





## ➤ Flap discs for stock removal

The average flap disc has the capacity to grind reasonably quickly and provide a reasonable finish. In comparison to the grinding disc, it produces hardly any noise and is free of vibration. It has been developed and continuously improved over many years. In the past, one disc was used to work all types of material and workpieces. Nowadays, however, there are very specific flap discs with very distinct properties. As a result, we now have special discs available to work specific material in very specific circumstances. Given the correct choice, each operator has efficient and technically advanced discs at his disposal to achieve a very controlled finish.

With a good flap disc it is important that the abrasive grit wears at the same rate as the cloth.

Given the very large variety on the market, it is not easy to make the right choice. If requested, the Cibo experts can provide an accurate analysis of your requirements and will advise you on how to save time and money.

The following pages contain an overview of the parameters that will determine your choice. They provide you with guidelines for selecting flap discs for stock removal.

## ➤ WHAT TYPE OF FLAP DISC TO SELECT?



### STOCK REMOVAL CAPACITY

This is often one of the first parameters under consideration in choosing a flap disc. If this parameter is important to you, you should take into account the total stock removal capacity of a disc within a specific time frame and under similar circumstances.

After all, certain discs have a very high initial cutting power, but they lose this cutting capacity after 3 to 5 minutes. Other discs only offer very high stock removal capacity at a high working pressure with the machine at high capacity. This is tiring for the operator; the machines required weigh considerably more, and not everyone has high-powered machines available.

### USEFUL LIFESPAN

Very often, the total lifespan of a disc is used as a reference when making a selection. At first glance, this may appear a good line of thought. However, when we look at the total grinding cost, we often find that this parameter is deceptive. In most industrial countries, labour costs are a very important factor in determining the total finishing costs of a workpiece. Therefore, your total cost price is not only determined by the lifespan, but also by the quantity of stock removal.

### PRICE OF THE DISC

Very often, it is easy to allow oneself to be blinded by the purchase price of the disc. There are very cheap discs available on the market today which at first glance appear excellent. In this context, many operators have personally experienced how deceptive this can prove to be. Please read on and you will find out that the most expensive disc to purchase is usually the cheapest to use.



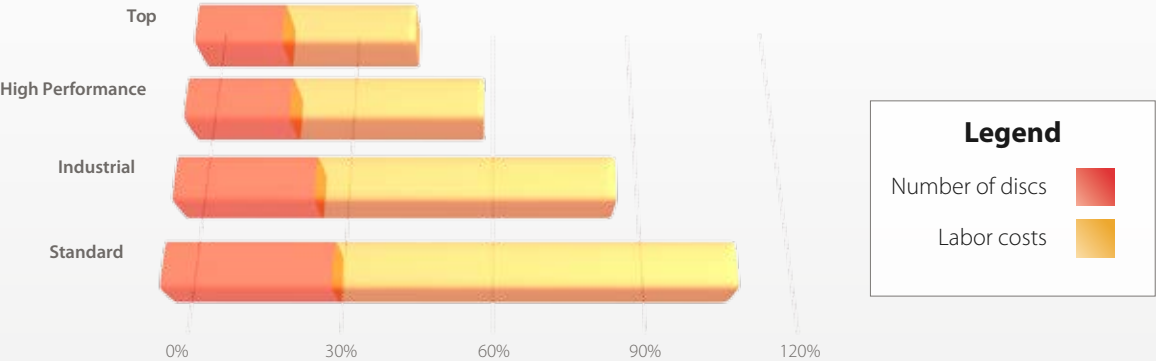
### TOTAL GRINDING COSTS

A cost price that takes into account all elements that determine cost is probably the only correct one.

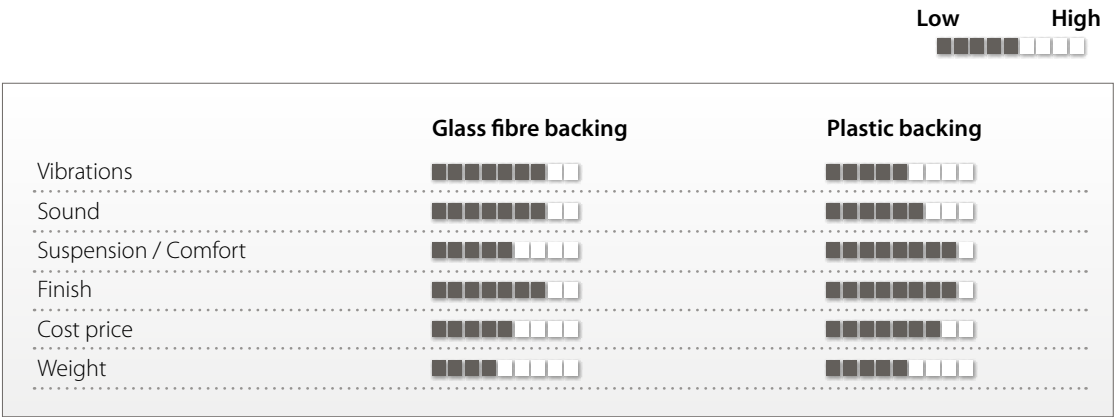
The speed and amount of stock removal per unit of time during the entire life span of the disc are the most decisive factors in the cost price of grinding.



### Total grinding costs for stock removal of 1 kg stainless steel weld seam



## WHAT TYPE OF FLAP DISC TO SELECT?



**?** **Did you know** that Cibo has set up its own flap disc department? In mid-2010, production capacity amounted to 2,500,000 discs. For these flap discs, Cibo uses abrasive cloth with specific properties. The standard, Industrial and the High Performance lines with their zirconium oxide grit, as well as the Top line with our latest ceramic quality, ensure the very fast removal of material and allow you to save considerably on labour.





**Glass fibre backings**

Low High

|                  | Stock removal capacity | Useful life | Finishing | Flexibility |
|------------------|------------------------|-------------|-----------|-------------|
| STANDARD         | ■ ■ ■ ■ ■              | ■ ■ ■ ■ ■   | ■ ■ ■ ■ ■ | ■ ■ ■ ■ ■   |
| INDUSTRIAL       | ■ ■ ■ ■ ■              | ■ ■ ■ ■ ■   | ■ ■ ■ ■ ■ | ■ ■ ■ ■ ■   |
| HIGH PERFORMANCE | ■ ■ ■ ■ ■              | ■ ■ ■ ■ ■   | ■ ■ ■ ■ ■ | ■ ■ ■ ■ ■   |
| TOP              | ■ ■ ■ ■ ■              | ■ ■ ■ ■ ■   | ■ ■ ■ ■ ■ | ■ ■ ■ ■ ■   |
| EXTENDED C       | ■ ■ ■ ■ ■              | ■ ■ ■ ■ ■   | ■ ■ ■ ■ ■ | ■ ■ ■ ■ ■   |
| EXTENDED Z       | ■ ■ ■ ■ ■              | ■ ■ ■ ■ ■   | ■ ■ ■ ■ ■ | ■ ■ ■ ■ ■   |
| LVZ (TAF)        | ■ ■ ■ ■ ■              | ■ ■ ■ ■ ■   | ■ ■ ■ ■ ■ | ■ ■ ■ ■ ■   |



**Plastic backings**

Low High

|            | Stock removal capacity | Useful life | Finishing | Flexibility |
|------------|------------------------|-------------|-----------|-------------|
| TOP        | ■ ■ ■ ■ ■              | ■ ■ ■ ■ ■   | ■ ■ ■ ■ ■ | ■ ■ ■ ■ ■   |
| INDUSTRIAL | ■ ■ ■ ■ ■              | ■ ■ ■ ■ ■   | ■ ■ ■ ■ ■ | ■ ■ ■ ■ ■   |
| 43/A (TAF) | ■ ■ ■ ■ ■              | ■ ■ ■ ■ ■   | ■ ■ ■ ■ ■ | ■ ■ ■ ■ ■   |
| 61/Z (TAF) | ■ ■ ■ ■ ■              | ■ ■ ■ ■ ■   | ■ ■ ■ ■ ■ | ■ ■ ■ ■ ■   |
| 43/C (TAF) | ■ ■ ■ ■ ■              | ■ ■ ■ ■ ■   | ■ ■ ■ ■ ■ | ■ ■ ■ ■ ■   |
| 91/Z (TAF) | ■ ■ ■ ■ ■              | ■ ■ ■ ■ ■   | ■ ■ ■ ■ ■ | ■ ■ ■ ■ ■   |

## > Cloth flaps / Glass fibre backing



STANDARD LINE

### FSF - FLAT



| dimensions | grit | code        | type  | max RPM | stock |    |
|------------|------|-------------|-------|---------|-------|----|
| Ø 115x22   | 40   | FSF/40/115  | Zirc. | 13.300  | ●     | 10 |
|            | 60   | FSF/60/115  | Zirc. | 13.300  | ●     | 10 |
|            | 80   | FSF/80/115  | Zirc. | 13.300  | ●     | 10 |
|            | 120  | FSF/120/115 | Zirc. | 13.300  | ●     | 10 |
| Ø 125x22   | 40   | FSF/40/125  | Zirc. | 12.200  | ●     | 10 |
|            | 60   | FSF/60/125  | Zirc. | 12.200  | ●     | 10 |
|            | 80   | FSF/80/125  | Zirc. | 12.200  | ●     | 10 |
|            | 120  | FSF/120/125 | Zirc. | 12.200  | ●     | 10 |



STANDARD LINE

### FSC - CONICAL



| dimensions | grit | code        | type  | max RPM | stock |    |
|------------|------|-------------|-------|---------|-------|----|
| Ø 115x22   | 40   | FSC/40/115  | Zirc. | 13.300  | ●     | 10 |
|            | 60   | FSC/60/115  | Zirc. | 13.300  | ●     | 10 |
|            | 80   | FSC/80/115  | Zirc. | 13.300  | ●     | 10 |
|            | 120  | FSC/120/115 | Zirc. | 13.300  | ●     | 10 |
| Ø 125x22   | 40   | FSC/40/125  | Zirc. | 12.200  | ●     | 10 |
|            | 60   | FSC/60/125  | Zirc. | 12.200  | ●     | 10 |
|            | 80   | FSC/80/125  | Zirc. | 12.200  | ●     | 10 |
|            | 120  | FSC/120/125 | Zirc. | 12.200  | ●     | 10 |



➤ Cloth flaps / Glass fibre backing

FNF - FLAT

| dimensions | grit | code        | type   | max RPM | stock |  |
|------------|------|-------------|--------|---------|-------|-------------------------------------------------------------------------------------|
| Ø 115x22   | 40   | FNF/40/115  | Zirc.+ | 13.300  | ●     | 10                                                                                  |
|            | 60   | FNF/60/115  | Zirc.+ | 13.300  | ●     | 10                                                                                  |
|            | 80   | FNF/80/115  | Zirc.+ | 13.300  | ●     | 10                                                                                  |
|            | 120  | FNF/120/115 | Zirc.+ | 13.300  | ●     | 10                                                                                  |
| Ø 125x22   | 40   | FNF/40/125  | Zirc.+ | 12.200  | ●     | 10                                                                                  |
|            | 60   | FNF/60/125  | Zirc.+ | 12.200  | ●     | 10                                                                                  |
|            | 80   | FNF/80/125  | Zirc.+ | 12.200  | ●     | 10                                                                                  |
|            | 120  | FNF/120/125 | Zirc.+ | 12.200  | ●     | 10                                                                                  |

FNC - CONICAL

| dimensions | grit | code        | type   | max RPM | stock |  |
|------------|------|-------------|--------|---------|-------|-------------------------------------------------------------------------------------|
| Ø 115x22   | 40   | FNC/40/115  | Zirc.+ | 13.300  | ●     | 10                                                                                  |
|            | 60   | FNC/60/115  | Zirc.+ | 13.300  | ●     | 10                                                                                  |
|            | 80   | FNC/80/115  | Zirc.+ | 13.300  | ●     | 10                                                                                  |
|            | 120  | FNC/120/115 | Zirc.+ | 13.300  | ●     | 10                                                                                  |
| Ø 125x22   | 40   | FNC/40/125  | Zirc.+ | 12.200  | ●     | 10                                                                                  |
|            | 60   | FNC/60/125  | Zirc.+ | 12.200  | ●     | 10                                                                                  |
|            | 80   | FNC/80/125  | Zirc.+ | 12.200  | ●     | 10                                                                                  |
|            | 120  | FNC/120/125 | Zirc.+ | 12.200  | ●     | 10                                                                                  |
| Ø 150x22   | 40   | FNC/40/150  | Zirc.+ | 10.000  | ●     | 10                                                                                  |
|            | 60   | FNC/60/150  | Zirc.+ | 10.000  | ●     | 10                                                                                  |
| Ø 180x22   | 40   | FNC/40/180  | Zirc.+ | 8.500   | ●     | 10                                                                                  |
|            | 60   | FNC/60/180  | Zirc.+ | 8.500   | ●     | 10                                                                                  |

FOZ - EXTENDED

| dimensions | grit | code       | type   | max RPM | stock |  |
|------------|------|------------|--------|---------|-------|---------------------------------------------------------------------------------------|
| Ø 115x22   | 40   | FOZ/40/115 | Zirc.+ | 13.300  | ●     | 10                                                                                    |
|            | 60   | FOZ/60/115 | Zirc.+ | 13.300  | ●     | 10                                                                                    |
|            | 80   | FOZ/80/115 | Zirc.+ | 13.300  | ●     | 10                                                                                    |
| Ø 125x22   | 40   | FOZ/40/125 | Zirc.+ | 12.200  | ●     | 10                                                                                    |
|            | 60   | FOZ/60/125 | Zirc.+ | 12.200  | ●     | 10                                                                                    |
|            | 80   | FOZ/80/125 | Zirc.+ | 12.200  | ●     | 10                                                                                    |

● = available from stock

● = available in 5 working days

● = on request

INDUSTRIAL LINE



INDUSTRIAL LINE



INDUSTRIAL LINE



## ➤ Cloth flaps / Glass fibre backing



HIGH PERFORMANCE  
LINE



### FPF - FLAT

| dimensions | grit | code       | type     | max RPM | stock |    |
|------------|------|------------|----------|---------|-------|----|
| Ø 115x22   | 40   | FPF/40/115 | Zirc.+++ | 13.300  | ●     | 10 |
|            | 60   | FPF/60/115 | Zirc.+++ | 13.300  | ●     | 10 |
|            | 80   | FPF/80/115 | Zirc.+++ | 13.300  | ●     | 10 |
| Ø 125x22   | 40   | FPF/40/125 | Zirc.+++ | 12.200  | ●     | 10 |
|            | 60   | FPF/60/125 | Zirc.+++ | 12.200  | ●     | 10 |
|            | 80   | FPF/80/125 | Zirc.+++ | 12.200  | ●     | 10 |



HIGH PERFORMANCE  
LINE



### FPC - CONICAL

| dimensions | grit | code       | type     | max RPM | stock |    |
|------------|------|------------|----------|---------|-------|----|
| Ø 115x22   | 40   | FPC/40/115 | Zirc.+++ | 13.300  | ●     | 10 |
|            | 60   | FPC/60/115 | Zirc.+++ | 13.300  | ●     | 10 |
|            | 80   | FPC/80/115 | Zirc.+++ | 13.300  | ●     | 10 |
| Ø 125x22   | 40   | FPC/40/125 | Zirc.+++ | 12.200  | ●     | 10 |
|            | 60   | FPC/60/125 | Zirc.+++ | 12.200  | ●     | 10 |
|            | 80   | FPC/80/125 | Zirc.+++ | 12.200  | ●     | 10 |



➤ Cloth flaps / Glass fibre backing

FTF - FLAT

| dimensions | grit | code       | type   | max RPM | stock |  |
|------------|------|------------|--------|---------|-------|-------------------------------------------------------------------------------------|
| Ø 115x22   | 40   | FTF/40/115 | Ceram. | 13.300  | ●     | 10                                                                                  |
|            | 60   | FTF/60/115 | Ceram. | 13.300  | ●     | 10                                                                                  |
|            | 80   | FTF/80/115 | Ceram. | 13.300  | ●     | 10                                                                                  |
| Ø 125x22   | 40   | FTF/40/125 | Ceram. | 12.200  | ●     | 10                                                                                  |
|            | 60   | FTF/60/125 | Ceram. | 12.200  | ●     | 10                                                                                  |
|            | 80   | FTF/80/125 | Ceram. | 12.200  | ●     | 10                                                                                  |

FTC - CONICAL

| dimensions | grit | code       | type   | max RPM | stock |  |
|------------|------|------------|--------|---------|-------|-------------------------------------------------------------------------------------|
| Ø 115x22   | 40   | FTC/40/115 | Ceram. | 13.300  | ●     | 10                                                                                  |
|            | 60   | FTC/60/115 | Ceram. | 13.300  | ●     | 10                                                                                  |
|            | 80   | FTC/80/115 | Ceram. | 13.300  | ●     | 10                                                                                  |
| Ø 125x22   | 40   | FTC/40/125 | Ceram. | 12.200  | ●     | 10                                                                                  |
|            | 60   | FTC/60/125 | Ceram. | 12.200  | ●     | 10                                                                                  |
|            | 80   | FTC/80/125 | Ceram. | 12.200  | ●     | 10                                                                                  |
| Ø 180x22   | 40   | FTC/40/180 | Ceram. | 8.500   | ●     | 10                                                                                  |

FOV - EXTENDED

| dimensions | grit | code       | type   | max RPM | stock |  |
|------------|------|------------|--------|---------|-------|---------------------------------------------------------------------------------------|
| Ø 115x22   | 40   | FOV/40/115 | Ceram. | 13.300  | ●     | 10                                                                                    |
|            | 60   | FOV/60/115 | Ceram. | 13.300  | ●     | 10                                                                                    |
|            | 80   | FOV/80/115 | Ceram. | 13.300  | ●     | 10                                                                                    |
| Ø 125x22   | 40   | FOV/40/125 | Ceram. | 12.200  | ●     | 10                                                                                    |
|            | 60   | FOV/60/125 | Ceram. | 12.200  | ●     | 10                                                                                    |
|            | 80   | FOV/80/125 | Ceram. | 12.200  | ●     | 10                                                                                    |

 Other configurations are possible; please consult Cibo.

TOP LINE 



TOP LINE 



TOP LINE 



## ➤ Cloth flaps / Glass fibre backing



TAF



### LVZ34 - FLAT

| dimensions | grit | code      | type   | max RPM | stock |  |
|------------|------|-----------|--------|---------|-------|-------------------------------------------------------------------------------------|
| Ø 115x22   | 40   | LVZ34/40  | Zirc.+ | 13.300  | ●     | 20                                                                                  |
|            | 60   | LVZ34/60  | Zirc.+ | 13.300  | ●     | 20                                                                                  |
|            | 80   | LVZ34/80  | Zirc.+ | 13.300  | ●     | 20                                                                                  |
|            | 120  | LVZ34/120 | Zirc.+ | 13.300  | ●     | 20                                                                                  |



TAF



### LVZ42 - FLAT

| dimensions | grit | code      | type   | max RPM | stock |  |
|------------|------|-----------|--------|---------|-------|-------------------------------------------------------------------------------------|
| Ø 125x22   | 40   | LVZ42/40  | Zirc.+ | 12.200  | ●     | 20                                                                                  |
|            | 60   | LVZ42/60  | Zirc.+ | 12.200  | ●     | 20                                                                                  |
|            | 80   | LVZ42/80  | Zirc.+ | 12.200  | ●     | 20                                                                                  |
|            | 120  | LVZ42/120 | Zirc.+ | 12.200  | ●     | 20                                                                                  |



TAF



### LVZ38 - CONICAL

| dimensions | grit | code      | type   | max RPM | stock |  |
|------------|------|-----------|--------|---------|-------|---------------------------------------------------------------------------------------|
| Ø 115x22   | 40   | LVZ38/40  | Zirc.+ | 13.300  | ●     | 20                                                                                    |
|            | 60   | LVZ38/60  | Zirc.+ | 13.300  | ●     | 20                                                                                    |
|            | 80   | LVZ38/80  | Zirc.+ | 13.300  | ●     | 20                                                                                    |
|            | 120  | LVZ38/120 | Zirc.+ | 13.300  | ●     | 20                                                                                    |

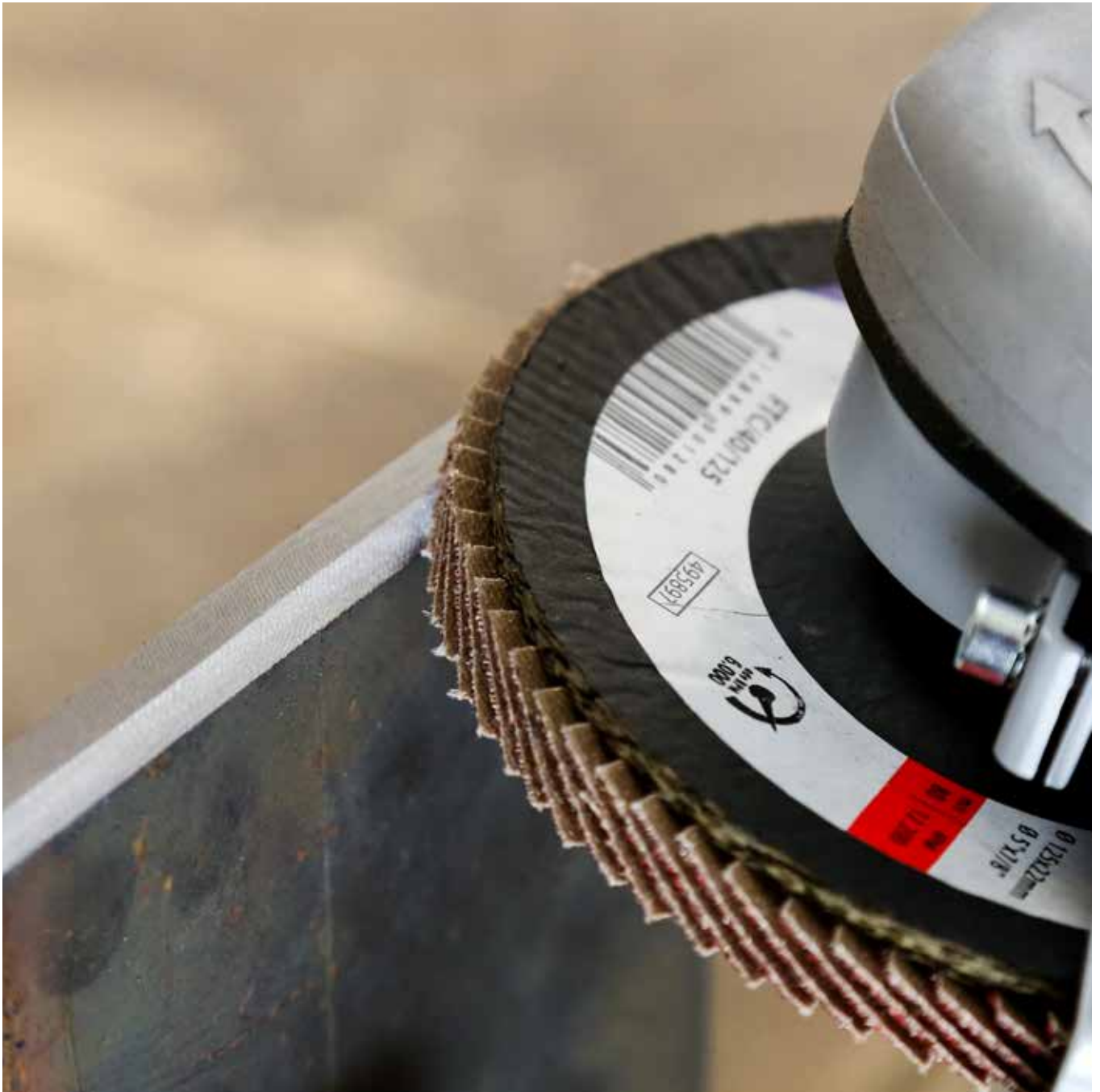


TAF



### LVZ44 - CONICAL

| dimensions | grit | code      | type   | max RPM | stock |  |
|------------|------|-----------|--------|---------|-------|---------------------------------------------------------------------------------------|
| Ø 125x22   | 40   | LVZ44/40  | Zirc.+ | 12.200  | ●     | 20                                                                                    |
|            | 60   | LVZ44/60  | Zirc.+ | 12.200  | ●     | 20                                                                                    |
|            | 80   | LVZ44/80  | Zirc.+ | 12.200  | ●     | 20                                                                                    |
|            | 120  | LVZ44/120 | Zirc.+ | 12.200  | ●     | 20                                                                                    |



● = available from stock

● = available in 5 working days

● = on request

## > Cloth flaps / Plastic backing



STANDARD LINE



### FSPF - FLAT

| dimensions | grit | code        | type  | max RPM | stock |    |
|------------|------|-------------|-------|---------|-------|----|
| Ø 115x22   | 40   | FSPF/40/115 | Zirc. | 13.300  | ●     | 10 |
|            | 60   | FSPF/60/115 | Zirc. | 13.300  | ●     | 10 |
|            | 80   | FSPF/80/115 | Zirc. | 13.300  | ●     | 10 |
| Ø 125x22   | 40   | FSPF/40/125 | Zirc. | 12.200  | ●     | 10 |
|            | 60   | FSPF/60/125 | Zirc. | 12.200  | ●     | 10 |
|            | 80   | FSPF/80/125 | Zirc. | 12.200  | ●     | 10 |



STANDARD LINE



### FSPC - CONICAL

| dimensions | grit | code        | type  | max RPM | stock |    |
|------------|------|-------------|-------|---------|-------|----|
| Ø 115x22   | 40   | FSPC/40/115 | Zirc. | 13.300  | ●     | 10 |
|            | 60   | FSPC/60/115 | Zirc. | 13.300  | ●     | 10 |
|            | 80   | FSPC/80/115 | Zirc. | 13.300  | ●     | 10 |
| Ø 125x22   | 40   | FSPC/40/125 | Zirc. | 12.200  | ●     | 10 |
|            | 60   | FSPC/60/125 | Zirc. | 12.200  | ●     | 10 |
|            | 80   | FSPC/80/125 | Zirc. | 12.200  | ●     | 10 |



INDUSTRIAL LINE



### FNPF - FLAT

| dimensions | grit | code        | type   | max RPM | stock |    |
|------------|------|-------------|--------|---------|-------|----|
| Ø 115x22   | 40   | FNPF/40/115 | Zirc.+ | 13.300  | ●     | 10 |
|            | 60   | FNPF/60/115 | Zirc.+ | 13.300  | ●     | 10 |
|            | 80   | FNPF/80/115 | Zirc.+ | 13.300  | ●     | 10 |
| Ø 125x22   | 40   | FNPF/40/125 | Zirc.+ | 12.200  | ●     | 10 |
|            | 60   | FNPF/60/125 | Zirc.+ | 12.200  | ●     | 10 |
|            | 80   | FNPF/80/125 | Zirc.+ | 12.200  | ●     | 10 |

## ➤ Cloth flaps / Plastic backing

### FNPC - CONICAL

| dimensions | grit | code        | type   | max RPM | stock |  |
|------------|------|-------------|--------|---------|-------|-------------------------------------------------------------------------------------|
| Ø 115x22   | 40   | FNPC/40/115 | Zirk.+ | 13.300  | ●     | 10                                                                                  |
|            | 60   | FNPC/60/115 | Zirk.+ | 13.300  | ●     | 10                                                                                  |
|            | 80   | FNPC/80/115 | Zirk.+ | 13.300  | ●     | 10                                                                                  |
| Ø 125x22   | 40   | FNPC/40/125 | Zirk.+ | 12.200  | ●     | 10                                                                                  |
|            | 60   | FNPC/60/125 | Zirk.+ | 12.200  | ●     | 10                                                                                  |
|            | 80   | FNPC/80/125 | Zirk.+ | 12.200  | ●     | 10                                                                                  |

### INDUSTRIAL LINE



### FTPM - FLAT - M14

| dimensions | grit | code        | type   | max RPM | stock |  |
|------------|------|-------------|--------|---------|-------|-------------------------------------------------------------------------------------|
| Ø 125x22   | 40   | FTPM/40/125 | Ceram. | 12.200  | ●     | 10                                                                                  |
|            | 60   | FTPM/60/125 | Ceram. | 12.200  | ●     | 10                                                                                  |

### TOP LINE



### FTPC - CONICAL

| dimensions | grit | code        | type   | max RPM | stock |  |
|------------|------|-------------|--------|---------|-------|--------------------------------------------------------------------------------------|
| Ø 125x22   | 40   | FTPC/40/125 | Ceram. | 12.200  | ●     | 10                                                                                   |
|            | 60   | FTPC/60/125 | Ceram. | 12.200  | ●     | 10                                                                                   |

### TOP LINE



### 43A - FLAT

| dimensions | grit | code    | type    | max RPM | stock |  |
|------------|------|---------|---------|---------|-------|---------------------------------------------------------------------------------------|
| Ø 110x22   | 40   | 43A/40  | Al.-Ox. | 11.000  | ●     | 20                                                                                    |
|            | 60   | 43A/60  | Al.-Ox. | 11.000  | ●     | 20                                                                                    |
|            | 80   | 43A/80  | Al.-Ox. | 11.000  | ●     | 20                                                                                    |
|            | 100  | 43A/100 | Al.-Ox. | 11.000  | ●     | 20                                                                                    |
|            | 120  | 43A/120 | Al.-Ox. | 11.000  | ●     | 20                                                                                    |
|            | 150  | 43A/150 | Al.-Ox. | 11.000  | ●     | 20                                                                                    |
|            | 180  | 43A/180 | Al.-Ox. | 11.000  | ●     | 20                                                                                    |
|            | 220  | 43A/220 | Al.-Ox. | 11.000  | ●     | 20                                                                                    |

### TAF - INTERNALLY BONDED



● = available from stock

● = available in 5 working days

● = on request

## > Cloth flaps / Plastic backing



TAF - INTERNALLY  
BONDED



### 61Z - FLAT

| dimensions | grit | code    | type  | max RPM | stock |    |
|------------|------|---------|-------|---------|-------|----|
| Ø 110x22   | 36   | 61Z/36  | Zirc. | 11.000  | ●     | 20 |
|            | 40   | 61Z/40  | Zirc. | 11.000  | ●     | 20 |
|            | 50   | 61Z/50  | Zirc. | 11.000  | ●     | 20 |
|            | 60   | 61Z/60  | Zirc. | 11.000  | ●     | 20 |
|            | 80   | 61Z/80  | Zirc. | 11.000  | ●     | 20 |
|            | 120  | 61Z/120 | Zirc. | 11.000  | ●     | 20 |



TAF - INTERNALLY  
BONDED



### 43C - FLAT

| dimensions | grit | code    | type       | max RPM | stock |    |
|------------|------|---------|------------|---------|-------|----|
| Ø 110x22   | 60   | 43C/60  | Sil. Carb. | 11.000  | ●     | 20 |
|            | 80   | 43C/80  | Sil. Carb. | 11.000  | ●     | 20 |
|            | 120  | 43C/120 | Sil. Carb. | 11.000  | ●     | 20 |
|            | 220  | 43C/220 | Sil. Carb. | 11.000  | ●     | 20 |
|            | 320  | 43C/320 | Sil. Carb. | 11.000  | ●     | 20 |



TAF - INTERNALLY  
BONDED



### 91Z - CONICAL

| dimensions | grit | code    | type  | max RPM | stock |    |
|------------|------|---------|-------|---------|-------|----|
| Ø 110x22   | 40   | 91Z/40  | Zirc. | 11.000  | ●     | 20 |
|            | 60   | 91Z/60  | Zirc. | 11.000  | ●     | 20 |
|            | 80   | 91Z/80  | Zirc. | 11.000  | ●     | 20 |
|            | 120  | 91Z/120 | Zirc. | 11.000  | ●     | 20 |



We recommend using the flap discs with a plastic backing with the universal flange set MHD13.  
For additional information, see. p 500

➤ Cloth flaps / Plastic backing

MINIFLAP – ZIRCONIUM OXIDE

| diameter | grit | code         | type    | max RPM | code support    | stock                                                                             |  |
|----------|------|--------------|---------|---------|-----------------|-----------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
| Ø 50     | 40   | MSZV/40/50   | Socatt® | 15.000  | QSRH/M/50M14    |  | 10                                                                                  |
|          | 60   | MSZV/60/50   | Socatt® | 15.000  |                 |  | 10                                                                                  |
|          | 80   | MSZV/80/50   | Socatt® | 15.000  |                 |  | 10                                                                                  |
|          | 120  | MSZV/120/50  | Socatt® | 15.000  |                 |  | 10                                                                                  |
| Ø 75     | 40   | MSZV/40/75*  | Socatt® | 10.000  | QSRH/M/75M14/MF |  | 10                                                                                  |
|          | 60   | MSZV/60/75*  | Socatt® | 10.000  |                 |  | 10                                                                                  |
|          | 80   | MSZV/80/75*  | Socatt® | 10.000  |                 |  | 10                                                                                  |
|          | 120  | MSZV/120/75* | Socatt® | 10.000  |                 |  | 10                                                                                  |

ZIRCONIUM OXIDE    SOCATT®



 Use Ø75 only with support pad **QSRH/M/75M14/MF**. (see p. 487)

MLZV - FLAT

| diameter | grit | code        | type    | max RPM | code support | stock                                                                               |  |
|----------|------|-------------|---------|---------|--------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
| Ø 50     | 40   | MLZV/40/50  | Lockit® | 15.000  | QLRH/M/50M14 |    | 10                                                                                  |
|          | 60   | MLZV/60/50  | Lockit® | 15.000  |              |   | 10                                                                                  |
|          | 80   | MLZV/80/50  | Lockit® | 15.000  |              |  | 10                                                                                  |
|          | 120  | MLZV/120/50 | Lockit® | 15.000  |              |  | 10                                                                                  |
| Ø 75     | 40   | MLZV/40/75  | Lockit® | 10.000  |              |  | 10                                                                                  |
|          | 60   | MLZV/60/75  | Lockit® | 10.000  |              |  | 10                                                                                  |
|          | 80   | MLZV/80/75  | Lockit® | 10.000  |              |  | 10                                                                                  |
|          | 120  | MLZV/120/75 | Lockit® | 10.000  |              |  | 10                                                                                  |

ZIRCONIUM OXIDE    LOCKIT®



 For additional information about holders, see accessories.

Socatt® and Lockit® are brandnames of the 3M Company.

 = available from stock     = available in 5 working days     = on request







## THE RCD-DISC

original patented - original patented  
**WORLDWIDE  
PATENTED**  
original patented product - original patented



### This disc is often used with:

- Finishing light weld seams
- Finishing angles and toothing
- Improving the surface roughness
- Refining coarse grinding lines
- Breaking edges
- Grinding down casting errors
- Removing milling lines
- Homogenising surfaces
- Preparation for polishing
- Remove welding spatter
- Light deburring

The Cibo RCD-disc allows you to grind down weld seams and provide a flawless finish in a single operation.

This revolutionary and universally patented Cibo innovation consists of two complementary abrasive materials which provide fantastic results in a single operation. In the past, an experienced grinder required at least three operations to completely remove a weld seam. An inexperienced user can now complete this task in a single step.



### For efficient use of the RCD:

Follow the recommended speed and you will see a drastic decrease in your grinding costs, together with a significantly better and, especially, more even finish.

**Recommended speed : 3,600 – 6,000 RPM**

"State of the art" abrasive cloth for the quick, controlled and cool removal of material.

Surface conditioning flaps ensure an even finish even at low pressure.



## BENEFITS

- Controlled material removal
- Forgiving
- Even finish
- Constant and low Ra-value
- Improved finish, even for inexperienced users
- Lower heat generation
- Enormous time savings, only one operation instead of three
- Significant cost savings
- Can be used in a wide variety of applications: stainless steel, aluminium, special alloys, soft metals, wood, auto repair, etc.
- Eco-friendly because less waste is created

## PROPERTIES

- A perfect match between 2 technically advanced abrasive materials with varying abrasive capacities
- Surface Conditioning with a very rapid and even grinding capacity
- Polycotton extra flexible abrasive cloth with grinding aid
- Even wear of both the Surface Conditioning and the abrasive cloth
- Shock reducing effect



## Combi flaps / Glass fibre backing



CONICAL



The optimal rpm for working with the RCD-disc is 3,600 to 6,000 RPM. This way you can prevent areas being burnt, the disc has a longer lifespan and you can maintain absolute control of the grinding process.

### Properties:

- Controlled material removal
- Even finish
- Constant and low Ra-value
- Shock dampening effect
- Lower heat generation
- Very broad application areas : Stainless steel, aluminum, soft metals, special alloys,...

### Applications:

- Finishing light weld seams
- Finishing angles and toothing
- Improving the surface roughness
- Refining coarse grinding lines
- Breaking edges
- Grinding down casting errors
- Etc.

| dimensions | grit | code       | type    | max RPM | advised RPM | stock |  |
|------------|------|------------|---------|---------|-------------|-------|-------------------------------------------------------------------------------------|
| Ø 115x22   | CO   | RCD/CO/115 | Al.-Ox. | 13.300  | 6.000       | ●     | 10                                                                                  |
|            | ME   | RCD/ME/115 | Al.-Ox. | 13.300  | 6.000       | ●     | 10                                                                                  |
|            | VF   | RCD/VF/115 | Al.-Ox. | 13.300  | 6.000       | ●     | 10                                                                                  |
| Ø 125x22   | CO   | RCD/CO/125 | Al.-Ox. | 12.200  | 5.500       | ●     | 10                                                                                  |
|            | ME   | RCD/ME/125 | Al.-Ox. | 12.200  | 5.500       | ●     | 10                                                                                  |
|            | VF   | RCD/VF/125 | Al.-Ox. | 12.200  | 5.500       | ●     | 10                                                                                  |
| Ø 180x22   | ME   | RCD/ME/180 | Al.-Ox. | 8.500   | 3.600       | ●     | 10                                                                                  |



CO = Coarse - ME = Medium - VF = Very Fine





**TIP: The three golden rules for RCD.**

**1**



### WORKING PRESSURE

A well controlled working pressure is important for the end result. Work with the RCD at light pressure.

**2**



### WORKING ANGLE

Grind at an angle of 10° to 15° (between the disc and the work-piece) to enlarge the contact surface

**3**



### GRINDING MOVEMENT

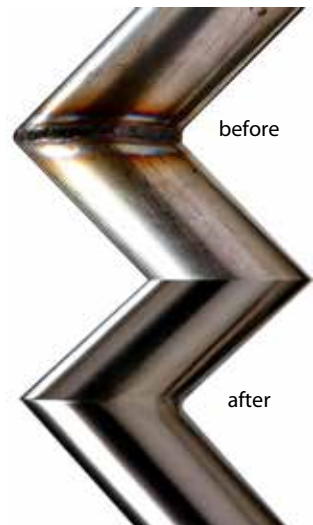
Make a back and forth movement with the RCD lengthwise along the work piece. The grinding movement with an RCD-disc is particularly important. The rotation of the disc is in the direction of the desired structure, the movement of the grinding tool is the opposite direction.



**Tips & tricks: Grind down a weld seam on a round outside angle.**



- Mount the RCD with the help of a flange on a variable speed angle grinder.
- Use the RCD Medium to grind down the weld seam.
- Use the RCD to grind down to the zone where both tubes come in contact with each other at the highest point. This is the point where the round outside corner moves into the hollow inside angle.
- After completing one side using the RCD, repeat the process on the other side.
- This process is completed when the outside angle where both tubes meet is nicely sharp and round, and the outside angle flows nicely into the inside angle.



## > Combi flaps / Glass fibre backing



CONICAL



### RCD - CERAMIC

#### Properties:

- Aggressive disc for a quick stock removal
- Shock dampening effect: controlled material removal
- can be used on aluminum, steel and stainless steel

#### Applications:

- removing heavy weld seams
- Finishing angles and toothing
- Deburring
- Breaking edges

| dimensions | grit | code       | type   | max RPM | advised RPM | stock |    |
|------------|------|------------|--------|---------|-------------|-------|----|
| Ø 115x22   | UC   | RCD/UC/115 | Ceram. | 13.300  | 6.000       | ●     | 10 |
|            | XC   | RCD/XC/115 | Ceram. | 13.300  | 6.000       | ●     | 10 |
| Ø 125x22   | UC   | RCD/UC/125 | Ceram. | 12.200  | 5.500       | ●     | 10 |
|            | XC   | RCD/XC/125 | Ceram. | 12.200  | 5.500       | ●     | 10 |
| Ø 180x22   | XC   | RCD/XC/180 | Ceram. | 8.500   | 3.600       | ●     | 10 |



XC = Extra Coarse - UC = Ultra Coarse

➤ **Combi flaps / Plastic backing**

**RCD - QUICK CHANGE**

- Properties:**
  - Small disk, very manoeuvrable
  - Controlled material removal
  - Even finish
  - Constant and low Ra-value
  - Shock dampening effect
  - Lower heat generation
  - Very broad application areas: Stainless steel, aluminum, soft metals, special alloys,...
- Applications:**
  - Finishing light weld seams
  - Finishing angles and toothing
  - Improving the surface roughness
  - Refining coarse grinding lines
  - Breaking edges
  - Grinding down casting errors

| dimensions | grit | code       | type    | max RPM | advised RPM | stock |  |
|------------|------|------------|---------|---------|-------------|-------|-------------------------------------------------------------------------------------|
| Ø 75       | CO   | MSRC/CO/75 | Socatt® | 10.000  | 5.000       | ●     | 10                                                                                  |
|            | ME   | MSRC/ME/75 | Socatt® | 10.000  | 5.000       | ●     | 10                                                                                  |
|            | CO   | MLRC/CO/75 | Lockit® | 10.000  | 5.000       | ●     | 10                                                                                  |
|            | ME   | MLRC/ME/75 | Lockit® | 10.000  | 5.000       | ●     | 10                                                                                  |

 **CO = Coarse - ME = Medium**

FLAT



## ➤ THE LVT-DISC



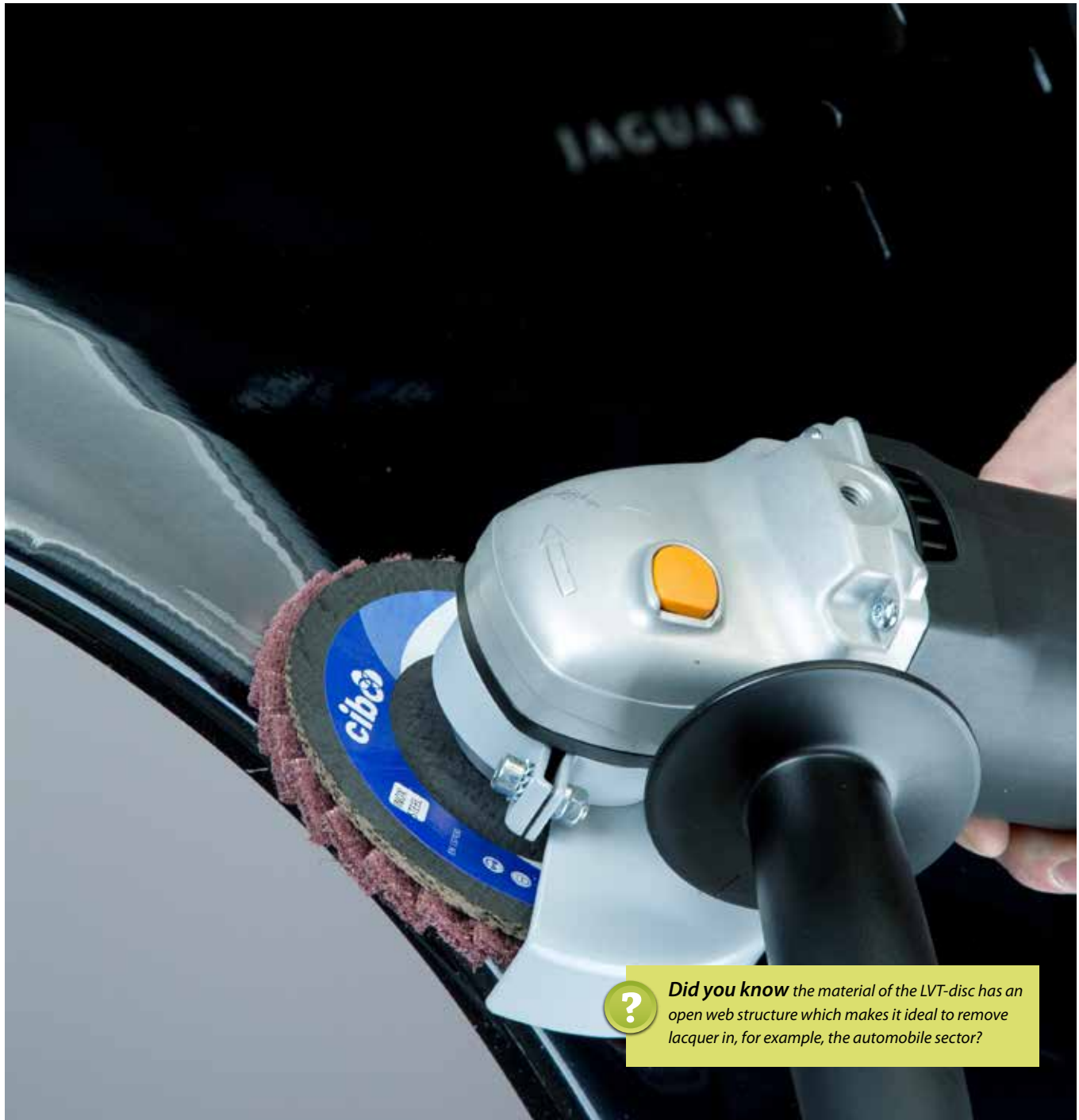
The LVT flap disc is a true finishing disc, not a deburring disc. Whereas the RCD still removes material, the LVT only aims to improve the surface roughness.

The LVT flap disc ensures very low heat generation. This disc never fills up, even with soft materials, electroplating or bodywork.

### PROPERTIES

- Cool finishing due to a significantly low heat generation
- It never fills up
- Extra long lifespan
- Fast results
- Constant finish





**Did you know** the material of the LVT-disc has an open web structure which makes it ideal to remove lacquer in, for example, the automobile sector?

>

Surface Conditioning flap discs / Glass fibre backing



CONICAL



LVT - CONICAL

- Properties:

  - Cool finishing due to a significantly low heat generation
  - It never fills up
  - Extra long lifespan
  - Fast results
  - Constant finish

| dimensions | grit | code        | type    | max RPM | advised RPM | stock |    |
|------------|------|-------------|---------|---------|-------------|-------|----|
| Ø 115x22   | CO   | LVT/RC1/115 | Al.-Ox. | 13.300  | 6.000       | ●     | 10 |
|            | ME   | LVT/RC2/115 | Al.-Ox. | 13.300  | 6.000       | ●     | 10 |
|            | VF   | LVT/RC3/115 | Al.-Ox. | 13.300  | 6.000       | ●     | 10 |
| Ø 125x22   | CO   | LVT/RC1/125 | Al.-Ox. | 12.200  | 5.500       | ●     | 10 |
|            | ME   | LVT/RC2/125 | Al.-Ox. | 12.200  | 5.500       | ●     | 10 |
|            | VF   | LVT/RC3/125 | Al.-Ox. | 12.200  | 5.500       | ●     | 10 |



CO = Coarse - ME = Medium - VF = Very Fine  
Other compositions are possible: contact CIBO.



● = available from stock

● = available in 5 working days

● = on request



## ➤ THE SAG DISC

The SAG is the absolute “missing link” between grinding and high-gloss polishing of round pieces. This disc is composed of unitized material on a glass fibre backing, which makes it a perfect addition to the RCD-discs. The flexible material also adapts perfectly to the shape of the workpiece, allowing you to grind away any scratches or minor damage from your workpiece. The SAG is also the ideal last step prior to polishing. You can create a fantastically even finish for the surface in almost no time at all, and little or no follow-up work is necessary.

The SAG allows you to work in a very controlled manner and to create a beautiful, constant and reproducible finish, time and time again.

Unitized abrasive material combines a reasonable degree of aggression with an excellent finish. Thanks to the fibre's unique structure and the special synthetic resins the unitized material consists of, Cibo can guarantee you a 100% smear-free operation of its disc. The disc is entirely free from iron, allowing it to be used to work stainless steel, all non-ferrous metals, cobalt and titanium alloys.



**Caution :** it is very important that your workpiece is sufficiently cooled before you start working it with the unitized disc!

The SAG consists of 3 different densities, which always determine the hardness, the material removal, the level of finish and the control of the workpiece.



**Did you know** that the pharmaceutical and food sector have very high standards for the surface smoothness of their products, because no traces of food or medication are allowed to remain on the surface? Using the SAG, the Ra-value of the surface can be managed perfectly.



**APPLICATIONS**

- Remove discolouration
- Breaking of corners, deburring and rounding
- Correct grinding errors and remove scratches
- Remove lacquers and coatings
- Remove rust
- Pre-polishing
- Improving surface roughness
- ...



**ADVICE ON SAG/TAG DISCS**

|                  | +               |    |     |     | -                |
|------------------|-----------------|----|-----|-----|------------------|
| density          | hard            |    |     |     | soft             |
|                  | Z7              | A6 | SA7 | SA6 | SA5              |
| material removal | most aggressive |    |     |     | least aggressive |
|                  | Z7              | A6 | SA7 | SA6 | SA5              |
| finish           | finer finish    |    |     |     | coarser finish   |
|                  | Z7              | A6 | SA7 | SA6 | SA5              |



**Speed**

- Always consult the product label with regard to our recommended speed
- Excessive speed can lead to excessive heat generation and premature wear
- A low rpm guarantees maximum efficiency and a better finish

**Pressure**

- Excessive pressure causes additional heat generation, and this can lead to grinding errors and premature wear
- If the pressure is too low, the SAG will grind insufficiently or not at all

### Unitized material / Glass fibre backing



FLAT



SAG - FLAT

- Properties :** Long lifespan, resistance to angles, open web structure, free of iron, does not leave any residue, adapts itself to the workpiece, grinds cooler,...
- Advantages :** Increased productivity, can be used in multiple applications, prevents clogging, no contamination of the workpiece, even finish, prevents damage and burnt areas.

| dimensions | density    | code      | type       | max RPM | advised RPM | stock |   |
|------------|------------|-----------|------------|---------|-------------|-------|---|
| Ø 115x22   | 5 - soft   | SAG/5/115 | Sil. Carb. | 10.000  | 5.000       | ●     | 5 |
|            | 6 - medium | SAG/6/115 | Sil. Carb. | 10.000  | 5.000       | ●     | 5 |
|            | 7 - medium | SAG/7/115 | Sil. Carb. | 10.000  | 5.000       | ●     | 5 |
| Ø 125x22   | 5 - soft   | SAG/5/125 | Sil. Carb. | 8.000   | 4.000       | ●     | 5 |
|            | 6 - medium | SAG/6/125 | Sil. Carb. | 8.000   | 4.000       | ●     | 5 |
|            | 7 - medium | SAG/7/125 | Sil. Carb. | 8.000   | 4.000       | ●     | 5 |

**Keep it cool!**

Always cool the workpiece sufficiently, prior to working it with unitized materials. Too high heat generation can cause the material to melt, and it's excellent properties will go to waste.



#### Tips & tricks : Cleaning surfaces

The SAG is the perfect disc to safely remove lacquer and limited amounts of rust from surfaces.

Unitized is a very forgiving material, allowing you to clean the surface without modifying the geometry of the surface. This is very important with workpieces for which tolerances have to be maintained to ensure that everything fits properly once the parts are cleaned.

The SAG allows you to clean the surface safely and efficiently, without damaging it.

➤ **Unitized material / Glass fibre backing**

**TAG - FLAT**

**Properties:**

- High density
- High cut rate
- cool grinding
- Long lifespan
- Resistance to angles
- Free of iron
- Does not leave any residue

**Advantages:**

- Increased productivity
- No contamination
- Even finish

**Applications:**

- Removing aluminum weld seams
- Finishing TIG weld seams on stainless steel
- Breaking edges, deburring and rounding

| dimensions | density | code       | type    | max RPM | advised RPM | stock |  |
|------------|---------|------------|---------|---------|-------------|-------|-------------------------------------------------------------------------------------|
| Ø 115x22   | A6      | TAG/A6/115 | Al.-Ox. | 10.000  | 5.000       | ●     | 5                                                                                   |
|            | Z7      | TAG/Z7/115 | Zirc.   | 10.000  | 5.000       | ●     | 5                                                                                   |
| Ø 125x22   | A6      | TAG/A6/125 | Al.-Ox. | 8.000   | 4.000       | ●     | 5                                                                                   |
|            | Z7      | TAG/Z7/125 | Zirc.   | 8.000   | 4.000       | ●     | 5                                                                                   |



## FIBRE DISCS

|                                        |     |
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| ● Aluminium oxide<br>with grinding aid | 296 |
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## FIBRE DISCS

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