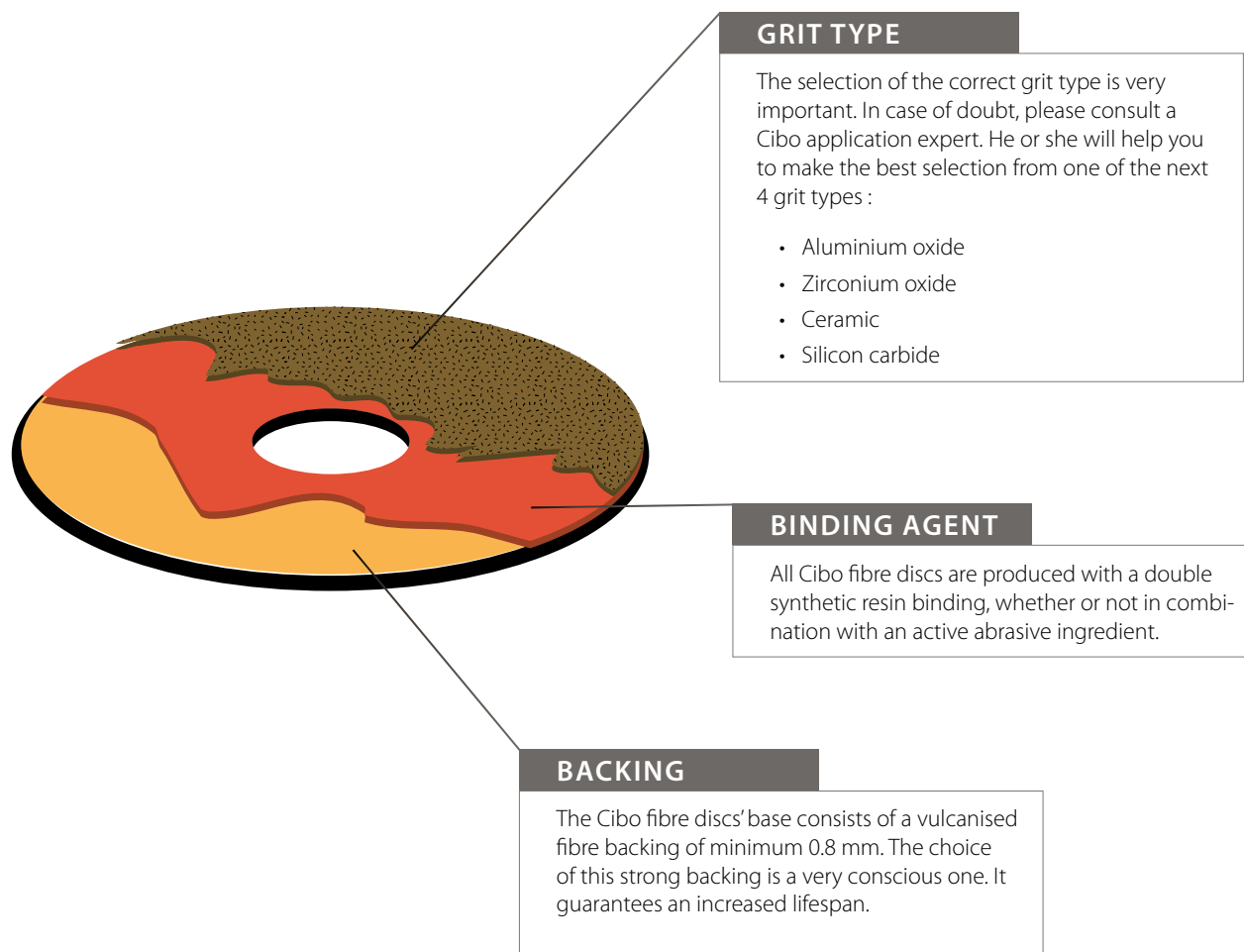




> BUILD-UP OF THE FIBRE DISC





Working pressure

We advise against using too high pressure when using fibre discs. This causes heat generation, burnt areas and premature wear.

Maximum and advised speeds

The maximum speed for all Cibo fibre discs is 80 m/s.

The ideal circumferential speed depends on the material to be worked. It is always best to work at speeds lower than 60 m/s. With silicon carbide discs, it is better to set the speeds based on the material you want to work. Please note, these speeds are not absolute, they are only a guideline. When in doubt, please consult your Cibo advisor.

CENTER HOLES



round center hole

○



star center hole

*



cross center hole

+



Prevent heat generation

By moving the disc smoothly back and forth you can considerably diminish the risk of burnt areas.

ADVICE ON USER SPEEDS (RPM)

	 Cast iron-Steel	 Stainless steel	 Alu-Non-ferrous metal Brass-Copper	 Hardened steel Titanium	 Glass-Stone Ceramic	 Plastics
Ø 115	7.100 - 8.200	4.900 - 5.700	4.500 - 5.100	4.000 - 4.600	2.500 - 2.900	900 - 1.200
Ø 125	6.500 - 7.500	4.500 - 5.200	4.100 - 4.700	3.700 - 4.200	2.300 - 2.700	800 - 1.100
Ø 178	4.500 - 5.200	3.200 - 3.700	2.900 - 3.300	2.600 - 3.000	1.600 - 1.900	600 - 800



FIZ



FIW



FIH

BACK-UP PADS

Fibre discs in combination with the correct back-up pad

Fibre discs must be used in combination with a back-up pad. The choice of back-up pad is important for the finish of your workpiece.

Please find an extensive overview of the different back-up pads of the Cibo product range on page 295.

Flexible back-up pad FIZ

Grinding with a soft contact. This guarantees a controlled removal and a finer finish. Ideally suited for use with finer grit types.

Hard back-up pad FIW

Grinding with a hard contact for a rapid and aggressive removal.

Hard back-up pad – *High performance* FIH

This high-performance back-up pad guarantees a hard and stable contact at all times due to its unique architecture. The ingenious composition of the disc ensures extreme heat resistance. The ribs preventing heat build-up ensure a cooler grinding process, whereby the back-up pad is not distorted under the influence of heat generation.



Please use a high-performance back-up pad up to grit 60 to make optimal use of the fibre disc's capabilities.



Tips & Tricks: Grit choice and back-up pads

For a rapid, aggressive removal of material, your best option is a grit type between 16 and 50.

A hard back-up pad is used for working flat surfaces. This also guarantees rapid removal of material. In order to grind bent and round shapes, and in order to achieve a better level of finish, your best option is a flexible back-up pad.



> Aluminium oxide

ALUMINIUM OXIDE



KFK

Properties :

- Base : fibre 0.8 mm
- Grit type : aluminium oxide

Applications :

- General metal work • Removing paints, primers, filler, etc.
- Sanding old wooden floors and antique beams

dimensions	grit	code	center hole	stock	
Ø 115x22	16	KFK/16/11522	*	●	25
	24	KFK/24/11522	*	●	50
	36	KFK/36/11522	*	●	50
	50	KFK/50/11522	*	●	50
	60	KFK/60/11522	*	●	50
	80	KFK/80/11522	*	●	50
	100	KFK/100/11522	*	●	50
	120	KFK/120/11522	*	●	50
	150	KFK/150/11522	*	●	50
	180	KFK/180/11522	*	●	50
	220	KFK/220/11522	*	●	50
Ø 125x22	16	KFK/16/12522	*	●	25
	24	KFK/24/12522	*	●	50
	36	KFK/36/12522	*	●	50
	50	KFK/50/12522	*	●	50
	60	KFK/60/12522	*	●	50
	80	KFK/80/12522	*	●	50
	100	KFK/100/12522	*	●	50
	120	KFK/120/12522	*	●	50
	150	KFK/150/12522	*	●	50
	180	KFK/180/12522	*	●	50
	220	KFK/220/12522	*	●	50
Ø 180x22	16	KFK/16/18022	*	●	25
	24	KFK/24/18022	*	●	25
	36	KFK/36/18022	*	●	50
	50	KFK/50/18022	*	●	50
	60	KFK/60/18022	*	●	50
	80	KFK/80/18022	*	●	50



KFK

dimensions	grit	code	center hole	stock	
	100	KFK/100/18022	*	●	50
	120	KFK/120/18022	*	●	50
	150	KFK/150/18022	*	●	50
	180	KFK/180/18022	*	●	50
	220	KFK/220/18022	*	●	50

Overview back-up pads : see p. 300



● = available from stock

● = available in 5 working days

● = on request

> Zirconium oxide with grinding aid

ZIRCONIUM OXIDE + ADDITIVE



ZK5

Properties :						• Base : fibre 0,8 mm
Applications :						• Grit type : zirconium oxide + active grinding ingredient • Stainless steel, aluminium, hard steel types, special alloys
dimensions	grit	code	center hole	stock		

Ø 115x22	36	ZK5/36/11522	*	●	50
	50	ZK5/50/11522	*	●	50
	60	ZK5/60/11522	*	●	50
	80	ZK5/80/11522	*	●	50
	100	ZK5/100/11522	*	●	50
	120	ZK5/120/11522	*	●	50
Ø 125x22	36	ZK5/36/12522	*	●	50
	50	ZK5/50/12522	*	●	50
	60	ZK5/60/12522	*	●	50
	80	ZK5/80/12522	*	●	50
	100	ZK5/100/12522	*	●	50
	120	ZK5/120/12522	*	●	50
Ø 180x22	36	ZK5/36/18022	*	●	50
	50	ZK5/50/18022	*	●	50
	60	ZK5/60/18022	*	●	50
	80	ZK5/80/18022	*	●	50
	100	ZK5/100/18022	*	●	50
	120	ZK5/120/18022	*	●	50

 The grinding aid ensures a cool grinding procedure and prevents burnt areas.

> **Zirconium oxide**

K3K – INCREASED AGGRESSIVENESS

- Properties :**
- Base : fibre 0,8 mm
 - Grit type : zirconium oxide
- Applications :**
- Stainless steel, aluminium, chrome, special alloys, hard steel types, etc.

dimensions	grit	code	center hole	stock	
Ø 115x22	24	K3K/24/11522	*	●	50
	36	K3K/36/11522	*	●	50
	50	K3K/50/11522	*	●	50
	60	K3K/60/11522	*	●	50
	80	K3K/80/11522	*	●	50
	120	K3K/120/11522	*	●	50
Ø 125x22	24	K3K/24/12522	*	●	50
	36	K3K/36/12522	*	●	50
	50	K3K/50/12522	*	●	50
	60	K3K/60/12522	*	●	50
	80	K3K/80/12522	*	●	50
	120	K3K/120/12522	*	●	50
Ø 180x22	24	K3K/24/18022	*	●	25
	36	K3K/36/18022	*	●	50
	50	K3K/50/18022	*	●	50
	60	K3K/60/18022	*	●	50
	80	K3K/80/18022	*	●	50
	120	K3K/120/18022	*	●	50

Overview back-up pads : see p. 300

ZIRCONIUM OXIDE



Did you know the K3K is the most popular disc in the stainless steel series?

● = available from stock

● = available in 5 working days

● = on request

> Ceramic with grinding aid

CERAMIC + ADDITIVE



FX

- Properties :

 - Base : fibre 0.8 mm
 - Grit type : ceramic
- Applications :

 - Stainless steel, chrome, hard steel types, etc.
 - Ideally suited for demanding applications
 - Rapid and cool stock removal

dimensions	grit	code	center hole	stock	
Ø 115x22	36	FX/36/11522	+	●	50
	40	FX/40/11522	+	●	50
	60	FX/60/11522	+	●	50
	80	FX/80/11522	+	●	50
	120	FX/120/11522	+	●	50
Ø 125x22	36	FX/36/12522	+	●	50
	40	FX/40/12522	+	●	50
	60	FX/60/12522	+	●	50
	80	FX/80/12522	+	●	50
	120	FX/120/12522	+	●	50
Ø 180x22	36	FX/36/18022	+	●	50
	40	FX/40/18022	+	●	50
	60	FX/60/18022	+	●	50
	80	FX/80/18022	+	●	50
	120	FX/120/18022	+	●	50

Overview back-up pads : see p. 300



➤ Silicon carbide

DC82					
Properties : • Base : fibre 0.8 mm • Grit type : silicon carbide					
Applications : • Non-ferrous metals, cast iron, marble, granite, stone, concrete, etc.					
dimensions	grit	code	center hole	stock	
Ø 115x22	24	DC/24/11522	+	●	100
	36	DC/36/11522	+	●	100
	60	DC/60/11522	+	●	100
	80	DC/80/11522	+	●	100
	120	DC/120/11522	+	●	100
	150	DC/150/11522	+	●	100
	180	DC/180/11522	+	●	100
	220	DC/220/11522	+	●	100
	320	DC/320/11522	+	●	100
Ø 125x22	36	DC/36/12522	+	●	100
	60	DC/60/12522	+	●	100
	80	DC/80/12522	+	●	100
	120	DC/120/12522	+	●	100
	220	DC/220/12522	+	●	100
	320	DC/320/12522	+	●	100
Ø 180x22	16	DC/16/18022	○	●	50
	24	DC/24/18022	○	●	100
	36	DC/36/18022	○	●	100
	50	DC/50/18022	○	●	100
	60	DC/60/18022	○	●	100
	80	DC/80/18022	○	●	100
	120	DC/120/18022	○	●	100
	150	DC/150/18022	○	●	100
	180	DC/180/18022	○	●	100
	220	DC/220/18022	○	●	100
	320	DC/320/18022	○	●	100
	400	DC/400/18022	○	●	100

SILICON CARBIDE



● = available from stock

● = available in 5 working days

● = on request

➤ Fibre disc back-up pads for angle grinder

HARD BACK-UP PAD



HARD BACK-UP PAD

- Properties:**
- Grinding with hard contact
 - Faster and more aggressive material removal

diameter	attach- ment	code	stock	
Ø 115	M14	FIW115	●	1
Ø 125	M14	FIW125	●	1
Ø 171	M14	FIW178	●	1
Ø 218	M14	FIW230	●	1

FLEXIBLE BACK-UP PAD



FLEXIBLE BACK-UP PAD

- Properties:**
- Grinding with soft contact
 - Controlled removal
 - Finer finish

diameter	attach- ment	code	stock	
Ø 115	M14	FIZ115	●	1
Ø 125	M14	FIZ125	●	1
Ø 171	M14	FIZ178	●	1
	5/8"	FIZ179	●	1
Ø 218	M14	FIZ230	●	1

HARD BACK-UP PAD (HP)



HARD BACK-UP PAD - HIGH PERFORMANCE

- Properties:**
- Ventilated back-up pads
 - Guarantee a hard and stable contact at all times
 - Extremely heat-resistant

diameter	attach- ment	code	stock	
Ø 115	M14	FIH115	●	1
Ø 125	M14	FIH125	●	1
Ø 171	M14	FIH178	●	1





QUICK CHANGE

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Cibo will very quickly produce for you any size, grade or grit that is not listed in the overview.
After all, customisation is the norm at Cibo.

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





QUICK CHANGE