

CATEGORY DEFINITION

Made from non-woven synthetic fiber mesh, which is impregnated with abrasives and bound with resins, non-woven wheels are designed to create desired surface finish where little or no stock removal is required. The industry's broadest offering is available for light stock removal, deburring, blending, finishing and polishing.

Non-woven wheels have an open mesh construction that is waterproof, washable, conformable and non-loading.

APPLICATIONS: Cleaning and removing imperfections on metal surfaces, cleaning built-up residue, deburring or finishing a variety of surfaces, blending weld seams or creating decorative finishes. Non-woven surface finishing products have excellent versatility.

ABRASIVE GRAIN: Aluminum Oxide, Silicon Carbide

GRIT RANGE: Extra Coarse (XC), Coarse (C), Medium (M), Fine (F),



APPLICATION/GRIT RECOMMENDATION GUIDE

NORTON	MOST AGGRESSIVE ← → LEAST AGGRESSIVE						
	RAPID STRIP WHEELS	RAPID BLEND UNIFIED WHEELS	SERIES 4000 & 1000 CONVOLUTE WHEELS	METAL FINISHING CONVOLUTE WHEELS	CLEAN & FINISH CONVOLUTE WHEELS	LIGHT FINISHING CONVOLUTE WHEELS	NON-WOVEN / INTERLEAF FLAP WHEELS
SCALE REMOVAL	BEST CHOICE						
STOCK REMOVAL		BEST CHOICE	2ND CHOICE				
HEAVY DEBURRING		BEST CHOICE	2ND CHOICE				
DECORATIVE FINISHING				BEST CHOICE	2ND CHOICE		
BLENDING			BEST CHOICE	2ND CHOICE			
CLEANING				2ND CHOICE	BEST CHOICE		
LIGHT DEBURRING			2ND CHOICE			BEST CHOICE	
LIGHT FINISHING			2ND CHOICE			BEST CHOICE	
POLISHING						BEST CHOICE	2ND CHOICE
BUFFING							BEST CHOICE

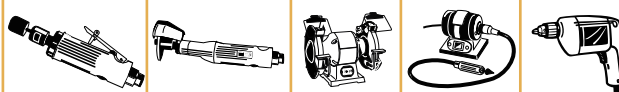
SURFACE FINISH VARIABLES

Changes in any one of many factors can affect the surface finish on the workpiece. 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. Wheel Speed	Slow	Fast
2. Feed Speed	Faster (Long Scratch)	Slower (Short Scratch)
3. Oscillation	No Oscillation	Oscillation
4. Lubricants	Dry	Water
	Soluble Oil	Straight Oil
	Compounds	

NON-WOVEN MARKING SYSTEM

ABRASIVE	S/C	A/O		
	SHARPER, FINER/BRIGHTER SCRATCH PATTERN	MORE DURABLE, LONGER LASTING, POLISHED FINISH		
GRIT SIZE	XC (24-36)	C (50-80)	M (100-150)	F (180-220)
	FASTER, AGGRESSIVE CUT, ROUGHER FINISH			REDUCED CUT RATE, FINER FINISH
DENSITY	2	9		
	SOFT, OPEN, CONFORMABLE, LESS BURNING/LOADING	HARDER, MORE DURABLE, FASTER CUTTING, BETTER FINISH		



CROSS REFERENCE GUIDE

	STRIPPING	HEAVY/LIGHT DEBURRING	LIGHT DEBURRING/BLENDING/POLISHING				CLEANING/FINISHING		
NORTON	GOOD Rapid Strip	BEST Vortex Rapid Blend	GOOD NEX Rapid Blend	BEST Series 4000	BETTER Series 1000	BEST Light Finishing	BEST Metal Finishing	BEST Clean & Finish	GOOD Non-Woven / Interleaf Flap Wheels
3M	Clean Strip	Cut & Polish Unitized	EXL Unitized	EX2 & EX3	EXL Deburring	Light Deburring	Metal Finishing	Multi Finishing	Finishing Flap Brush
Standard	Britestrip	800 & 900 Series	500 - 700 Series	GP Plus	Deburring Convolute	LDW	Metal Finishing	Multi Finishing	Buff & Blend Flap Brush

Rapid Strip Wheels



NORTON RAPID STRIP WHEELS

IDEAL FOR REMOVING COATINGS ON A VARIETY OF SUBSTRATES, SUCH AS WOOD, METAL AND PLASTICS

FEATURES

- Extruded nylon fibers, flexible resin technology, and extra-coarse silicon carbide mineral

BENEFITS

- Provide a unique combination of aggressive performance, long life, and improved finish while outperforming traditional coated abrasives
- Leave a thoroughly cleaned surface that ensures excellent adhesion for subsequent processes such as coating, painting and soldering.

AVAILABILITY

TIER:	GOOD
BRAND:	Norton
TRADENAME:	RAPID STRIP WHEELS
GRIT:	Extra Coarse

SIZE	MAX. RPM	STD. PKG.	PART #
Arbor Hole			
4 x 1/4	8,000	25	66261008008
4 x 1/2	8,000	25	66261007916
6 x 1/2	5,500	15	66261008051

Rapid Blend Unified Wheels

Designed for maintenance operations needing an efficient and cost-effective method of deburring, polishing, cleaning or finishing metals and composites. Easily preformed for use on a wide variety of shapes/contours. Hold shape well; less wheel dressing. Non-metallic so no contamination of workpiece. Uniform construction maintains part tolerance; prevents cutting or gouging.



NORTON VORTEX RAPID BLEND UNIFIED WHEELS

BETTER CHOICE FOR LIGHT WELD BEAD AND WELD SPLATTER REMOVAL, HEAVY DEBURRING AND FINISHING APPLICATIONS

FEATURES

- High-performance engineered grain and improved resin bond system
- Thick nylon web
- Controlled porosity

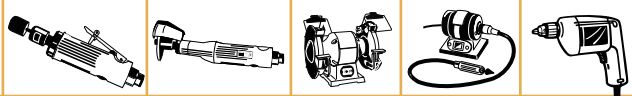
BENEFITS

- Aggressive, fast, stock removal, reduced cycle times, and increased part quality
- 2X longer life and faster finishing – with minimal shedding
- Cool cutting and improved cut rate

AVAILABILITY

TIER:	BETTER
BRAND:	Norton
TRADENAME:	VORTEX RAPID BLEND UNIFIED WHEELS

SIZE (D x T x H)	ABRASIVE	GRIT SIZE	STD. PKG.	MAX. RPM	3 DENSITY PART #	MAX. RPM	5 DENSITY PART #	MAX. RPM	7 DENSITY PART #	MAX. RPM	9 DENSITY PART #
2 x 1/8 x 1/8	A/O	M	60			22,000	66254425657	20,000	66254410849		
2 x 1/8 x 1/4	A/O	M	60			22,000	66254406346	22,000	66261191446		
2 x 1/4 x 1/4	A/O	M	60	18,000	66254428456	22,000	66254433504	22,000	66261080270		
2 x 1 x 1/4	A/O	M	15					22,000	66261080269		
3 x 1/8 x 1/4	A/O	M	40			18,000	66261093448	18,000	66261191445		
3 x 1/8 x 3/8	A/O	M	40			18,000	66254433503	18,000	66254401131		
3 x 1/4 x 1/4	A/O	M	40	12,000	66254428454	18,000	66254414832	18,000	66261199696		
3 x 1/4 x 3/8	A/O	M	40	12,000	66254433505	12,000	66254433506	18,000	66261199697		
3 x 1/2 x 1/4	A/O	M	20			18,000	66254432925	18,000	66261080267	18,000	66254433507
3 x 1/2 x 3/8	A/O	M	20			18,000	66254433508	18,000	66261080266	18,000	66254420696



Rapid Blend Unified Wheels CONTINUED



NORTON NEX RAPID BLEND WHEELS
GOOD CHOICE FOR LIGHT DEBURRING AND BLENDING

FEATURES

- Uniform construction
- Smear-resistant formula

BENEFITS

- Extra long life
- Excellent, consistent, smear-free finishes

AVAILABILITY

TIER:

GOOD

BRAND:

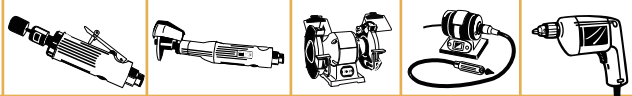
Norton

TRADENAME:

NEX RAPID BLEND UNIFIED WHEELS

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	2 DENSITY PART #	3 DENSITY PART #	4 DENSITY PART #	6 DENSITY PART #	7 DENSITY PART #	8 DENSITY PART #	
1 x 1 x 3/16	A/O	C	30,000	50						66261014915	
	A/O	M	18,000	50	66261014891						
	A/O	M	30,000	50				66261014908		66261014924	
	A/O	F	30,000	50				66261014900			
	S/C	F	18,000	50	66261014883						
2 x 1/8 x 1/4	S/C	F	30,000	50				66261014904		66261014923	
	A/O	M	22,000	60						66261014927	
	2 x 1/4 x 1/4	A/O	C	22,000	60					66261014916	
	A/O	M	18,000	60	66261014892						
	A/O	M	22,000	60						66261014926	
2 x 1/4 x 1/4	A/O	M	22,000	60				66261014901			
	A/O	F	22,000	60							
	S/C	M	22,000	60						66261014964	
	S/C	F	18,000	60	66261014884						
	2 x 1/2 x 1/4	A/O	M	22,000	30						66261014925
3 x 1/8 x 1/4	A/O	M	18,000	40						66261014934	
3 x 1/4 x 1/4	A/O	C	18,000	40						66261014919	
	A/O	M	12,000	40	66261014894						
	A/O	M	18,000	40				66261014909		66261014930	
	A/O	F	18,000	40			66261015565	66261014902			
	S/C	M	18,000	40						66261014937	
3 x 1/4 x 3/8	S/C	F	12,000	40	66261014886	66261016392					
	A/O	C	18,000	40						66261014920	
	A/O	M	12,000	40	66261014895						
	A/O	M	18,000	40				66261014910		66261014933	
	A/O	F	12,000	40			66261014899				
3 x 1/4 x 1/4	S/C	M	18,000	40						66261014965	
	S/C	F	12,000	40	66261014887	66261016006					
	S/C	F	18,000	40				66261014905			
	3 x 1/2 x 1/4	A/O	C	18,000	20						66261014917
	A/O	M	12,000	20	66261014893						
3 x 1/2 x 3/8	A/O	M	18,000	20				66261014928			
	A/O	M	18,000	20						66261014918	
	S/C	XC	14,000	20						66261014929	
3 x 1 x 3/8	S/C	XC	14,000	10					66261014914		
6 x 1/2 x 1	A/O	M	7,500	4						66261014931	
6 x 1 x 1	A/O	M	5,000	2	66261014896						
	S/C	F	5,000	2	66261014888						





Rapid Blend Unified Wheels CONTINUED



AVAILABILITY

NORTON RAPID BLEND DEBURRING UNIFIED WHEELS
GOOD STARTING SPECIFICATION FOR HIGH-SPEED DEBURRING APPLICATIONS

FEATURES

■ Controlled density range

BENEFITS

■ More durable than General Duty Wheels

TIER: **GOOD**

BRAND: Norton

TRADENAME: **RAPID BLEND DEBURRING
UNIFIED WHEELS**

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	PART #
2 x 1/4 x 1/4	A/O	220	20,000	60	66261052200
2 x 1/2 x 1/4	A/O	120	20,000	40	66261058876
	S/C	220	20,000	40	66261058782
3 x 1/4 x 1/4	A/O	220	18,000	40	66261058877
	S/C	220	18,000	40	66261058854
3 x 1/2 x 1/4	S/C	220	18,000	20	66261058859
3 x 3/4 x 1/4	A/O	220	18,000	20	66261058881



AVAILABILITY

NORTON RAPID BLEND GENERAL DUTY DEBURRING UNIFIED WHEELS
GOOD CHOICE FOR GENERAL PURPOSE LIGHT DEBURRING APPLICATIONS

FEATURES

■ Outstanding resistance to snagging

BENEFITS

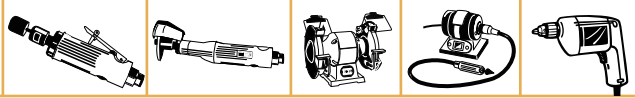
■ For general purpose light deburring applications

TIER: **GOOD**

BRAND: Norton

TRADENAME: **RAPID BLEND
GENERAL DUTY UNIFIED WHEELS**

SIZE (D x T x H)	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #
1 x 1 x 3/16	A/O	C	8	15,000	50	66261000938
2 x 1/4 x 1/4	A/O	C	8	11,000	60	66261052275
2 x 1/2 x 1/4	A/O	F	4	11,000	40	66261058764
3 x 1/4 x 1/4	A/O	C	8	8,000	40	66261052276
	A/O	F	4	8,000	40	66261058816
	S/C	F	4	8,000	40	66261000745
3 x 1/2 x 1/4	A/O	F	4	8,000	20	66261054046
	S/C	F	4	8,000	20	66261054048
3 x 3/4 x 1/4	A/O	F	4	8,000	20	66261058769
	S/C	M	4	8,000	20	66261058773
	S/C	F	4	8,000	20	66261058771
6 x 1/2 x 1/2	S/C	M	4	4,800	8	66261058779
6 x 1 x 1/2	S/C	M	4	4,800	4	66261058792
	S/C	F	4	4,800	4	66261058790
6 x 1 x 1	S/C	F	4	4,800	4	66261058797



Mandrels for Unified Wheels

FITS WHEEL CENTER HOLE	FOR WHEEL WIDTH	FOR WHEEL DIAMETER	SHANK DIAMETER	OVERALL LENGTH	WASHER DIAMETER	3M EQUIVALENT	STD. PKG.	PART #
Mandrel Assemblies for Unified Wheels and Discs on Edge								
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

FOR CENTER HOLE	USE WITH UNIFIED WHEEL	SHANK DIAMETER	SHANK LENGTH	3M EQUIVALENT	STD. PKG.	PART #
Threaded Mandrel for Unified Wheels						
3/16	1 x 1 x 3/16	1/4"	1-3/4"	948	5	66261047584



MANDREL ASSEMBLY 66261059421



MANDREL ASSEMBLY 66261059422



THREADED MANDREL 66261047584





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:

- 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

TECHtip

- 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 refer to and comply with all safety regulations.

FEATURED PRODUCTS



SERIES 4000 RAPID FINISH CONVOLUTE WHEELS

BEST CHOICE FOR HEAVY DEBURRING APPLICATIONS

FEATURES

- Advanced resin bond system
- High quality synthetic web

BENEFITS

- Free cutting
- Use both wet and dry
- Long life for heavy deburring, edge breaking and removing parting lines on exotic metals

AVAILABILITY

TIER:

BEST

BRAND:

Norton

TRADENAME:

SERIES 4000 RAPID FINISH CONVOLUTE WHEELS

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	8 DENSITY PART #	9 DENSITY PART #
Series 4000 Rapid Finish Convolute Wheels						
6 x 1/2 x 1	S/C	F	6,000	4		66261004021
6 x 1 x 1	A/O	M	6,000	3	66261004208	
	S/C	F	6,000	3	66261004142	66261004141
8 x 1 x 3	A/O	M	4,500	3	66261004165	
	S/C	F	4,500	3	66261004123	66261004135
12 x 1 x 5	S/C	F	3,000	2	66261004284	66261004148
12 x 2 x 5	S/C	F	3,000	1		66261004011



BEAR-TEX[®]



Convolute Wheels CONTINUED



SERIES 1000 LONG LIFE RAPID FINISH CONVOLUTE WHEELS
BETTER CHOICE FOR GENERAL DEBURRING, BLENDING, AND FINAL 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-resistant 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

AVAILABILITY

TIER:	BETTER
BRAND:	Norton
TRADENAME:	SERIES 1000 LONG LIFE RAPID FINISH CONVOLUTE WHEELS

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	7 DENSITY PART #	8 DENSITY PART #	9 DENSITY PART #
Series 1000 Long Life Rapid Finish Convolute Wheels							
6 x 1/2 x 1	A/O	M	6,000	4	66261018857	66261018789	66261018650
	S/C	M	6,000	4			66261019540
	S/C	F	6,000	4	66261018628		66261018629
6 x 1 x 1	A/O	M	6,000	3	69957397884	66261018636	66261019337
	S/C	M	6,000	3	69957397882	69957397883	66261018630
	S/C	F	6,000	3	66261018631	66261018774	66261018632
8 x 1 x 3	A/O	M	4,500	3	69957397885	66261018855	66261018633
	S/C	M	4,500	3	69957394610	66261018673	66261018997
	S/C	F	4,500	3	66261018639	66261018640	66261018641
12 x 1 x 5	A/O	M	3,000	2	69957397887		66261018896
	S/C	M	3,000	2		66261018786	66261018908
	S/C	F	3,000	2			66261018626



LIGHT FINISHING CONVOLUTE WHEELS
BEST CHOICE FOR LIGHT DEBURRING, POLISHING, AND FINE FINISHING APPLICATIONS

FEATURES	BENEFITS
■ Controlled cut rate	■ Prevents "over benching"
	■ Deburrs and polishes without altering geometry
■ Very conformable	■ Operator friendly, reduces fatigue
■ Superior form holding	■ Consistent, reliable edge breaking and finishing with minimal wheel dressing and reshaping
	■ Less dust and shedding with more uniform wear
■ Durable resin bond system	■ Substantial extended wheel life in a soft, conformable wheel
■ Advanced manufacturing process	■ Improved web forming and grain distribution produce consistent finish on intricate polishing applications

AVAILABILITY

TIER:	BEST
BRAND:	Norton
TRADENAME:	LIGHT FINISHING CONVOLUTE WHEELS

SIZE (D x T x H)	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	6 DENSITY PART #	7 DENSITY PART #	8 DENSITY PART #
Light Finishing Convolute Wheels							
6 x 1/2 x 1	S/C	F	6,000	4	66261092322	66261092324	66254421572
6 x 1 x 1	S/C	F	6,000	3	66254403708	66254403709	66254421573
8 x 1/2 x 3	S/C	F	4,500	4	66254403707	66254409698	66254421575
8 x 1 x 3	S/C	F	4,500	3	66261095702	66254409924	66254421577



Convolute Wheels CONTINUED



METAL FINISHING CONVOLUTE WHEELS

BEST CHOICE FOR DECORATIVE FINISHING, BLENDING, AND FINAL FINISHING

FEATURES

- Premium, medium grit aluminum oxide grain
- Dense, very durable web
- Strongest resin binders
- Uniform grain dispersion and coating
- Available in 5 and 6 densities

BENEFITS

- Generates uniform distinct satin and antique finishes
- Can be used for blending applications
- Resilient, long life construction
- Clean and condition without gouging or changing dimensions of workpiece
- Ideal for blending and matching #3 and 4 mil. finishes, and surface prep for buffing, polishing and applying decorative finishes

AVAILABILITY

TIER: **BEST**

BRAND: Norton

TRADENAME: **METAL FINISHING
CONVOLUTE WHEELS**

SIZE (D x T x H)	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #
Metal Finishing Convolute Wheels						
6 x 1 x 1	A/O	M	5	6,000	3	66261007936
		M	6	6,000	3	66261010148
6 x 2 x 1	A/O	M	5	6,000	2	66261007957
		M	6	6,000	2	66261009635
8 x 1 x 3	A/O	M	5	4,500	3	66261007831
8 x 2 x 3	A/O	M	5	4,500	2	66261007904
		M	6	4,500	2	66261012971
12 x 1 x 5	A/O	M	5	3,000	2	66261007434
		M	6	3,000	2	66261009481
12 x 2 x 5	A/O	M	5	3,000	1	66261007212
14 x 2 x 8	A/O	M	5	2,550	1	66261007817
		M	6	2,550	1	66261012041



CLEAN & FINISH CONVOLUTE WHEELS

BEST CHOICE FOR FINE FINISHING WITH LIGHT PRESSURE

FEATURES

- Silicon carbide grain
- Open mesh construction

BENEFITS

- Good for blending, rust removal, applying decorative, contrast finishes and low- to moderate-speed applications
- Not used for deburring
- Used with light to moderate pressure, low speed

AVAILABILITY

TIER: **BEST**

BRAND: Norton

TRADENAME: **CLEAN & FINISH
CONVOLUTE WHEELS**

SIZE (D x T x H)	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	PART #
Clean & Finish Convolute Wheels						
4 x 1 x 1	S/C	M	4	4,000	10	66261058502
		F	4	4,000	10	66261058501
6 x 1 x 1	S/C	M	4	3,000	4	66261058507
		F	4	3,000	4	66261058506
6 x 2 x 1	S/C	M	4	3,000	2	66261058510
		F	4	3,000	2	66261058509
6 x 3 x 1	S/C	M	4	3,000	1	66261058512
6 x 4 x 1	S/C	M	4	3,000	1	66261058514
8 x 1 x 3	S/C	M	4	2,500	3	66261058518
8 x 2 x 3	S/C	M	4	2,500	2	66261058521
8 x 3 x 3	S/C	M	4	2,500	1	66261058524
8 x 4 x 3	S/C	M	4	2,500	1	66261058526





Aluminum Reducing Bushings for Flap and Convolute Wheels



- Durable, aluminum one-piece-design flanges with integrated “contact washer”
- Snug fit; extended usable 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.	PART #
Aluminum Reducing Bushing for Flap and Convolute Wheels				
1	3/8	4 - 6	1 Pair	66261080522
	1/2	4 - 6	1 Pair	66261080523
	5/8	4 - 6	1 Pair	66261080524
	3/4	4 - 6	1 Pair	66261080525
	7/8	4 - 6	1 Pair	66261080526
2	1/2	6	1 Pair	66261080527
	5/8	6	1 Pair	66261080528
	1	6	1 Pair	66261080529
	1-1/4	6	1 Pair	66261080530
3	1	8	1 Pair	66261080531
	1-1/4	8	1 Pair	66261080532
	1-1/2	8	1 Pair	66261080383
	2	8	1 Pair	66261080514
5	1	10 and 12	1 Pair	66261080533
	1-1/4	10 and 12	1 Pair	66261080534
	3	10 and 12	1 Pair	66261080535
8	1-1/4	14	1 Pair	66261080536
10	1-1/4	16	1 Pair	66261080520

