

ATORN® Rough grinding discs for steel/cast iron

Type A 24 Q-BF 725

Application:

For deburring, chamfering, fettling and for preparatory and finishing work on weld seams.

Advantage:

- Hard version - ideal for grinding edges
- High removal rate with long service life

Technical data:

- Washer thickness: 7.0 mm
- Bore diameter: 22.23 mm
- Version: Hard
- Form: Cranked
- Free from iron and sulphur: No



Ident. No. 115-125

Washer Ø (mm)	115	125	180	230
Max. rotation speed (U/min(rpm))	13285	12200	8600	6600
Number of pieces per packet (PCS)	25	25	10	10
76100... Ident. No.	115	125	180	230

Prod. Gr. 6CH

3M Cubitron II rough grinding discs for steel/stainless steel

With sharp precision grain

Application:

For deburring, chamfering, fettling and for preparatory and finishing work on weld seams.

Advantage:

- Higher removal rate with the same expenditure of energy and longer service life thanks to sharp precision grain

Technical data:

- Washer thickness: 7.0 mm
- Bore diameter: 22.23 mm
- Version: Hard
- Form: Cranked
- Number of pieces per packet: 20 PCS



Ident. No. 126

Washer Ø (mm)	115	125	180	230
Max. rotation speed (U/min(rpm))	13300	12250	8500	6650
76105... Ident. No.	116	126	181	231

Prod. Gr. 6DM

RHODIUS Rough grinding disc for aluminium/non-ferrous metals

Type A 24 N-BF 28

TOPLINE

Application:

For deburring, chamfering and pre/post-machining of welding seams.

- High cutting performance
- Minimal heat generation

Technical data:

- Washer thickness: 7.0 mm
- Bore diameter: 22.23 mm
- Version: Medium hard
- Form: Cranked



Ident. No. 103

Washer Ø (mm)	115	125	180
Max. rotation speed (U/min(rpm))	13285	12200	8600
Number of pieces per packet	25	25	10
76102... Ident. No.	100	103	106

Prod. Gr. 6BB

RHODIUS XTK 35 Cross cutting and sanding discs

Type A 46 U 9 BF 1432, for stainless steel

TOPLINE

Application:

For cutting, deburring, chamfering and grinding as well as for preparatory and finishing work on weld seams.

Advantage:

- Cutting and grinding work in a single operation. Saves time and costs: no work interruptions due to conversion or machine changes
- Protection against age-related power loss thanks to HydroProtect formula

Technical data:

- Washer thickness: 1.9 mm
- Bore diameter: 22.23 mm
- Version: Hard
- Free from iron and sulphur: Yes
- Number of pieces per packet: 25 PCS



Washer Ø (mm)	Max. rotation speed (U/min(rpm))	Form	Cranked
115	13285	76099... Ident. No.	115
125	12200		125

Prod. Gr. 6BB

Source: Hahn+Kolb Werkzeuge GmbH
Technical data subject to change.
Availability subject to country specific rules and regulations

www.iconridge.com

ATORN® Cutting discs for stainless steel – extra thin Type A 46 U9 BF 725

Application:

For burr-free cutting of thin-walled pipes, sheet steel and profiles.

Advantage:

- Very hard cutting disc for extremely short cutting times

Technical data:

- Bore diameter: 22.23 mm
- Version: Very hard
- Free from iron and sulphur: Yes



Ident. No. 125

Washer Ø (mm)	Washer thickness (mm)	Max. rotation speed (U/min(rpm))	Number of pieces per packet (PCS)	Form	
				Straight	
115	1.0	13300	50	76116...	Ident. No.
115	1.5	13300	50	115	•
125	1.0	12250	50	116	•
125	1.5	12250	50	125	•
180	1.5	8500	25	126	•
230	1.9	6650	25	180	•
				230	•

Prod. Gr. 6CH

ATORN® Cutting discs for stainless steel – ultra thin Type 41 A60R BF

Application:

Ideal for cutting of thin-walled metal plates, profiles, tubes, rods and solid material.

Advantage:

- Maximum cost-effectiveness due to longer life span and improved cutting ability
- Reduced working hours since subsequent cleaning or deburring is no longer necessary

- 30% less dust production as well as additional noise and vibration damping ensure maximum working comfort

Technical data:

- Washer thickness: 0.75 mm
- Bore diameter: 22.23 mm
- Version: Very hard
- Free from iron and sulphur: Yes
- Number of pieces per packet: 25



Washer Ø (mm)	Max. rotation speed (U/min(rpm))	Form		Cranked	
		Straight		Ident. No.	
115	13300	76116...	Ident. No.	315	•
125	12250	325	•	415	•
				425	•

Prod. Gr. 6CH

RHODIUS XTK 6 EXACT cutting discs for stainless steel – ultra thin

TOP LINE ●●●

Application:

Specially designed for almost burr-free and cool cutting of thin-walled materials

- Minimum burr formation and the clean cut make time-consuming re-working unnecessary

Technical data:

- Washer thickness: 0.6 mm
- Bore diameter: 22.23 mm
- Version: Very hard
- Free from iron and sulphur: Yes
- Number of pieces per packet: 50 PCS



Ident. No. 005

Washer Ø (mm)	Max. rotation speed (U/min(rpm))	Form		Cranked	
				Ident. No.	
115	13285	76114...	Ident. No.	000	•
125	12200	005	•	005	•

Prod. Gr. 6BB

RHODIUS XT 38 INOX cutting discs Type A 46 T 11 BF 1415

PRO LINE ●●○

Application:

For cutting sheet metal, pipes, steel sections and solid material.

Technical data:

- Bore diameter: 22.23 mm
- Version: Hard
- Free from iron and sulphur: Yes

Advantage:

- Protection against age-related power loss thanks to HydroProtect formula.



Washer Ø (mm)	Washer thickness (mm)	Max. rotation speed (U/ min(rpm))	Number of pieces per packet (PCS)	Form	
				Straight	Cranked
				76113... Ident. No.	76113... Ident. No.
115	1.0	13285	50	310	410
115	1.5	13285	50	315	415
125	1.0	12200	50	320	420
125	1.5	12200	50	325	425
180	1.5	8600	25	330	430
230	1.9	6600	25	340	440

Prod. Gr. 6BB



SG-ELASTIC cutting discs for stainless steel

Type A 46 R BF 80

Application:

For burr-free cutting of sheet metals, steel sections and solid materials with cool cutting.

Advantage:

- Good machining performance with cool grinding

Technical data:

- Bore diameter: 22.23 mm
- Version: Hard
- Free from iron and sulphur: Yes
- Number of pieces per packet: 25 PCS



Washer Ø (mm)	Washer thickness (mm)	Max. rotation speed (U/ min(rpm))	Form	
			Straight	
			76107... Ident. No.	
115	1.0	13300	115	●
125	1.0	12200	125	●
180	1.6	8600	178	●
230	1.9	6600	230	●

Prod. Gr. 6AB

ORION® Cutting discs for stainless steel – extra thin

A 46 T 11-BF 130

Application:

For cutting stainless steel.

- Bore diameter: 22.23 mm
- Version: Hard
- Free from iron and sulphur: Yes

Technical data:



Ident. No. 115, 125, 230

Washer Ø (mm)	Washer thickness (mm)	Max. rotation speed (U/min(rpm))	Number of pieces per packet (PCS)	Form	
				Straight	
				76115... Ident. No.	
115	1.0	13300	50	115	●
115	1.5	13300	50	118	●
125	1.0	12250	50	125	●
125	1.5	12250	50	128	●
180	1.5	8500	25	180	●
230	1.9	6650	25	230	●

Prod. Gr. 6LH

RHODIUS

TOP LINE ●●●

Mini cutting discs for stainless steel: XT 8 EXACT Mini and XT 10 Mini

Type A 60 U9 BF 1433

Application:

Specifically for virtually burr-free and ultra-precise cutting of thin-walled materials up to 2.5 mm thick - in conjunction with clamping bolt.

Advantage:

- Protection against age-related power loss thanks to HydroProtect formula

Technical data:

- Version: Very hard
- Free from iron and sulphur: Yes
- Number of pieces per packet: 50 PCS

Execution:

- For compressed air operated machines, flexible shafts, straight grinders, etc.



Ident. No. 130-165



Ident. No. 250-275

				Mini cutting discs for stainless steel: XT 8 EXACT Mini and XT 10 Mini				Cutting disc accessories	
				XT 8 EXACT Mini		XT 10 Mini			
				Straight		Straight			
Washer Ø (mm)	Washer thickness (mm)	Bore Ø (mm)	Max. rotation speed (U/min(rpm))	76114... Ident. No.		76114... Ident. No.		76114... Ident. No.	
30	0.8	6	50900	130	●	-	-	300	●
40	0.8	6	38200	140	●	-	-	300	●
50	0.8	6	30560	150	●	-	-	300	●
65	0.8	6	23500	165	●	-	-	300	●
50	1.0	6	30560	-	-	250	●	302	●
65	1.0	6	23500	-	-	265	●	302	●
75	1.0	10	20100	-	-	275	●	302	●

Prod. Gr. 6BB

ATORN® Cutting discs for steel – extra thin type – 74 A30 T11-BF 725

Application:

For burr-free cutting of thin-walled pipes, sheet steel and profiles.

Advantage:

- Very hard cutting disc for extremely short cutting times

Technical data:

- Bore diameter: 22.23 mm
- Version: Very hard
- Free from iron and sulphur: No



				Form	Straight
Washer Ø (mm)	Washer thickness (mm)	Max. rotation speed (U/min(rpm))	Number of pieces per packet (PCS)	76109... Ident. No.	
115	1.0	13300	50	115	●
115	1.5	13300	50	116	●
125	1.0	12250	50	125	●
125	1.5	12250	50	126	●
180	1.5	8500	25	180	●
230	1.9	6650	25	230	●

Prod. Gr. 6CH

ORION® Cutting discs for steel – extra thin Type A 60 S-BF T41

Application:

For cutting thin-walled pipes, sheet steel and profiles.

Technical data:

- Washer thickness: 1.0 mm
- Bore diameter: 22.23 mm
- Version: Hard
- Number of pieces per packet: 25



		Form	Straight
Washer Ø (mm)	Max. rotation speed (U/min(rpm))	76110... Ident. No.	
115	13300	315	●
125	12200	325	●

Prod. Gr. 6LH

ATORN® Cutting discs for steel/cast iron Type A 24 Q-BF 725

Application:

For machining of all construction steels, alloyed and high-alloy steels, stainless steels and cast iron as well as for cutting larger cross-sections of solid material.

Technical data:

- Washer thickness: 3.0 mm
- Bore diameter: 22.23 mm
- Version: Medium hard
- Free from iron and sulphur: No
- Number of pieces per packet: 25 PCS



Ident. No. 115–125

		Form	Cranked	Straight
Washer Ø (mm)	Max. rotation speed (U/min(rpm))	76112... Ident. No.		76112... Ident. No.
115	1330	115	●	-
125	12250	125	●	-
180	8500	-	-	178
230	6650	-	-	230

Prod. Gr. 6CH

ORION® Cutting discs for steel

Type A 24 P-BF 130

Application:

Suitable for a wide range of uses, such as for cutting pipes, sheet metal and steel sections.

Technical data:

- Washer thickness: 3.0 mm
- Bore diameter: 22.23 mm
- Version: Hard
- Free from iron and sulphur: No
- Number of pieces per packet: 25 PCS

Washer Ø (mm)	Max. rotation speed (U/min(rpm))	Form		Cranked		Straight	
		76110...	Ident. No.	76110...	Ident. No.	76110...	Ident. No.
115	13300	115	●	-	-	-	-
125	12250	125	●	-	-	-	-
180	8500	-	-	180	●	-	-
230	6650	-	-	230	●	-	-

Prod. Gr. 6LH



Ident. No. 125-180

RHODIUS

TOP LINE ●●●

Cutting discs for aluminium/non-ferrous metals

Type A 24 P-BF 26

Application:

For cutting greasy

non-ferrous metals.

Advantage:

- The disc does not clog due to the open structure

Technical data:

- Bore diameter: 22.23 mm
- Version: Medium hard
- Free from iron and sulphur: No
- Number of pieces per packet: 25 PCS

Washer Ø (mm)	Washer thickness (mm)	Max. rotation speed (U/min(rpm))	Form		Cranked		Straight	
			76117...	Ident. No.	76117...	Ident. No.	76117...	Ident. No.
115	2.0	13285	115	●	-	-	-	-
125	2.0	12200	125	●	-	-	-	-
180	2.5	8600	-	-	180	●	-	-
230	2.5	6600	-	-	230	●	-	-

Prod. Gr. 6BB





HSS and cemented carbide milling bits

For electric and compressed air operated machines and systems with flexible shafts

Recommendations for use:

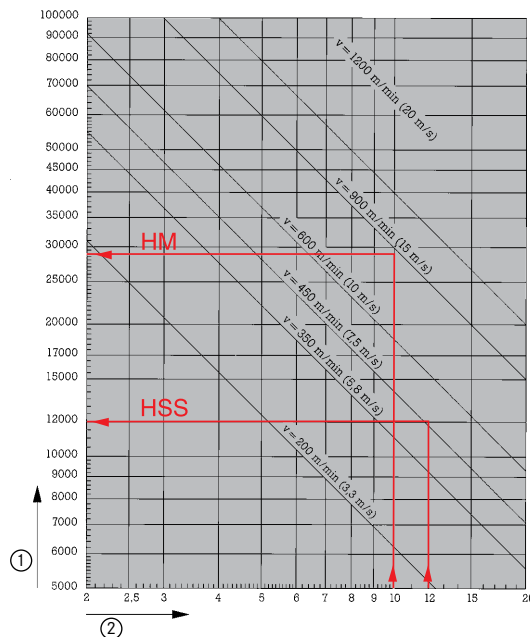
Optimal rotation speed and performance of the tool drive (compressed air, electric, flexible shaft) are crucial for efficient use of cemented carbide milling bits.

- Use the highest possible rotation speeds within the recommended ranges of rotation speed/cutting speed.
- Pay particular attention to the rotation speed recommendations when working with materials with poor thermal conductivity, such as stainless steel, titanium alloys etc. so that you do not damage the tool. Blue colouration of the shaft and tool should be avoided.
- Only use clamping systems/drives without play; knocking and rattling of the tools results in premature wear.
- Do not choose a milling bit clamping length that is too small. Rule: Minimum clamping length is 2/3 of the shaft length.

When selecting the milling bits, take into account the material to be processed and the rotation speed.

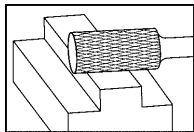
To determine the correct rotation speed range for the particular HSS or cemented carbide milling bit in your application, please note the following:

- Choose the tooling you want based on the material that will be processed and the resulting cutting speed.
- Find your required cutting diameter and the calculated cutting speed for the chosen tooling in the diagram on the right. The point where the lines cross gives you the required rotation speed range.

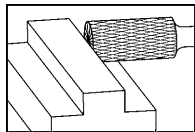


① Rotation speed (rpm), ② Cutting diameter (mm)

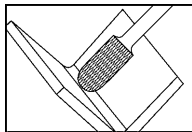
Milling bit shapes and their applications:



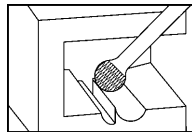
Shape: Cylindrical without end cut (ZYA)



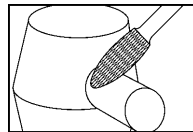
Shape: Cylindrical with end cut (ZYAS)



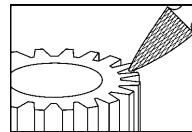
Shape: Cylindrical with radius end (WRC)



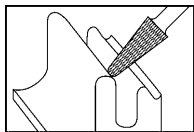
Shape: Ball (KUD)



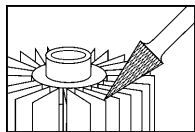
Shape: Flame (SH)



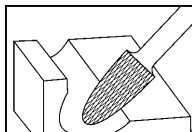
Shape: Pointed tree shape (SPG)



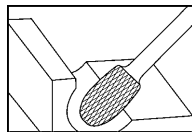
Shape: Conical shape with radius end (KEL)



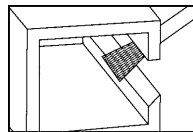
Shape: Tip cone (SKM)



Shape: Tree shape with radius end (RBF)



Shape: Oval (TRE)



Shape: Inverted cone (WKN)