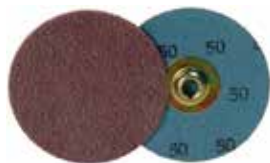




> GENERAL INFO



SOCATT®

Socatt® discs have a metal attachment plate on the disc and a quick change mechanism in the support. Socatt® guarantees a safe and durable attachment. You can change a disc in no time. Socatt® is the most popular quick change system worldwide. All Socatt® quick change discs are adaptable to all Speed-Lock supports.



LOCKIT® / ROLOC®

The Lockit® / Roloc® discs are provided with a nylon disc with a screw thread. This screw thread fits into the attachment system of the support. These discs fit on all Lockit® and Roloc® supports. You can easily exchange a disc with half a turn.

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



Benefits

- Firm attachment of the discs
- The diameter of the disc and flexibility of the support allow for accurate working
- Can be changed very quickly
- Due to the large variety of discs and supports, we can provide the correct grinding disc for each application
- Use of adapted discs guarantees a longer lifespan
- The disc is always centred on the support

To be mounted on

To be used on angle grinders, drills and machines with flexible shafts.

Build up of the discs

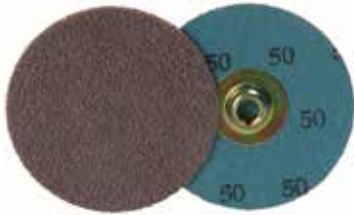
Quick Change discs are laminated and the bases are usually built of several layers (2ply = 2 layers). This has the advantage that they have a much longer lifespan, and a more rapid removal of material can be guaranteed. Laminated discs may be used under very high pressure and resistance.

ADVICE ON USER SPEEDS (RPM)					
 Never exceed the max. speed of the support!					
General	Ø 25	19,000-25,000	16,000-20,000	12,000-16,000	8,000-12,000
	Ø 38	12,500-15,000	10,000-12,500	7,500-10,000	5,000-7,500
	Ø 50	10,000-12,000	7,500-9,500	5,500-7,500	4,000-5,500
	Ø 75	6,500-7,500	5,000-6,500	3,500-5,000	2,500-3,500
Reinforced Tex	Ø 25	–	13,600-17,000	10,200-13,600	6,800-10,200
	Ø 50	–	6,375-8,000	4,700-6,300	3,400-4,600
	Ø 75	–	4,250-5,500	2,900-4,300	2,100-2,900

> **Socatt®**

ALUMINIUM OXIDE

ALUMINIUM OXIDE 2PLY



Applications :

- Grinding down pointed welds, unevenness and damage
- Can be used on all ferrous metals

diameter	grit	code	max RPM	stock	
Ø 25	36	QSAO/36/25	40.000	●	100
	40	QSAO/40/25	40.000	●	100
	60	QSAO/60/25	40.000	●	100
	80	QSAO/80/25	40.000	●	100
	120	QSAO/120/25	40.000	●	100
	240	QSAO/240/25	40.000	●	100
Ø 38	36	QSAO/36/38	25.000	●	100
	40	QSAO/40/38	25.000	●	100
	60	QSAO/60/38	25.000	●	100
	80	QSAO/80/38	25.000	●	100
	120	QSAO/120/38	25.000	●	100
	240	QSAO/240/38	25.000	●	100
Ø 50	36	QSAO/36/50	25.000	●	100
	40	QSAO/40/50	25.000	●	100
	60	QSAO/60/50	25.000	●	100
	80	QSAO/80/50	25.000	●	100
	120	QSAO/120/50	25.000	●	100
	240	QSAO/240/50	25.000	●	100
	320	QSAO/320/50	25.000	●	100
Ø 75	36	QSAO/36/75	20.000	●	50
	40	QSAO/40/75	20.000	●	50
	60	QSAO/60/75	20.000	●	50
	80	QSAO/80/75	20.000	●	50
	120	QSAO/120/75	20.000	●	50
	240	QSAO/240/75	20.000	●	50

 Socatt®

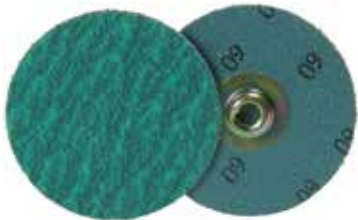
WITH GRINDING AID 2PLY

Properties : With heat-resistant additive
Applications : Ideally suited to work stainless steel, titanium alloys, etc.

diameter	grit	code	max RPM	stock	
Ø 25	36	QSPZ/36/25	40.000	●	100
	50	QSPZ/50/25	40.000	●	100
	60	QSPZ/60/25	40.000	●	100
	80	QSPZ/80/25	40.000	●	100
	120	QSPZ/120/25	40.000	●	100
Ø 38	36	QSPZ/36/38	25.000	●	100
	50	QSPZ/50/38	25.000	●	100
	60	QSPZ/60/38	25.000	●	100
	80	QSPZ/80/38	25.000	●	100
	120	QSPZ/120/38	25.000	●	100
Ø 50	36	QSPZ/36/50	25.000	●	100
	50	QSPZ/50/50	25.000	●	100
	60	QSPZ/60/50	25.000	●	100
	80	QSPZ/80/50	25.000	●	100
	120	QSPZ/120/50	25.000	●	100
Ø 75	36	QSPZ/36/75	20.000	●	50
	50	QSPZ/50/75	20.000	●	50
	60	QSPZ/60/75	20.000	●	50
	80	QSPZ/80/75	20.000	●	50
	120	QSPZ/120/75	20.000	●	50

Overview supports: see p. 319

ZIRCONIUM OXIDE



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

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

> Socatt®

CERAMIC



Advantages:

- Faster material removal, combined with a long lifespan and amazing resistance to burrs and angles.
- Unbeatable in terms of aggressiveness and lifespan!

CERAMIC – WITH GRINDING AID 2PLY

Applications : Best choice for stock removal of hard steel and exotic steel alloys

- Properties :**
- Ceramic grit type
 - Top coating for cooler grinding
 - High pressure is required

diameter	grit	code	max RPM	stock	
Ø 25	36	QSPP/36/25	40.000	●	100
	60	QSPP/60/25	40.000	●	100
	80	QSPP/80/25	40.000	●	100
	120	QSPP/120/25	40.000	●	100
Ø 38	36	QSPP/36/38	25.000	●	100
	60	QSPP/60/38	25.000	●	100
	80	QSPP/80/38	25.000	●	100
	120	QSPP/120/38	25.000	●	100
Ø 50	36	QSPP/36/50	25.000	●	100
	60	QSPP/60/50	25.000	●	100
	80	QSPP/80/50	25.000	●	100
	120	QSPP/120/50	25.000	●	100
Ø 75	36	QSPP/36/75	20.000	●	50
	60	QSPP/60/75	20.000	●	50
	80	QSPP/80/75	20.000	●	50
	120	QSPP/120/75	20.000	●	50



Please consult Cibo for other sizes, qualities and grits.

➤ **Socatt®**

CERAMIC ON FIBRE 2PLY

Properties: Retains its shape better, with less wear and harder contact than the 2PLY
Applications : Grinding down weld seams, burrs and imperfections

diameter	grit	code	max RPM	stock	
Ø 50	36	QSFC/36/50	25.000	●	100
	60	QSFC/60/50	25.000	●	100
	80	QSFC/80/50	25.000	●	100
	120	QSFC/120/50	25.000	●	100
Ø 75	36	QSFC/36/75	20.000	●	50
	60	QSFC/60/75	20.000	●	50
	80	QSFC/80/75	20.000	●	50
	120	QSFC/120/75	20.000	●	50

Overview supports: see p. 319

CERAMIC ON FIBRE



➤ **Combi flaps / Plastic backing**

RCD - QUICK CHANGE

Properties:

- Small disk, very manoeuvrable
- Controlled material removal
- 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	max RPM	advised RPM	stock	
Ø 75	CO	MSRC/CO/75	10.000	5.000	●	10
	ME	MSRC/ME/75	10.000	5.000	●	10

FLAT



 **CO = Coarse - ME = Medium**

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

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

> Socatt®

ZIRCONIUM OXIDE

MINIFLAP – ZIRCONIUM OXIDE



Properties : The properties of a flap disc are now also available in Quick Change:

- Longer lifespan
- Less frequent disc replacements
- Overlapping flaps ensure a better resistance to angles
- Less heat generation
- Greater accessibility

diameter	grit	code	max RPM	stock	
Ø 50	40	MSZV/40/50	15.000	●	10
	60	MSZV/60/50	15.000	●	10
	80	MSZV/80/50	15.000	●	10
	120	MSZV/120/50	15.000	●	10
Ø 75	40	MSZV/40/75*	10.000	●	10
	60	MSZV/60/75*	10.000	●	10
	80	MSZV/80/75*	10.000	●	10
	120	MSZV/120/75*	10.000	●	10



(*) Caution! Use Ø75 only with support QSRH/M/75M14/MF. See p. 319

Socatt®

TEX 2PLY

Applications : Removing, refining and improving surface errors, minor oxidation, primary rust, primary burrs, casting errors, residue on moulds, structured surfaces, etc.

diameter	grit	code	max RPM	stock	
Ø 50	ME	QSBB/M/50	12.000	●	50
	F	QSBB/F/50	12.000	●	50
	VF	QSBB/VF/50	12.000	●	50
Ø 75	ME	QSBB/M/75	8.000	●	25
	F	QSBB/F/75	8.000	●	25
	VF	QSBB/VF/75	8.000	●	25

TEX



REINFORCED TEX - SURFACE CONDITIONING

Applications : Removing and refining minor burrs, weld spatter, milling lines, minor damage, grinding lines, paint, coatings, seals, glue, weld seams, etc.

diameter	grit	code	max RPM	stock	
Ø 25	CO	QSVT/ST1/25	15.000	●	50
	ME	QSVT/ST2/25	15.000	●	50
	VF	QSVT/ST3/25	15.000	●	50
Ø 50	CO	QSVT/ST1/50	12.000	●	50
	ME	QSVT/ST2/50	12.000	●	50
	VF	QSVT/ST3/50	12.000	●	50
Ø 75	CO	QSVT/ST1/75	10.000	●	25
	ME	QSVT/ST2/75	10.000	●	25
	VF	QSVT/ST3/75	10.000	●	25

SURFACE CONDITIONING



Overview supports: see p. 319

 Never exceed the maximum rpm! For the speed recommended by Cibo, see p. 305

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

> Socatt®

UNITIZED



UNITIZED

- Applications :**
- For applications in which the contact surface of the disc has to be relatively small, or where the control of the grinding activity is important
 - Weld discolourations
 - Removing milling lines
 - Improving surface roughness

diameter	thick- ness	density	code	max RPM	stock	
Ø 50	3	7 - medium	QSSA/7/503	18.000	●	10
	3	8 - hard	QSSA/8/503	18.000	●	10
	6	5 - soft	QSSA/5/506	18.000	●	10
	6	6 - medium	QSSA/6/506	18.000	●	10
	6	7 - medium	QSSA/7/506	18.000	●	10
	6	8 - hard	QSSA/8/506	18.000	●	10
Ø 75	3	7 - medium	QSSA/7/753	12.000	●	10
	3	8 - hard	QSSA/8/753	12.000	●	10
	6	5 - soft	QSSA/5/756	12.000	●	10
	6	6 - medium	QSSA/6/756	12.000	●	10
	6	7 - medium	QSSA/7/756	12.000	●	10
	6	8 - hard	QSSA/8/756	12.000	●	10



➤ **Lockit® / Roloc®**

ALUMINIUM OXIDE 2ply

Applications :

- Grinding down pointed welds, unevenness and damage
- Can be used on all ferrous metals

diameter	grit	code	max RPM	stock	
Ø 25	36	QLAO/36/25	40.000	●	100
	40	QLAO/40/25	40.000	●	100
	60	QLAO/60/25	40.000	●	100
	80	QLAO/80/25	40.000	●	100
	120	QLAO/120/25	40.000	●	100
Ø 38	36	QLAO/36/38	25.000	●	100
	40	QLAO/40/38	25.000	●	100
	60	QLAO/60/38	25.000	●	100
	80	QLAO/80/38	25.000	●	100
	120	QLAO/120/38	25.000	●	100
Ø 50	36	QLAO/36/50	25.000	●	100
	40	QLAO/40/50	25.000	●	100
	60	QLAO/60/50	25.000	●	100
	80	QLAO/80/50	25.000	●	100
	120	QLAO/120/50	25.000	●	100
Ø 75	36	QLAO/36/75	20.000	●	50
	40	QLAO/40/75	20.000	●	50
	60	QLAO/60/75	20.000	●	50
	80	QLAO/80/75	20.000	●	50
	120	QLAO/120/75	20.000	●	50

Overview supports : see p. 319

ALUMINIUM OXIDE



Please consult Cibo for other sizes, qualities and grits.

● = available from stock

● = available in 5 working days

● = on request

ZIRCONIUM OXIDE



> Lockit® / Roloc®

ZIRCONIUM OXIDE – WITH GRINDING AID 2PLY

Properties : Heat resistant additive

Applications : Ideally suited for working stainless steel, titanium alloys, etc.

diameter	grit	code	max RPM	stock	
Ø 25	36	QLPZ/36/25	40.000	●	100
	50	QLPZ/50/25	40.000	●	100
	60	QLPZ/60/25	40.000	●	100
	80	QLPZ/80/25	40.000	●	100
	120	QLPZ/120/25	40.000	●	100
Ø 38	36	QLPZ/36/38	25.000	●	100
	50	QLPZ/50/38	25.000	●	100
	60	QLPZ/60/38	25.000	●	100
	80	QLPZ/80/38	25.000	●	100
	120	QLPZ/120/38	25.000	●	100
Ø 50	36	QLPZ/36/50	25.000	●	100
	50	QLPZ/50/50	25.000	●	100
	60	QLPZ/60/50	25.000	●	100
	80	QLPZ/80/50	25.000	●	100
	120	QLPZ/120/50	25.000	●	100
Ø 75	36	QLPZ/36/75	20.000	●	50
	50	QLPZ/50/75	20.000	●	50
	60	QLPZ/60/75	20.000	●	50
	80	QLPZ/80/75	20.000	●	50
	120	QLPZ/120/75	20.000	●	50

➤ **Lockit® / Roloc®**

CERAMIC – WITH GRINDING AID

- Applications :** Best choice for heavy stock removal of steel and stainless steel
- Properties :**
- Ceramic grit type
 - Top coating for cooler grinding
 - High pressure is required

diameter	grit	code	max RPM	stock	
Ø 25	36	QLPP/36/25	40.000	●	100
	60	QLPP/60/25	40.000	●	100
	80	QLPP/80/25	40.000	●	100
	120	QLPP/120/25	40.000	●	100
Ø 38	36	QLPP/36/38	25.000	●	100
	60	QLPP/60/38	25.000	●	100
	80	QLPP/80/38	25.000	●	100
	120	QLPP/120/38	25.000	●	100
Ø 50	36	QLPP/36/50	25.000	●	100
	60	QLPP/60/50	25.000	●	100
	80	QLPP/80/50	25.000	●	100
	120	QLPP/120/50	25.000	●	100
Ø 75	36	QLPP/36/75	20.000	●	50
	60	QLPP/60/75	20.000	●	50
	80	QLPP/80/75	20.000	●	50
	120	QLPP/120/75	20.000	●	50

CERAMIC



Advantages:

- Faster material removal,combined with a long lifespan and amazing resistance to burrs and angles.
- Unbeatable in terms of aggressiveness and lifespan!



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

CERAMIC ON FIBRE



> Lockit® / Roloc®

CERAMIC ON FIBRE

Properties: Retains its shape better, with less wear and harder contact than the 2PLY
Applications : Grinding down weld seams, burrs and imperfections

diameter	grit	code	max RPM	stock	
Ø 50	36	QLFC/36/50	25.000	●	100
	60	QLFC/60/50	25.000	●	100
	80	QLFC/80/50	25.000	●	100
	120	QLFC/120/50	25.000	●	100
Ø 75	36	QLFC/36/75	20.000	●	50
	60	QLFC/60/75	20.000	●	50
	80	QLFC/80/75	20.000	●	50
	120	QLFC/120/75	20.000	●	50

Overview supports: see p. 319

> Lockit®

RCD - QUICK CHANGE



FLAT



Properties:

- Small disk, very manoeuvrable
- Controlled material removal
- 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

diameter	grit	code	max RPM	advised TPM	stock	
Ø 75	CO	MLRC/CO/75	10.000	5.000	●	10
	ME	MLRC/ME/75	10.000	5.000	●	10

i CO = Coarse - ME = Medium

➤ **Lockit® / Roloc®**

MINIFLAP – ZIRCONIUM OXIDE

Properties : The properties of a flap disc are now also available in Quick Change:

- Longer lifespan
- Less frequent disc replacements
- Overlapping flaps ensure a better resistance to angles
- Less heat generation
- Greater accessibility

diameter	grit	code	max RPM	stock	
Ø 50	40	MLZV/40/50	15.000	●	10
	60	MLZV/60/50	15.000	●	10
	80	MLZV/80/50	15.000	●	10
	120	MLZV/120/50	15.000	●	10
Ø 75	40	MLZV/40/75	10.000	●	10
	60	MLZV/60/75	10.000	●	10
	80	MLZV/80/75	10.000	●	10
	120	MLZV/120/75	10.000	●	10

ZIRCONIUM OXIDE



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

> Lockit® / Roloc®

SURFACE CONDITIONING



REINFORCED TEX - SURFACE CONDITIONING

Applications : Removing and refining minor burrs, weld spatter, milling lines, minor damage, grinding lines, oxidation, paint, coatings, seals, glue, weld seams, etc.

diameter	grit	code	max RPM	stock	
Ø 50	CO	QLVT/ST1/50	12.000	●	50
	ME	QLVT/ST2/50	12.000	●	50
	VF	QLVT/ST3/50	12.000	●	50
Ø 75	CO	QLVT/ST1/75	10.000	●	25
	ME	QLVT/ST2/75	10.000	●	25
	VF	QLVT/ST3/75	10.000	●	25

UNITIZED



UNITIZED

Applications :

- For applications in which the contact surface of the disc has to be relatively small, or where the control of the grinding activity is important
- Weld discolourations
- Removing milling lines
- Improving surface roughness

diameter	thick-ness	density	code	max RPM	stock	
Ø 50	3	7 - medium	QLSA/7/503	18.000	●	10
	3	8 - hard	QLSA/8/503	18.000	●	10
	6	5 - soft	QLSA/5/506	18.000	●	10
	6	6 - medium	QLSA/6/506	18.000	●	10
	6	7 - medium	QLSA/7/506	18.000	●	10
	6	8 - hard	QLSA/8/506	18.000	●	10
Ø 75	3	7 - medium	QLSA/7/753	12.000	●	10
	3	8 - hard	QLSA/8/753	12.000	●	10
	6	5 - soft	QLSA/5/756	12.000	●	10
	6	6 - medium	QLSA/6/756	12.000	●	10
	6	7 - medium	QLSA/7/756	12.000	●	10
	6	8 - hard	QLSA/8/756	12.000	●	10

OVERVIEW SUPPORTS

Lockit® / Roloc® back-up pads

LOCKIT® / ROLOC® HEAT-RESISTANT

diameter	density	diameter shaft	attach-ment	code	max RPM	stock	
Ø 25	medium	Ø 6	–	QLHO/M/256	40.000	●	1
Ø 38	hard	Ø 6	–	QLHO/H/386	25.000	●	1
	medium	Ø 6	–	QLHO/M/386	25.000	●	1
	soft	Ø 6	–	QLHO/S/386	25.000	●	1
Ø 50	hard	Ø 6	–	QLHO/H/506	25.000	●	1
	medium	Ø 6	–	QLHO/M/506	25.000	●	1
	soft	Ø 6	–	QLHO/S/506	25.000	●	1
Ø 75	hard	Ø 6	–	QLHO/H/756	20.000	●	1
	medium	Ø 6	–	QLHO/M/756	20.000	●	1
	soft	Ø 6	–	QLHO/S/756	20.000	●	1
Ø 50	medium	–	M14	QLRH/M/50M14	25.000	●	1
Ø 75	medium	–	M14	QLRH/M/75M14	20.000	●	1

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

Socatt® back-up pads

SOCATT® HEAT-RESISTANT

diameter	density	diameter shaft	attach-ment	code	max RPM	stock	
Ø 19	medium	Ø 6	–	QSHO/M/196	40.000	●	1
Ø 25	medium	Ø 6	–	QSHO/M/256	40.000	●	1
Ø 38	hard	Ø 6	–	QSHO/H/386	25.000	●	1
	medium	Ø 6	–	QSHO/M/386	25.000	●	1
	soft	Ø 6	–	QSHO/S/386	25.000	●	1
Ø 50	hard	Ø 6	–	QSHO/H/506	25.000	●	1
	medium	Ø 6	–	QSHO/M/506	25.000	●	1
	soft	Ø 6	–	QSHO/S/506	25.000	●	1
Ø 75	hard	Ø 6	–	QSHO/H/756	20.000	●	1
	medium	Ø 6	–	QSHO/M/756	20.000	●	1
	soft	Ø 6	–	QSHO/S/756	20.000	●	1
Ø 50	medium	–	M14	QSRH/M/50M14	25.000	●	1
Ø 75	medium	–	M14	QSRH/M/75M14	25.000	●	1
	medium	–	M14	QSRH/M/75M14/MF*	25.000	●	1

 * The Socatt® Miniflap, diameter of 75mm (see p. 310), is only to be used in combination with this special back-up pad!

● = available from stock

● = available in 5 working days

● = on request

LOCKIT® / ROLOC®



SOCATT®



CUTTING AND GRINDING DISCS

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CUTTING AND GRINDING DISCS
