PU	Comments
233756	27	125x7x22,2	ZA24N-BFX	10	High performance tools for machine all types of cast materials:  ZA24N-BFX: particularly for surface grinding ZA24P-BFX: the universal type ZZA24R-BFX:the deburring specialist
233773	27	125x7x22,2	ZZA24R-BFX	10	
233757	27	178x4x22,2	ZA24N-BFX	10	
233774	27	178x4x22,2	ZZA24R-BFX	10	
233759	27	178x7x22,2	ZA24N-BFX	10	
233768	27	178x7x22,2	ZA24P-BFX *	10	
154544	27	178x7x22,2	ZA30-BF	10	
233776	27	178x7x22,2	ZZA24R-BFX	10	
929018	27	178x7x22,2	ZZA24S-BFX	10	
233760	27	230x4x22,2	ZA24N-BFX	10	
233777	27	230x4x22,2	ZZA24R-BFX	10	
929019	27	230x4x22,2	ZZA24S-BFX	10	
233762	27	230x7x22,2	ZA24N-BFX	10	
233771	27	230x7x22,2	ZA24P-BFX *	10	
154545	27	230x7x22,2	ZA30-BF	10	
233778	27	230x7x22,2	ZZA24R-BFX	10	
929020	27	230x7x22,2	ZZA24S-BFX	10	
233765	27	125x7x22,2	ZA24P-BFX	10	

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- Fibre reinforcement
- Very easy cutting and low vibration
- Patented grinding wheel design

- Grinding angle from 20-30°





PREMIUM



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Type No.	Shape	Dimensions	Specification	PU	Comments
474524	27	178x7x22,23	A30R-BFX	10	New generation of grinding wheels with fixed plastic flansh reduces vibration on the user's body by 50%. Optimised running characteristics. VIB STAR
474526	27	230x7x22,23	A30R-BFX	10	
474527	27	178x7x22,23	ZA24N-BFX	10	 
474528	27	178x7x22,23	ZA24P-BFX *	10	
474529	27	178x7x22,23	ZZA24R-BFX	10	
474532	27	230x7x22,23	ZA24N-BFX	10	
474533	27	230x7x22,23	ZA24P-BFX *	10	
474534	27	230x7x22,23	ZZA24R-BFX	10	

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- $v_s = 80$ m/s
- Resinoid bond
- Fibre reinforcement
- Very easy cutting and low vibration
- Patented grinding wheel design

- Grinding angle from 20-30°

STANDARD ★★ Rough grinding wheels

A clearly set out assortment in the ★★ line and a thorough colour guidance system enables you to find the best suited product. The new specifications on the ★★ line meet all the requirements of ergonomic, convenient and vibration-free rough grinding combined with excellent machining performance and high service life.



Type No.	Shape	Dimensions	Specification	PU	Comments
368002	27	100x6x16	A24-BF	10	Universal rough grinding wheels for use on steel; surface or edge grinding
367377	27	115x6x22,23	A24-BF	10	
367771	27	125x6x22,23	A24-BF	10	
367772	27	150x6x22,23	A24-BF	10	
367773	27	178x6x22,23	A24-BF	10	
367775	27	230x6x22,23	A24-BF	10	
368014	27	100x6x16	A30-BFINOX *	10	Universal rough grinding wheels for use on INOX; surface or edge grinding
367545	27	115x6x22,23	A30-BFINOX *	10	
367548	27	125x6x22,23	A30-BFINOX *	10	
367550	27	150x6x22,23	A30-BFINOX *	10	
367551	27	178x6x22,23	A30-BFINOX *	10	
367553	27	178x8x22,23	A30-BFINOX *	10	
367554	27	230x6x22,23	A30-BFINOX *	10	
367556	27	230x8x22,23	A30-BFINOX *	10	
368008	27	100x6x16	C30-BF	10	Universal rough grinding wheels for soft to hard stone, natural and artificial stone and concrete.
367546	27	115x6x22,23	C30-BF	10	
367549	27	125x6x22,23	C30-BF	10	
367552	27	178x6x22,23	C30-BF	10	
367557	27	230x6x22,23	C30-BF	10	

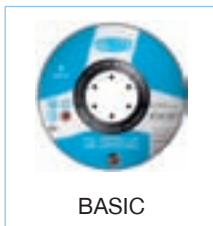
*Fe, S, Cl content ≤ 0.1%

- $v_s = 80$ m/s
- Resinoid bond
- Fibre reinforcement
- Very easy cutting
- High product safety

- Patented grinding wheel design
- Grinding angle from 20-30°

BASIC ★, BASIC ★ FAST CUT, BASIC ★ TOUCH Rough grinding wheels

For all applications and materials including castings and stone.
Rough grinding wheels in the ★ line distinguish themselves by their high stock removal performance and wheel life, easy handling and fast work.






BASIC



27



Type No.	Shape	Dimensions	Specification	PU	Comments
222854	27	100x6x16	A30-BF *	10	TOUCH: Rough grinding wheels for grinding different types of steel materials (incl. stainless steels and cast materials).  2 in 1
222858	27	115x6x22,23	A30-BF *	10	
222860	27	125x6x22,23	A30-BF *	10	
222861	27	150x6x22,23	A30-BF *	10	
222863	27	178x6x22,23	A30-BF *	10	
222868	27	178x8x22,23	A30-BF *	10	
222865	27	230x6x22,23	A30-BF *	10	
222870	27	230x8x22,23	A30-BF *	10	
222872	27	100x6x16	C30-BF	10	TOUCH: For grinding stone and concrete. 
222873	27	115x6x22,23	C30-BF	10	
222889	27	125x6x22,23	C30-BF	10	
222892	27	150x6x22,23	C30-BF	10	
222043	27	178x6x22,23	C30-BF	10	
222898	27	230x6x22,23	C30-BF	10	
297324	27	100x6x16	A30-BF *	10	FAST CUT: Aggressive and easy cutting - more stock removal in the shortest of times (all steel and stainless steel materials).  2 in 1 FAST CUT
297325	27	115x6x22,23	A30-BF *	10	
297327	27	125x6x22,23	A30-BF *	10	
297329	27	150x6x22,23	A30-BF *	10	
297331	27	178x6x22,23	A30-BF *	10	
297333	27	230x6x22,23	A30-BF *	10	

*Fe, S, Cl content ≤ 0.1%

- $v_s = 80$ m/s
- Resinoid bond
- Fibre reinforcement
- Very easy cutting
- High product safety

- Patented grinding wheel design
- Grinding angle from 20-30°



BASIC



29T



Type No.	Shape	Dimensions	Specification	PU	Comments
236318	29T	115x22,23	WA46-BF *	25	Aggressive and easy cutting - semi-flexible roughing wheel for machining all steel materials (incl. stainless steel) and non-ferrous metals (aluminium, copper, bronze etc.).
236319	29T	125x22,23	WA46-BF *	25	
236320	29T	178x22,23	WA46-BF *	25	

**2 in 1**

*Fe, S, Cl content \leq 0.1%

- $v_s = 80$ m/s
- Resinoid bond
- Fibre reinforcement
- Very easy cutting
- High product safety

- Patented grinding wheel design
- Grinding angle from 20-30°

