



10388236
F-23543

PFERD



Germany



www.pferd.com



SG-ELASTIC
00 PT 500-5 A 24 SG
Stahl - Steel - Acier - Accro

929 891

PFERD



Germany



Safety code

EN 12413
41 A 16 K
RF 80
80 mm - 16mm
4400 RPM
10-ECIP: 84082

WARNING: Improper use may cause personal damage or serious machine damage. Consult with local authorities and OSHA regulations. Read all instructions. Use safety glasses and proper work practices.



SG-ELASTIC
80 T 350-2,8 A 36 K SG-CHOP
Stahl - Steel - Acier - Accro

891 291

www.pferd.com
250 x 2,8 x 25,4 mm
10 x 1/2 x 1"



Stationary Cut-Off Wheels

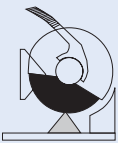

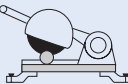

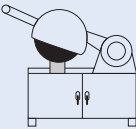

Table of Contents, Cutting Processes

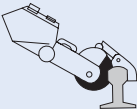

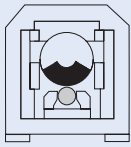

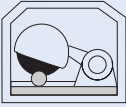




Cut-off wheels for stationary machines are allocated to the PFERD performance line SG-ELASTIC.

Product labels and packaging are marked "Silver" in accordance to the colour coding system catalogue 206 "Grinding and Cut-Off Wheels".

Contents	Page
■ Table of contents, cutting processes	2
■ General information	3-5

Tool drive	Contents	Page
 < 3 KW	 CHOPSAW Cut-off wheels for cutting solid material, profiles and pipes	6
 3-5 KW	 TABLECUT Cut-off wheels for cutting solid material, profiles and pipes	7
 > 5 KW	 UNIVERSAL Cut-off wheels for cutting solid material, profiles and pipes	8

Tool drive	Contents	Page
	 RAIL Special cut-off wheels for rail cutting	9
	 HEAVY DUTY High-performance cut-off wheels for cutting solid material, profiles and pipes with stationary high-performance machines	10
	 LABORATORY High-performance cut-off wheels for cutting of laboratory samples	11
	 For detailed information and ordering data on grinding and cut-off wheels for manual use please refer to catalogue 206.	

Cutting processes

Basically we differentiate between four cutting processes. Each of which have developed through special application demands.



Chop stroke



Horizontal



Oscillation

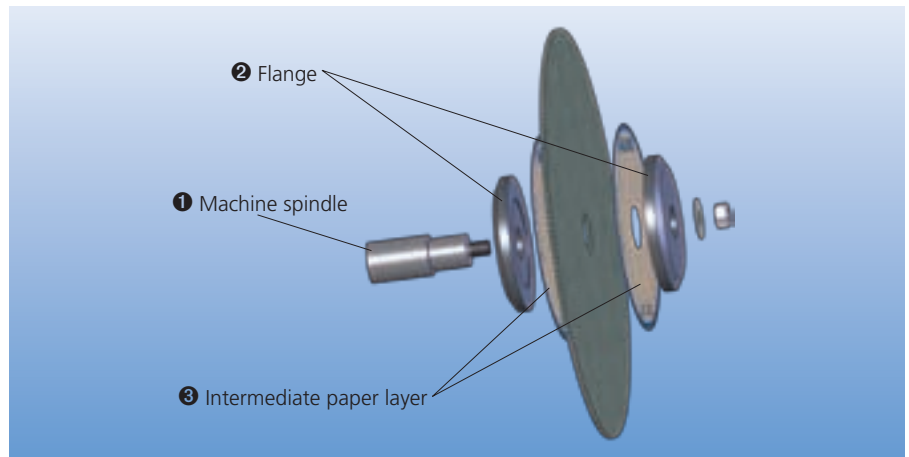


Rotary

Optimum clamping of cut-off wheels

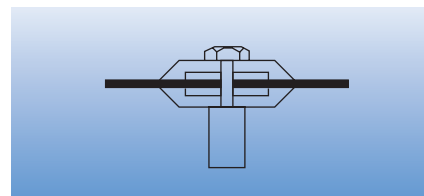
The prerequisite for optimum cut-off wheel performance is correct clamping. This is vital for protecting the user's safety. The adjacent figure shows the things to be observed:

- ❶ Machine spindle with high concentricity,
 - ❷ flanges of equal size and
 - ❸ intermediate paper layers if required for secure clamping and safe usage.
- Our recommendations:
- Replace the intermediate paper layers after every second wheel change.
 - Always use intermediate paper layers with a disc diameter of > 400 mm.

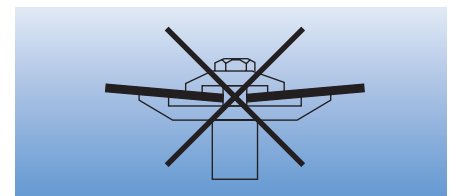


Please observe!

The use of flanges with two unequal diameters is not permitted. The clamping system must be regularly inspected. Both flanges, between which the grinding tool is mounted, must have the same diameter and the same contact surfaces (acc. to EN 60745-2-3:2007, AS 1788.1:1987, ANSI B7.1:2000).



Correct



Incorrect

Maximum operating speed

Max. operating speed	Colour bar
80 m/s	red
100 m/s	green

Safety standards

PFERD cut-off wheels conform to the highest quality and safety requirements and are marked according to EN 12413:2007 for grinding tools made of bonded abrasives.

PFERD is an oSa founding member

Together with other manufacturers, PFERD has undertaken voluntarily to produce quality tools conforming to the most exacting safety standards.

oSa member companies manufacture to the most stringent specifications worldwide and are committed to continuous product safety and quality monitoring. PFERD tools carry the oSa mark.



Safety recommendations



= Wear eye protection!



= Wear hearing protection!



= Wear a respirator!



= Wear gloves!



= Read the instructions!



= Do not use if damaged!



= Not permitted for hand-held or manually guided grinding!

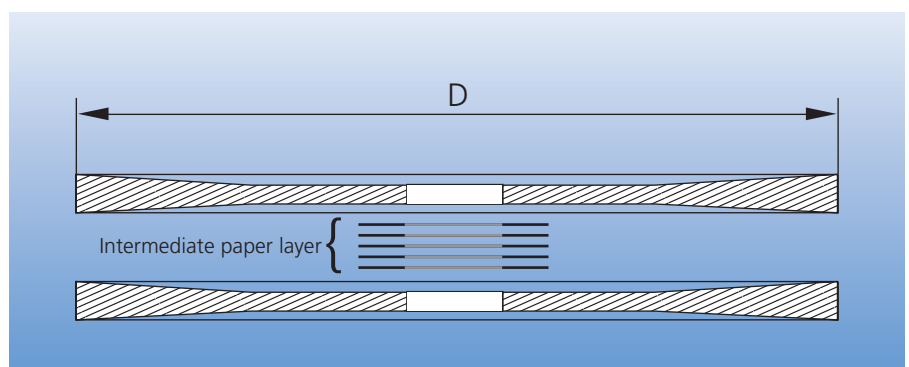
Storage of cut-off wheels

Please always store cut-off wheels horizontally in dry rooms.

An even load on a flat support is necessary to stop the cut-off wheels distorting.

Guideline on storing tapered wheels (CT)

Tapered cut-off wheels must always be stacked with intermediate paper layers. Wheels must be subject to uniform loads and placed on a flat surface to prevent warping.



Advantages of stationary cut-off grinding

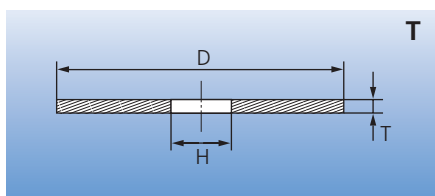
- Universal cutting process for all steels, cast iron, non-ferrous metal alloys and special alloys.
- Smooth cutting surfaces and blank cuts during cold cutting-off.
- Short cutting times, independent of the material quality e.g. material dia. 100 mm cold cut-off in approx. 7 s/cut hot cut-off in approx. 4 s/cut.
- Easy cutting of steels which cannot be sawn or flame cut.
- Consistent cutting quality over entire cut-off wheel lifetime until it is completely used up, due to the continuous self-sharpening process.
- A method of cutting cooled rolled or forged parts in hot cut lines.
- Low thermal load on parts being cold cut.
- Cost-effective cutting procedure.
- Far less burr formation with hot cutting compared to hot sawing.
- Lower noise level than hot sawing, e.g. hot cut 85-95 dBA in comparison to hot sawing 105-110 dBA.

Dimensions, manufactured to customer orders

Dia. D [mm]	Type			Bores H (Standard) [mm]
	T	PT	CT	
250	●	-	-	25,4/30/32
300	●	-	-	25,4/32/40
350	●	-	-	25,4/32/40
400	●	-	-	25,4/32/40
450	●	-	-	25,4/32/40
500	●	●	-	40/60/76,2
600	●	●	-	40/60/76,2
660	●	-	-	40/60/80
700	●	●	-	60/80/100
800	●	●	●	80/100/152,4
1.000	-	-	●	100/127/152,4
1.250	-	-	●	127/152,4/230

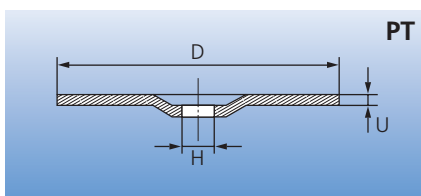
Special bores are available on request!

Types



Flat type T

- Suitable for general use.

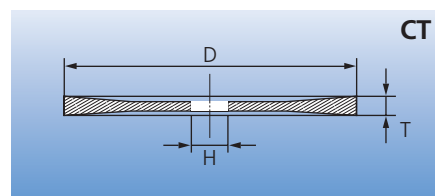


Depressed centre type PT

Particularly suitable for foundries.

Advantages:

- The clamping flange does not project over the side surfaces of the cut-off wheel.
- Flush separation of risers on cast pieces possible.
- No subsequent finishing necessary.



Tapered type CT

Particularly suitable for hot cutting.

Advantages:

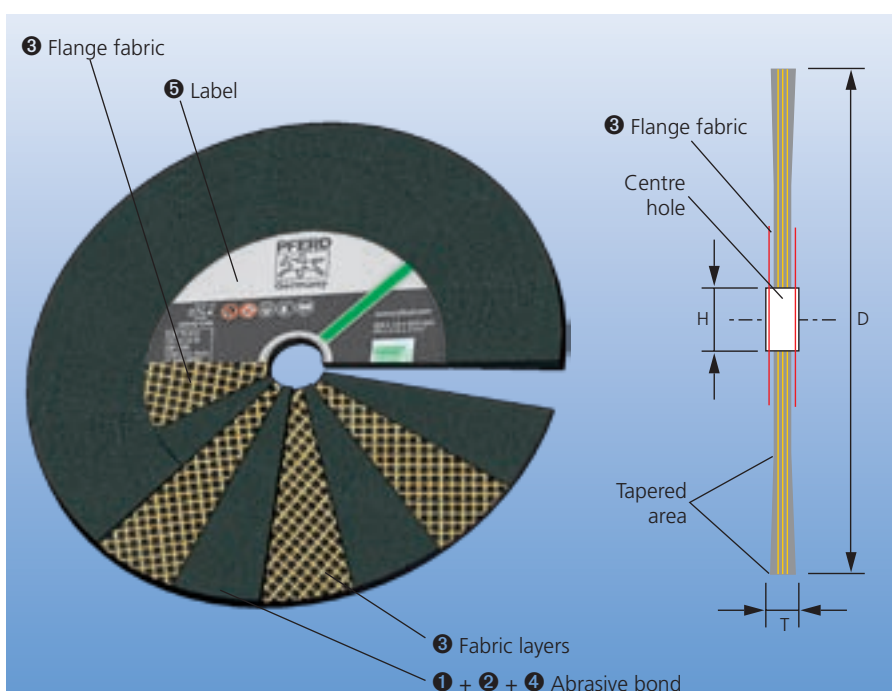
- Low side friction.
- Particularly advantageous for deep cuts and when used in traverse cutting (cut-off wheel traverses along the workpiece, which has already been cut).

Construction of a cut-off wheel

Synthetic, resin bonded, fibre material reinforced cut-off wheels are used for stationary cutting, they basically consist of five components:

- ① Abrasive
- ② Bond, which holds the abrasive grit in the cut-off wheel
- ③ Fabric layers which ensure that the cut-off wheel remains secure and stable
- ④ Active grinding filler materials
- ⑤ Label with all important data

Pore spaces in the cut-off wheel, not visible from outside, promote chip removal.



PFERD order no.

80 T 350-2,8 A 36 K SG-CHOP-INOX/25,4

1 2 3 4 5 6 7 8 9 10 11

- Maximum operating speed**
- Designation and shape of the tool**
T = Straight type
PT = Depressed centre type
CT = Tapered type
- Outer diameter**
Outer dia. D in [mm]
- Wheel thickness**
Thickness T/U in [mm]
- Abrasive**
A = Aluminium oxide
C = Silicon carbide
ZA = Zirconia alumina, aluminium oxide
- Grit size**
Grit size according to ISO 8486
- Hardness grade (wheel characteristics)**

Hardness grade	Wheel characteristics	Material groups
Performance line SG-ELASTIC (SG)		
H	Very soft	Steel, stainless steel (INOX)
K	Very soft	Steel, stainless steel (INOX)
L	Soft	Steel, cast iron, stone, plastics, non-ferrous metals
N	Soft	Steel
P	Medium-hard	Steel
O	Medium-hard	Steel, cast iron
Q	Medium-hard	Steel
R	Hard	Steel, cast iron
S	Hard	Steel
T	Very hard	Steel, cast iron

8. PFERD product line

Performance line SG-ELASTIC

9. Product group

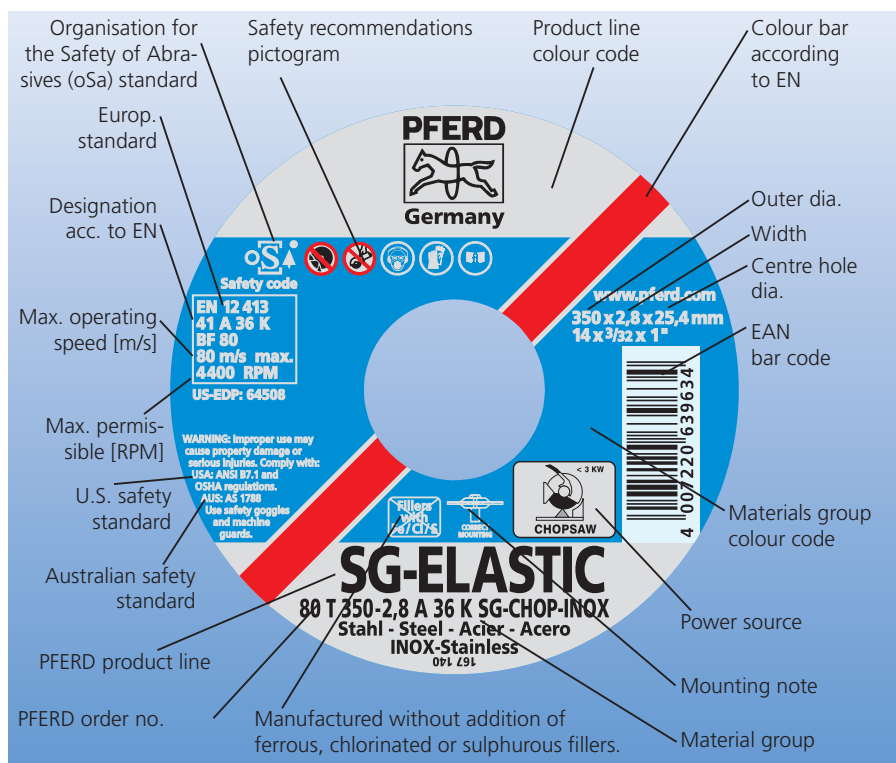
CHOPSAW = for tool drives < 3 KW
TABLECUT = for tool drives 3-5 KW
UNIVERSAL = for tool drives > 5 KW
RAIL = for rails
HEAVY DUTY = for high output tool drives
LABOR = for laboratory samples

10. Material group

See also point 7.

11. Centre hole diameter

Centre hole dia. H in [mm]








Designation according to EN 12413

41 A 36 K BF 80

1 2 3 4 5 6

- Type and shape of the wheel**
41 = Cut-off wheel, flat type
42 = Cut-off wheel, depressed centre type
- Abrasive**
A = Aluminium oxide
C = Silicon carbide
ZA = Zirconia alumina, aluminium oxide
- Grit size**
Grit size according to ISO 8486
- Hardness grade (wheel characteristics)**
The hardness grades are indicated using letters in alphabetical order starting with extremely soft through to the extremely hard (A to Z).
- Bond**
BF = Fibre-reinforced fabric in resinoid bond
- Max. operating speed in [m/s]**

Colour coding for the recommended materials to be ground

Performance line SG-ELASTIC (SG)		
		
Material = Colour		Page
 Steel black		6-10, 12
 Steel/cast iron black/red		11
 Stainless steel (INOX) blue		6, 11
 Stone green		7

PFERD advice and service

The large number of cutting problems requires detailed advice. PFERD provides this service upon request, free of charge and without any obligation on the part of the customer. Our advice does not only extend to the selection of the right PFERD cut-off wheel, but also addresses equipment improvement aspects, e.g. with relation to extractor systems, work-piece feeding devices, clamping, etc.

Years of experience gathered by our technical customer service and our research department ensure quick and professional advice when solving cutting problems.

Due to the excellent contacts formed by our development department to cut-off wheel machine manufacturers both in this country and abroad, we are also able to advise you on the layout of appropriate automatic equipment.



Stationary Cut-Off Wheels

Performance Line SG-ELASTIC, CHOPSAW



Steel
Very soft type - hardness grade K



Multipurpose tool of hardness grade K for abrasive cutting operations using stationary machines.

PFERD product characterized by aggressive abrasive performance for fast cuts and very long tool life.

Abrasive: Aluminium oxide A

Workpiece materials:

Steel

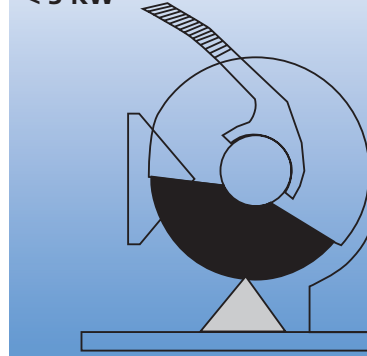
Application:

Cutting of solid material, sections and pipes

Recommendation for use:

Provides excellent cutting results on machines with up to 3 KW output.

< 3 KW



Order No.	EAN 4007220	EN-designation	D x T x H [mm (inch)]	Max. speed [RPM]		
Maximum operating speed 80 m/s, flat type T (Form 41)						
80 T 300-2,8 A 36 K SG-CHOP/25,4	629123	41 A 36 K BF 80	300 x 2,8 x 25,4 (1)	5.100	20	9,100
80 T 300-2,8 A 36 K SG-CHOP/32,0	639573	41 A 36 K BF 80	300 x 2,8 x 32,0 (1 1/4)	5.100	20	9,100
80 T 350-2,8 A 36 K SG-CHOP/25,4	629154	41 A 36 K BF 80	350 x 2,8 x 25,4 (1)	4.400	10	6,210
80 T 350-2,8 A 36 K SG-CHOP/32,0	639597	41 A 36 K BF 80	350 x 2,8 x 32,0 (1 1/4)	4.400	10	6,210
80 T 400-3,8 A 36 K SG-CHOP/25,4	638675	41 A 36 K BF 80	400 x 3,8 x 25,4 (1)	3.800	10	10,360
80 T 400-3,8 A 36 K SG-CHOP/32,0	639610	41 A 36 K BF 80	400 x 3,8 x 32,0 (1 1/4)	3.800	10	10,360

INOX
Very soft type - hardness grade K



Multipurpose tool of hardness grade K for abrasive cutting.

PFERD product characterized by aggressive, cool cutting performance for fast results and very long tool life.

Abrasive: Aluminium oxide A

Manufactured without addition of ferrous, sulphurous or chlorinated fillers.

Workpiece materials:

Stainless steel (INOX)

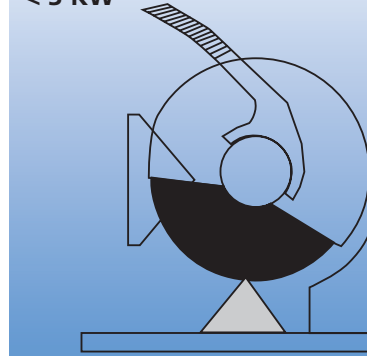
Application:

Cutting of solid material, sections and pipes

Recommendation for use:

Provides excellent cutting results on machines with up to 3 KW output.

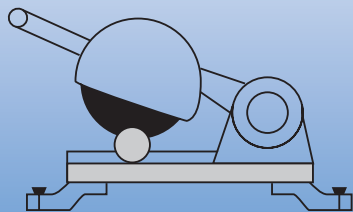
< 3 KW



Order No.	EAN 4007220	EN-designation	D x T x H [mm (inch)]	Max. speed [RPM]		
Maximum operating speed 80 m/s, flat type T (Form 41)						
80 T 300-2,8 A 36 K SG-CHOP-INOX/25,4	803219	41 A 36 K BF 80	300 x 2,8 x 25,4 (1)	5.100	20	9,100
80 T 350-2,8 A 36 K SG-CHOP-INOX/25,4	639634	41 A 36 K BF 80	350 x 2,8 x 25,4 (1)	4.400	10	6,210
80 T 400-2,8 A 36 K SG-CHOP-INOX/25,4	669303	41 A 36 K BF 80	400 x 2,8 x 25,4 (1)	3.800	10	8,440



3-5 KW



Multipurpose tool of hardness grade L for abrasive cutting operations using stationary machines.

PFERD product characterized by high lateral stability and very long tool life.

Abrasive: Aluminium oxide A

Workpiece materials:

Steel

Application:

Cutting of solid material, sections and pipes



Recommendation for use:

Best cutting results are achieved with high-powered machines in the 3 - 5 KW output range.

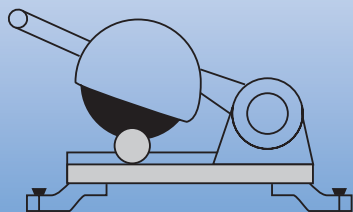
Steel
Soft type - hardness grade L



T

Order No.	EAN 4007220	EN-designation	D x T x H [mm (inch)]	Max. speed [RPM]		
Maximum operating speed 80 m/s, flat type T (Form 41)						
80 T 300-3,0 A 30 L SG-TABLE/25,4	629185	41 A 30 L BF 80	300 x 3,0 x 25,4 (1)	5.100	20	9,200
80 T 300-3,0 A 30 L SG-TABLE/32,0	639580	41 A 30 L BF 80	300 x 3,0 x 32,0 (1 1/4)	5.100	20	9,200
80 T 350-3,0 A 30 L SG-TABLE/25,4	629130	41 A 30 L BF 80	350 x 3,0 x 25,4 (1)	4.400	10	6,500
80 T 350-3,0 A 30 L SG-TABLE/32,0	639603	41 A 30 L BF 80	350 x 3,0 x 32,0 (1 1/4)	4.400	10	6,500
80 T 400-4,0 A 30 L SG-TABLE/25,4	638682	41 A 30 L BF 80	400 x 4,0 x 25,4 (1)	3.800	10	10,900
80 T 400-4,0 A 30 L SG-TABLE/32,0	639627	41 A 30 L BF 80	400 x 4,0 x 32,0 (1 1/4)	3.800	10	10,900

3-5 KW



Multipurpose tool of hardness grade L for abrasive cutting operations using stationary machines.

PFERD product characterized by high lateral stability and very long tool life.

Abrasive: Silicon carbide C

Workpiece materials:

Cast iron, stone, plastic, non-ferrous metals

Application:

Cutting of solid material, sections and pipes



Recommendation for use:

Best cutting results are obtained with high-powered machines in the 3 - 5 KW output range.

Cast iron/stone/plastic/non-ferrous metals
Soft type - hardness grade L



T

Order No.	EAN 4007220	EN-designation	D x T x H [mm (inch)]	Max. speed [RPM]		
Maximum operating speed 80 m/s, flat type T (Form 41)						
80 T 300-3,0 C 36 L SG-TABLE/25,4	540268	41 C 36 L BF 80	300 x 3,0 x 25,4 (1)	5.100	20	8,300
80 T 350-3,4 C 36 L SG-TABLE/25,4	540275	41 C 36 L BF 80	350 x 3,4 x 25,4 (1)	4.400	10	6,210
80 T 400-4,0 C 36 L SG-TABLE/25,4	540282	41 C 36 L BF 80	400 x 4,0 x 25,4 (1)	3.800	10	10,700



Stationary Cut-Off Wheels

Performance Line SG-ELASTIC, UNIVERSAL



Steel
Medium-hard type - hardness grade O



General-use product of hardness grade O for abrasive cutting operations using stationary machines.

PFERD product with extremely good cutting capability for a quick cut combined with excellent tool life.

Abrasive: Aluminium oxide A

Workpiece materials:

Steel

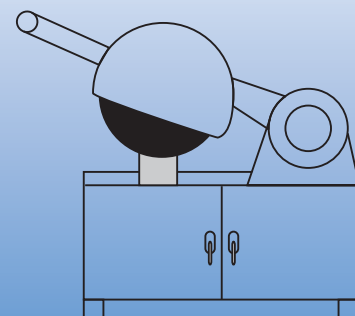
Application:



Cutting of solid material, sections and pipes

Recommendation for use:

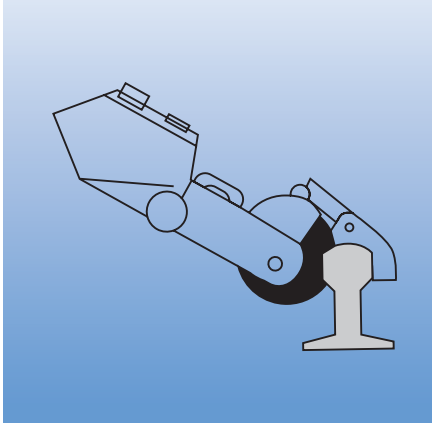
Optimum cutting results are achieved with high-powered machines delivering more than 5 KW output.

> 5 KW



Order No.	EAN 4007220	EN-designation	D x T x H [mm (inch)]	Max. speed [RPM]		
Maximum operating speed 80 m/s, flat type T (Form 41)						
80 T 300-3,4 A 30 O SG-UNI/25,4	540299	41 A 30 O BF 80	300 x 3,4 x 25,4 (1)	5.100	20	11,700
80 T 300-3,4 A 30 O SG-UNI/32,0	721223	41 A 30 O BF 80	300 x 3,4 x 32,0 (1 1/4)	5.100	20	11,700
80 T 350-3,8 A 30 O SG-UNI/25,4	540329	41 A 30 O BF 80	350 x 3,8 x 25,4 (1)	4.400	10	8,600
80 T 350-3,8 A 30 O SG-UNI/32,0	721247	41 A 30 O BF 80	350 x 3,8 x 32,0 (1 1/4)	4.400	10	8,600
80 T 400-4,2 A 30 O SG-UNI/32,0	721254	41 A 30 O BF 80	400 x 4,2 x 32,0 (1 1/4)	3.800	10	12,000
80 T 400-4,2 A 30 O SG-UNI/40,0	540374	41 A 30 O BF 80	400 x 4,2 x 40,0 (1 1/2)	3.800	10	12,000
Maximum operating speed 100 m/s, flat type T (Form 41)						
100 T 300-3,8 A 30 O SG-UNI/25,4	721230	41 A 30 O BF 100	300 x 3,8 x 25,4 (1)	6.400	20	12,300
100 T 300-3,8 A 30 O SG-UNI/32,0	540305	41 A 30 O BF 100	300 x 3,8 x 32,0 (1 1/4)	6.400	20	12,300
100 T 300-3,8 A 30 O SG-UNI/40,0	540312	41 A 30 O BF 100	300 x 3,8 x 40,0 (1 1/2)	6.400	20	12,300
100 T 350-4,2 A 30 O SG-UNI/25,4	540336	41 A 30 O BF 100	350 x 4,2 x 25,4 (1)	5.500	10	9,300
100 T 350-4,2 A 30 O SG-UNI/32,0	540343	41 A 30 O BF 100	350 x 4,2 x 32,0 (1 1/4)	5.500	10	9,300
100 T 350-4,2 A 30 O SG-UNI/40,0	540350	41 A 30 O BF 100	350 x 4,2 x 40,0 (1 1/2)	5.500	10	9,300
100 T 400-4,8 A 30 O SG-UNI/32,0	540428	41 A 30 O BF 100	400 x 4,8 x 32,0 (1 1/4)	4.800	10	14,000
100 T 400-4,8 A 30 O SG-UNI/40,0	540435	41 A 30 O BF 100	400 x 4,8 x 40,0 (1 1/2)	4.800	10	14,000





Special-purpose tool of hardness grade Q for cutting rails.
PFERD product noted for its long tool life.

Abrasive: Aluminium oxide A



Workpiece materials:
Steel

Application:
Rail cutting operations

Recommendation for use:
Best cutting results are obtained with high-powered machines.

Steel
Medium-hard type - hardness grade Q



Order No.	EAN 4007220	EN-designation	D x T x H [mm (inch)]	Max. speed [RPM]		
Maximum operating speed 100 m/s, flat type T (Form 41)						
100 T 300-3,8 A 24 Q SG-RAIL/22,23	539705	41 A 24 Q BF 100	300 x 3,8 x 22,23 (7/8)	6.400	20	12,200
100 T 300-3,8 A 24 Q SG-RAIL/25,4	539712	41 A 24 Q BF 100	300 x 3,8 x 25,4 (1)	6.400	20	12,200
100 T 350-3,8 A 24 Q SG-RAIL/22,23	539729	41 A 24 Q BF 100	350 x 3,8 x 22,23 (7/8)	5.500	10	9,290
100 T 350-3,8 A 24 Q SG-RAIL/25,4	539736	41 A 24 Q BF 100	350 x 3,8 x 25,4 (1)	5.500	10	9,290
100 T 400-4,2 A 24 Q SG-RAIL/25,4	539743	41 A 24 Q BF 100	400 x 4,2 x 25,4 (1)	4.800	10	12,500



Stationary Cut-Off Wheels

Performance Line SG-ELASTIC, HEAVY DUTY



Steel Types in various hardness grades



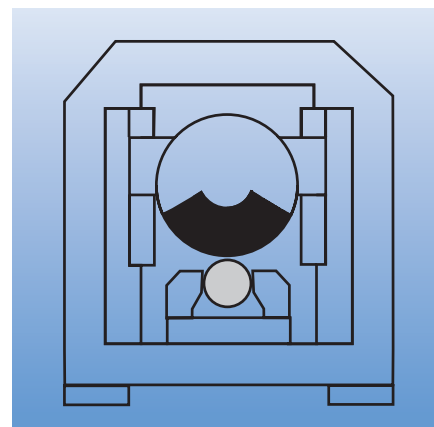
High-performance cut-off wheels for use in stationary machines.
PFERD product designed for aggressive cutting action, leaving a clean and bright cut even in large-diameter material.



Abrasive: Aluminium oxide A

Workpiece materials:
Steel

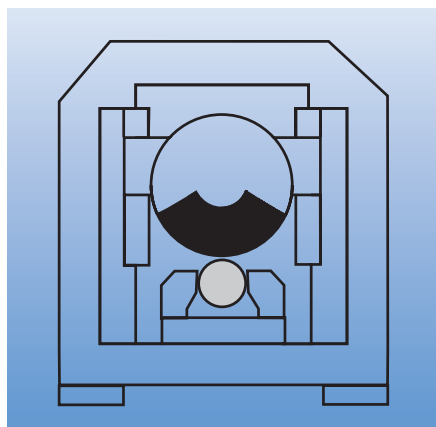
Application:
Cutting of solid material, sections and pipes

Recommendation for use:
These wheels deliver optimal cutting results when driven by a high power output stationary machine. The wide hardness grade range makes it possible to find a wheel suitable for all power outputs.



Order No.	EAN 4007220	EN-designation	D x T x H [mm (inch)]	Max. speed [RPM]		
Maximum operating speed 80 m/s, flat type T (Form 41)						
80 T 300-3,4 A 24 Q SG-HD/25,4	166185	41 A 24 Q BF 80	300 x 3,4 x 25,4 (1)	5.100	20	10,700
80 T 300-3,4 A 24 Q SG-HD/40,0	166208	41 A 24 Q BF 80	300 x 3,4 x 40,0 (1 1/2)	5.100	20	10,700
80 T 350-3,8 A 24 Q SG-HD/25,4	166260	41 A 24 Q BF 80	350 x 3,8 x 25,4 (1)	4.400	10	8,300
80 T 400-4,2 A 24 Q SG-HD/40,0	166307	41 A 24 Q BF 80	400 x 4,2 x 40,0 (1 1/2)	3.800	10	12,350
80 T 500-5,5 A 24 Q SG-HD/40,0	166321	41 A 24 Q BF 80	500 x 5,5 x 40,0 (1 1/2)	3.100	5	12,400
Maximum operating speed 100 m/s, flat type T (Form 41)						
100 T 250-1,8 A 24 Q SG-HD/30,0	539873	41 A 24 Q BF 100	250 x 1,8 x 30,0 (19/16)	7.600	20	3,880
100 T 250-1,8 A 24 Q SG-HD/32,0	803257	41 A 24 Q BF 100	250 x 1,8 x 32,0 (1 1/4)	7.600	20	3,880
100 T 300-3,0 A 24 N SG-HD/40,0	539842	41 A 24 N BF 100	300 x 3,0 x 40,0 (1 1/2)	6.400	20	9,240
100 T 300-3,6 A 24 Q SG-HD/40,0	166253	41 A 24 Q BF 100	300 x 3,6 x 40,0 (1 1/2)	6.400	20	11,360
100 T 350-3,8 A 24 N SG-HD/40,0	539859	41 A 24 N BF 100	350 x 3,8 x 40,0 (1 1/2)	5.500	10	9,100
100 T 350-4,0 A 24 Q SG-HD/25,4	166284	41 A 24 Q BF 100	350 x 4,0 x 25,4 (1)	5.500	10	9,200
100 T 350-4,0 A 24 Q SG-HD/40,0	166291	41 A 24 Q BF 100	350 x 4,0 x 40,0 (1 1/2)	5.500	10	9,200
100 T 400-4,3 A 24 N SG-HD/40,0	539866	41 A 24 N BF 100	400 x 4,3 x 40,0 (1 1/2)	4.800	10	13,230
100 T 400-4,6 A 24 S SG-HD/40,0	166314	41 A 24 S BF 100	400 x 4,6 x 40,0 (1 1/2)	4.800	10	14,100
100 T 400-4,8 A 24 Q SG-HD/40,0	539880	41 A 24 Q BF 100	400 x 4,8 x 40,0 (1 1/2)	4.800	10	15,660
100 T 500-6,3 A 24 L SG-HD/40,0	803417	41 A 24 L BF 100	500 x 6,3 x 40,0 (1 1/2)	3.800	5	14,600
100 T 500-5,8 A 24 N SG-HD/40,0	166338	41 A 24 N BF 100	500 x 5,8 x 40,0 (1 1/2)	3.800	5	13,500
100 T 500-5,8 A 24 Q SG-HD/40,0	539897	41 A 24 Q BF 100	500 x 5,8 x 40,0 (1 1/2)	3.800	5	13,500
100 T 500-5,8 A 24 S SG-HD/40,0	539958	41 A 24 S BF 100	500 x 5,8 x 40,0 (1 1/2)	3.800	5	13,500
100 T 600-7,6 A 24 N SG-HD/60,0	166482	41 A 24 N BF 100	600 x 7,6 x 60,0 (2 3/8)	3.200	5	25,500





High-performance cut-off wheels for use in stationary machines.
PFERD product designed for a long lifetime, leaving a clean and bright cut.

Abrasive: Zirconia alumina, aluminium oxide ZA



Workpiece materials:
Cast iron, steel



Application:
Cutting of solid material, sections and pipes

Recommendation for use:
These wheels deliver optimal cutting results when driven by a high power output stationary machine. The wide hardness grade range makes it possible to find a wheel suitable for all power outputs.

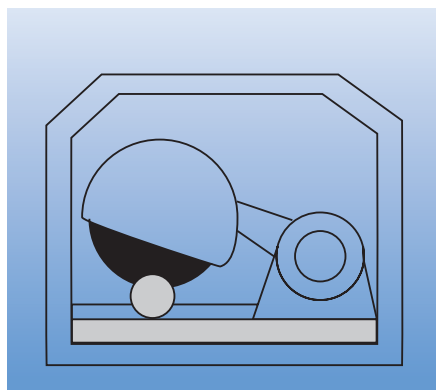
Cast iron/steel
Types in various hardness grades



Order No.	EAN 4007220	EN-designation	D x T x H [mm (inch)]	Max. speed [RPM]		
Maximum operating speed 100 m/s, flat type T (Form 41)						
100 T 400-4,8 ZA 24 T SG-HD/40,0	539965	41 ZA 24 T BF 100	400 x 4,8 x 40,0 (1 1/2)	4.800	10	14,190
100 T 500-5,6 ZA 24 T SG-HD/40,0	803462	41 ZA 24 T BF 100	500 x 5,6 x 40,0 (1 1/2)	3.800	5	12,900
100 T 600-7,8 ZA 24 P SG-HD/60,0	803486	41 ZA 24 P BF 100	600 x 7,8 x 60,0 (2 3/8)	3.200	5	26,300
100 T 600-8,0 ZA 24 R SG-HD/60,0	166437	41 ZA 24 R BF 100	600 x 8,0 x 60,0 (2 3/8)	3.200	5	28,400

Order No.	EAN 4007220	EN-designation	D x U x H [mm (inch)]	Max. speed [RPM]		
Maximum operating speed 100 m/s, depressed centre type PT (Form 42)						
100 PT 600-7,8 ZA 24 T SG-HD/76,2	539989	42 ZA 24 T BF 100	600 x 7,8 x 76,2 (3)	3.200	5	30,100

Performance Line SG-ELASTIC, LABOR



Reinforced high-performance cut-off wheels for stationary cutting.
PFERD product with cool grinding, specially designed for metallographic sampling.

Abrasive: Aluminium oxide A
Manufactured without addition of ferrous, sulphurous or chlorinated fillers.



Workpiece materials:
Stainless steel (INOX), steel, cast iron

Application:
Cutting of solid material, sections and pipes

Recommendation for use:
Due to their construction, these tools are only intended for use on stationary precision cutting machines.

INOX/steel/cast iron
Very soft type - hardness grade H



Order No.	EAN 4007220	EN-designation	D x T x H [mm (inch)]	Max. speed [RPM]		
Maximum operating speed 80 m/s, flat type T (Form 41)						
80 T 150-1,0 A 60 H SG-LAB-INOX/22,23	804124	41 A 60 H BF 80	150 x 1,0 x 22,23 (7/8)	10.200	25	1,100
80 T 230-1,5 A 60 H SG-LAB-INOX/22,23	804865	41 A 60 H BF 80	230 x 1,5 x 22,23 (7/8)	6.600	25	3,650
80 T 250-1,8 A 46 H SG-LAB-INOX/32,0	804919	41 A 46 H BF 80	250 x 1,8 x 32,0 (1 1/4)	6.100	20	4,360
80 T 300-2,0 A 46 H SG-LAB/32,0	804926	41 A 46 H BF 80	300 x 2,0 x 32,0 (1 1/4)	5.100	20	9,000
80 T 350-2,5 A 46 H SG-LAB/32,0	805596	41 A 46 H BF 80	350 x 2,5 x 32,0 (1 1/4)	4.400	10	5,920
80 T 400-3,0 A 46 H SG-LAB/32,0	805657	41 A 46 H BF 80	400 x 3,0 x 32,0 (1 1/4)	3.800	10	10,830

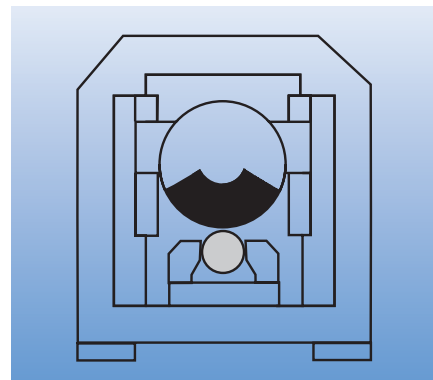
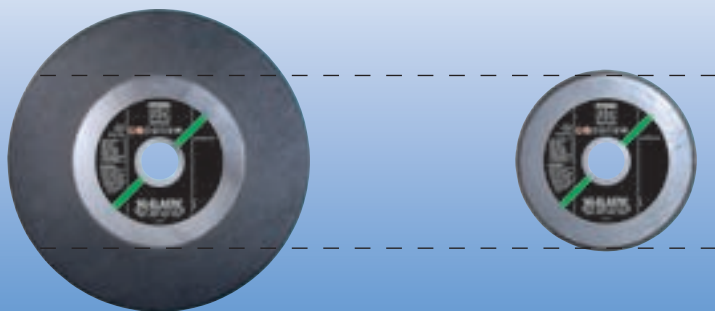
Stationary Cut-Off Wheels

Performance Line SG-ELASTIC, HEAVY DUTY



Steel core cut-off wheel SCT 1250

Maximum utilisation of abrasive



The steel-core cut-off wheels developed and patented by PFERD stand out thanks to their sandwich-construction solid steel body which does not contain any abrasive.

This special tool structure has the following benefits:

1. The steel core allows the use of smaller wheel flanges

As a result:

- Reduced residual disc diameter
- Cutting of larger material cross-sections
- Reduction of the cutting costs

2. The steel core improves the lateral stability of the cut-off wheel

As a result:

- Reduced cut-off wheel width
- Less loss of cut material
- Less chips or cinder waste
- Less machine power output necessary
- Shorter cutting times
- Higher material flow rate
- More sturdy, low-vibration cut
- Increased tool life
- Noise reduction

3. Due to the abrasive-free steel core, there are no additional costs for the disposal of the old wheel.

