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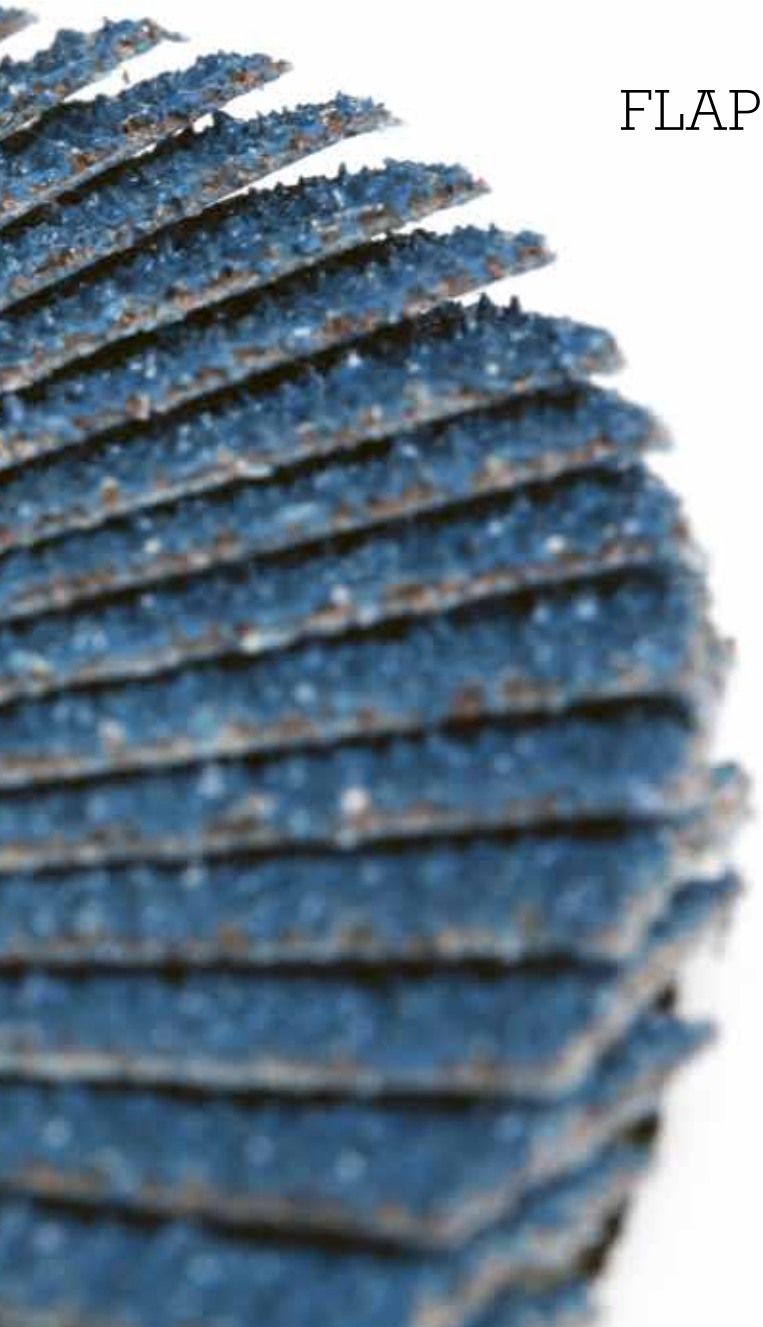
Cibo can also rapidly manufacture any sizes, grades or grit types that are not listed in the overview.
After all, customisation is the norm at Cibo.



FLAP DISCS

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

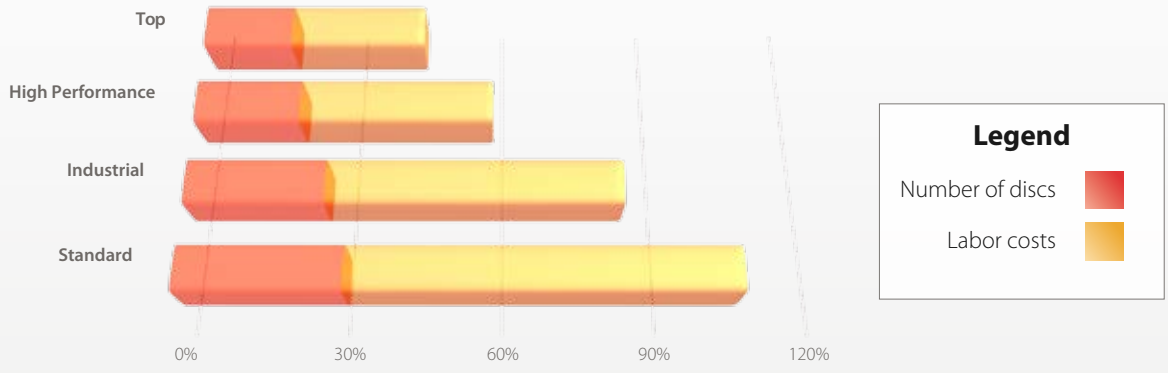
Very often, it is easy to allow oneself to be blinded by the purchase price of the disc. There are very cheap discs available on the market today which at first glance appear excellent. In this context, many operator has personally experienced how deceptive this can prove to be. Please read on and you 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?

Low High

	Glass fibre backing	Plastic backing
Vibrations	■■■■■■■□□	■■■■■□□□□
Sound	■■■■■■■□□	■■■■■■□□□
Suspension / Comfort	■■■■■□□□□	■■■■■■■■□
Finish	■■■■■■■□□	■■■■■■■■□
Cost price	■■■■■□□□□	■■■■■■■□□
Weight	■■■■□□□□□	■■■■■□□□□

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

INDUSTRIAL LINE

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

INDUSTRIAL LINE

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

INDUSTRIAL LINE

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

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

TOP LINE

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

TOP LINE

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

TOP LINE

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.

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

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

INDUSTRIAL LINE

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

FTPM - FLAT - M14

TOP LINE

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

FTPC - CONICAL

TOP LINE

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

43A - FLAT

TAF - INTERNALLY BONDED

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

● = 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

ZIRCONIUM OXIDE | SOCATT®

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

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

MLZV - FLAT

ZIRCONIUM OXIDE | LOCKIT®

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

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

cibo
INOX
STEEL

Finishing discs

The Cibo finishing discs are flap discs which, besides a limited removal of material, allow you to achieve a very high-quality finish in almost no time,

The flap discs for stock removal are distinguished by their reasonably quick material removal, but they do not succeed in safely creating a beautiful and constant decorative finish. They often create irreparable grinding errors, especially on workpieces where a decorative or cosmetic finish is required.

Stainless steel, aluminium and non-ferrous metals are materials that are often used in sectors where very high standards are required for the finish. In order to meet high market demand, Cibo has developed a number of very efficient and exclusive finishing discs.

These discs attract attention because of their capacity to create a constant and reproducible finish in a safe and controlled manner, mainly on stainless steel, aluminium and non-ferrous metals.

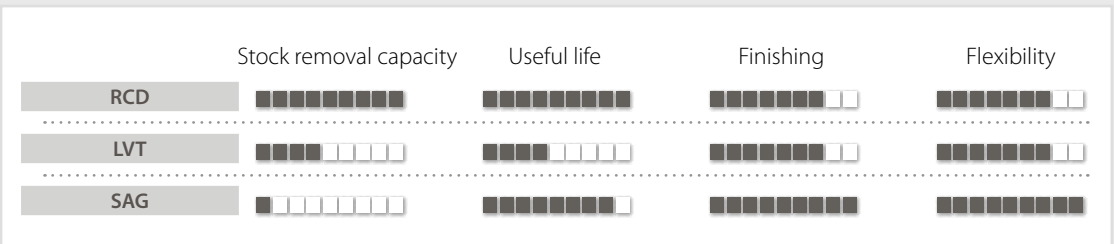
The range of finishing discs consists of 3 families: the **RCD**, the **LVT** and the **SAG**.

RCD

SAG

LVT

Finishing discs



RCD

original patented - original patented product - original patented

WORLDWIDE PATENTED

THE RCD-DISC

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

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

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.

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

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.

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.

dimensions	grit	code	type	max RPM	adviced 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

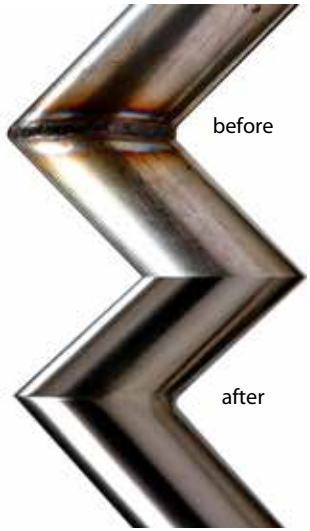
3

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 completinig 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	adviced 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

FLAT

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	adviced 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

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

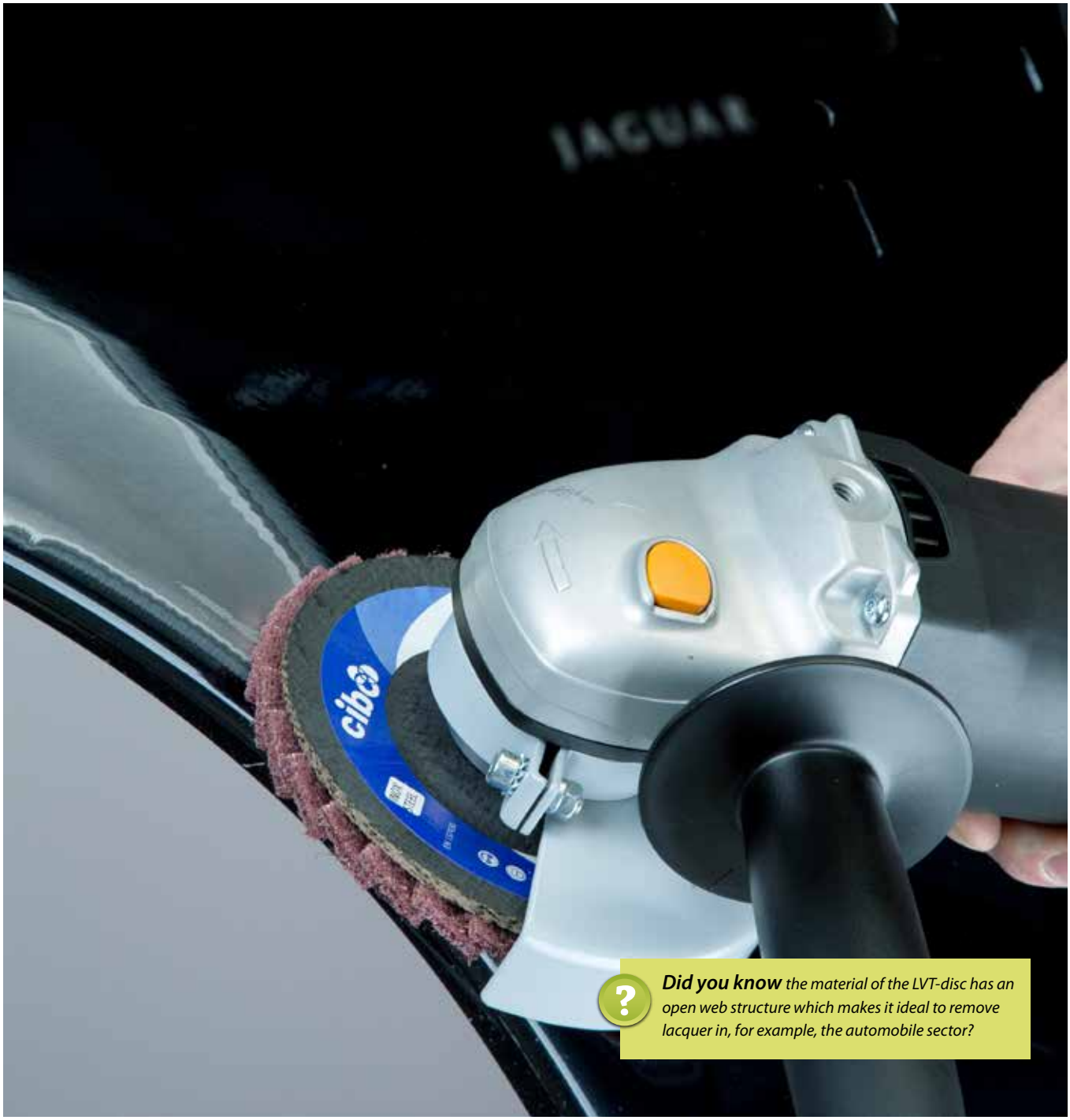
THE LVT-DISC

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	adviced 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	adviced 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

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	adviced 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

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