





# Cutoff and Roughing Wheels

## General working and safety precautions

- ✦ Clearly laid-out and correct storage of wheels → dry, at 20°C room temperature
- ✦ Work only when wearing the appropriate protective clothing such as safety goggles, gloves, steel-capped work shoes, hearing protectors and dust mask.
- ✦ Only secure cutoff and roughing wheels with original clamping flanges provided for this purpose. Do not use defective or worn flanges.
- ✦ Only carry out cutting and roughing work with the corresponding protective hood.
- ✦ The use of damaged wheels increases the risk of an accident. Only process undamaged wheels.
- ✦ The permissible circumferential speed may not be exceeded.
- ✦ Do not mount worn wheels on smaller machines.

## Areas of use

Materials	Material Designations
<b>Steel</b> 	General construction steels High-strength construction steels Structural steels Tool steels Hardened steels
<b>Non-ferrous metals / Aluminum</b> 	Aluminum Aluminum alloys Copper Brass Bronze Other lubricating non-ferrous metals
<b>Stainless steel</b> 	Stainless-steel sheets Non-alloyed stainless steels Alloyed and high-alloy steels Rust and acid-proof steels Chrome-nickel steel
<b>Stone</b> 	Natural stone Artificial stone Chalky sandstone Concrete/reinforced concrete

## Special Working and Safety Precautions

### Cutting:

- ✦ Cutoff wheels are not permissible for rough grinding.
- ✦ Do not jam or tilt wheels in the cut. → Increased risk of breakage!
- ✦ A slight pendulum movement in the cut causes the wheel to be cut free.
- ✦ Ensure proper contact pressure. → The machines own weight is generally sufficient!
- ✦ Ensure proper clamping of workpiece.
- ✦ Always clamp cutoff wheels (straight version) with metal ring toward machine.

- ✦ **Attention:** With cutoff wheels with a thickness of 1.0 mm, it must be checked whether the flange mounting of the angle grinder is suitable for the 1.0 mm wheel. Otherwise firm seating of the wheel must be ensured with the cardboard rings provided for this purpose.

### Roughing:

- ✦ For free-handed grinding.
- ✦ Ensure the proper contact angle of the roughing wheel. → A contact angle which is too flat will cause the wheel to break out around the edge.

