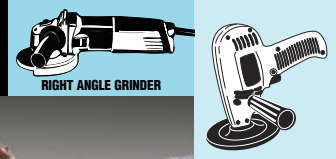


FLAP DISCS



RIGHT ANGLE GRINDER

VERTICAL SHAFT GRINDER

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 fibre disc to reduce process time and lower total grinding costs.

Typical Applications

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



NORTON TYPE 29
MERIT TYPE 27C (CONICAL)



TYPE 27



NORTON TYPE 27 JUMBO
MERIT HIGH DENSITY



BEST TwinFiber Type 29 Flap Discs – For maximum stock removal

expanded offering!

FEATURES	BENEFITS
• Premium ceramic and zirconia alumina abrasives blend	• Excellent performance and efficiencies on stainless and carbon 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
• New 4-1/2" and 7" with 5/8-11 hub	• Less downtime for disc changes
• New 5" and 6" with 7/8 hole	• Support increasing volume of 5" and 6" tools



BEST TwinStar Type 27 Flap Discs – For fine finishes

expanded offering!

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



BETTER Charger R822 Type 29, Type 27 and Type 27 Jumbo Flap Discs

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



GOOD Norton R265 A/O Type 27 Flap Discs – Great value

new!

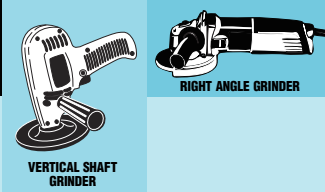
FEATURES	BENEFITS
• Durable aluminum oxide grain with Y-weight cotton on a nylon back; "flat design"	• Fast initial cut rate, especially on carbon steel
	• Smooth cutting action; excellent finish
	• Great value for all MRO operations



GOOD Merit Type 27C, Type 27 HD, Mini – Fast stock removal with fine finishes

FEATURES	BENEFITS
• High performance zirconia alumina grain with a phenolic resin back	• Fast cutting; fine finishes

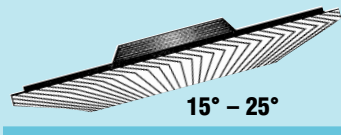




Two Basic Flap Disc Designs

Norton Type 29 Conical / Merit Type 27C Conical THE MOST AGGRESSIVE CHOICE

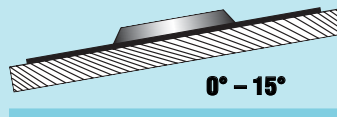
- Conical flap discs have flaps angled at 10 degrees and may be used on both conical and flat surfaces
- The angle provides greater surface contact and as a result, tends to be the most aggressive choice
- The best choice when speed is a primary consideration



GRIND AT
STEEPER ANGLES

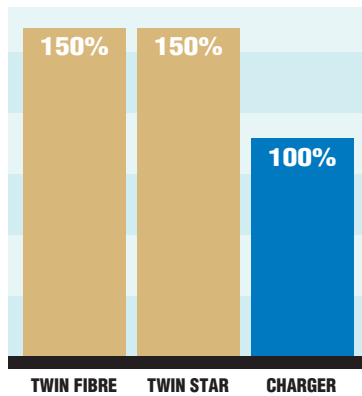
Norton and Merit Type 27 Flat THE CHOICE FOR THE BEST FINISH

- The Type 27 flap disc has a flat design and is used primarily on flat surfaces
- The best choice for smooth finishing
- 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

Relative Flap Disc Life



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 fibre discs, except in 36 grit.



It is the user's responsibility to refer to and comply with ANSI B7.1

SPECcheck

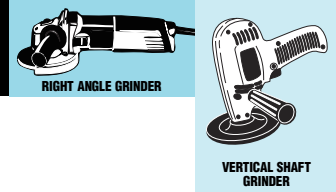



Flap Disc Starting Recommendations by Material


MATERIAL	HEAVY-DUTY / AGGRESSIVE STOCK REMOVAL	FINE FINISHING
Carbon and stainless steel	TwinFiber Type 29	TwinStar Type 27
Other ferrous and nonferrous materials	Charger R822 Type 29	Charger Type 27

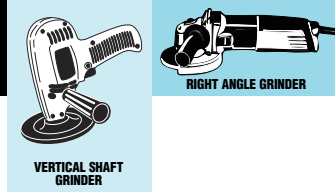
Flap Disc Competitive Cross Reference

NORTON	DEWALT	GARRYSOON	GEMTEX	KLINGSPOR	PFERD	SAIT	3M	WALTER	WEILER
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
Norton R265 A/O		A/O	A/O			Saitlam 2A			



SIZE	GRIT	MAX. RPM	STD. PKG.	BEST		BETTER		GOOD	
				TYPE 29 TWINFIBER UPC NO.	STD. PKG.	TYPE 29 CHARGER R822 UPC NO.	STD. PKG.	TYPE 27C CONICAL MERIT POWERFLEX UPC NO.	
TYPE 29 									
4 X 5/8	36 40 60 80 120	13,000			5	66261119265 66261119264 66261119263 66261119262 66261119261			
4-1/2 X 5/8-11	24 36 40 60 80 120	13,000	5	63642536156 63642536157 63642536158	5	66261121291 66261121290 66261121289 66261121288 66261121287 66261121286	10	08834194803 08834194804 08834194805	
4-1/2 X 7/8	24 36 40 60 80 120	13,000	10	63642504329 63642504330 63642504331 63642504332 63642504333	5	66261119271 66261119270 66261119269 66261119268 66261119267 66261119266	10	08834194296 08834194766 08834194767 08834194768	
5 X 7/8	24 36 40 60 80 120	12,000	10	63642541413 63642541414 63642541415	5	66261119277 66261119276 66261119275 66261119274 66261119273 66261119272	10	08834193649 08834193650 08834193651 08834193652	
6 X 7/8	40 60 80	10,200	10	63642541406 63642541407 63642541408					
7 X 5/8-11	24 36 40 60 80 120	8,500	10	63642536159 63642536160 63642536161	5	66261119289 66261119288 66261119287 66261119286 66261119285 66261119284	10	08834197210 08834197212 08834197213	
7 X 7/8	24 36 40 60 80 120	8,500	10	63642504334 63642504335 63642504336 63642504337 63642504338	5	66261119283 66261119282 66261119281 66261119280 66261119279	10	08834197194 08834197195 08834194777 08834197199 08834197204	

SIZE	GRIT	MAX. RPM.	STD. PKG.	BETTER		GOOD	
				TYPE 27 JUMBO CHARGER R822 UPC NO.	STD. PKG.	TYPE 27 HIGH DENSITY MERIT POWERFLEX UPC NO.	
TYPE 27 JUMBO / HIGH DENSITY 							
4-1/2 X 5/8-11	40 60 80	13,000	5	63642503527 63642503528 63642503529			
4-1/2 X 7/8	40 60 80	13,000	5	63642503531 63642503532 63642503533	10	08834190172 08834190767 08834194360	
7 X 5/8-11	40 60 80	8,500	5	63642503539 63642503540 63642503541			
7 X 7/8	40 60 80	8,500	5	63642503535 63642503536 63642503537	10	08834190933 08834194514 08834194362	



SIZE	GRIT	MAX. RPM.	STD. PKG.	BEST		BETTER		GOOD	
				TYPE 27 TWINSTAR UPC NO.	STD. PKG.	TYPE 27 CHARGER R822 UPC NO.	STD. PKG.	TYPE 27 NORTON R265 A/O UPC NO.	TYPE 27 MERIT POWERFLEX UPC NO.
TYPE 27									
2" TYPE II TURN-ON	36 40 60 80 120	24,000						10	08834195020 08834195021 08834195022 08834195023 08834195024
3" TYPE II TURN-ON	36 40 60 80 120	20,000						10	08834195035 08834195036 08834195037 08834195038 08834195039
4 X 5/8	40 60 80	13,000	10	63642536153 63642536154 63642536155					
4-1/2 X 5/8-11	36 40 60 80	13,000	5	63642536147 63642536148 63642536149	5	63642503510 63642503511 63642503512 63642503513			
4-1/2 X 7/8	36 40 60 80 120	13,000	10	63642504876 63642504877 63642504878 63642504879 63642505279	5	66261134069 66261134070 66261134071	10	63642540602 63642540603 63642540604 63642540605	
5 X 7/8	36 40 60 80 120	12,000	10	63642505281 63642505282 63642505283 63642505284 63642505285	5	63642503515 63642503516 63642503517	10	63642540617 63642540618 63642540619 63642540620	
7 X 5/8-11	36 40 60 80	8,500	5	63642536150 63642536151 63642536152	5	63642503518 63642503519 63642503520 63642503521			
7 X 7/8	36 40 60 80 120	8,500	10	63642504880 63642504881 63642504882 63642504883 63642505280	5	66261134072 66261134073 66261134074	10	63642540606 63642540607 63642540608 63642540609	

FLAP DISCS

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Mini Powerflex Holder



DESCRIPTION	STD. PKG.	UPC NO.
MINI POWERFLEX TYPE III HOLDER	1	08834160172
FIT 2" AND 3" MERIT FLAP DISCS		