



FIBRE DISCS

- **Introduction** 290
- **Aluminium oxide** 294
- **Aluminium oxide with grinding aid** 296
- **Zirconium oxide** 297
- **Ceramic with grinding aid** 298
- **Silicon carbide** 299
- **Overview back-up pads** 300

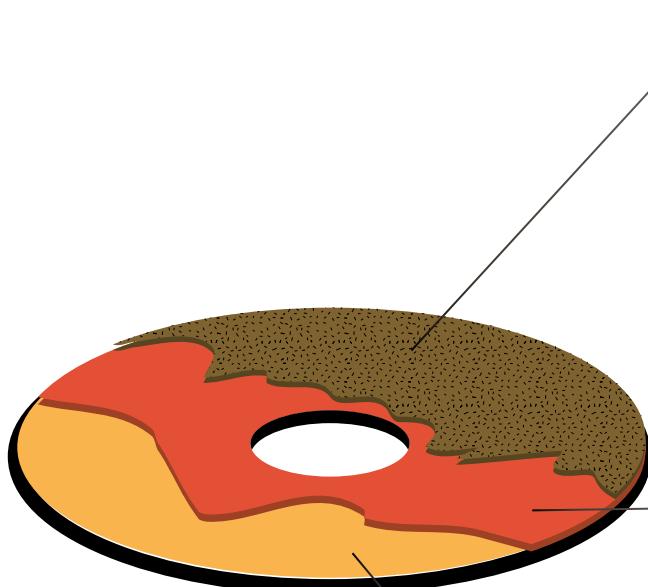


FIBRE DISCS





➤ BUILD-UP OF THE FIBRE DISC



GRIT TYPE

The selection of the correct grit type is very important. In case of doubt, please consult a Cibo application expert. He or she will help you to make the best selection from one of the next 4 grit types :

- Aluminium oxide
- Zirconium oxide
- Ceramic
- Silicon carbide

BINDING AGENT

All Cibo fibre discs are produced with a double synthetic resin binding, whether or not in combination with an active abrasive ingredient.

BACKING

The Cibo fibre discs' base consists of a vulcanised fibre backing of minimum 0.8 mm. The choice of this strong backing is a very conscious one. It guarantees an increased lifespan.



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



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	
$\varnothing 115 \times 22$	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
$\varnothing 125 \times 22$	220	KFK/220/11522	*	●	50
	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
$\varnothing 180 \times 22$	180	KFK/180/12522	*	●	50
	220	KFK/220/12522	*	●	50
	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

• Grit type : zirconium oxide + active grinding ingredient

Applications :

• Stainless steel, aluminium, hard steel types, special alloys

dimensions	grit	code	center hole	stock	
$\varnothing 115 \times 22$	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
$\varnothing 125 \times 22$	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
$\varnothing 180 \times 22$	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

ZIRCONIUM OXIDE

Properties :

- Base : fibre 0,8 mm

- Grit type : zirconium oxide

Applications :

- Stainless steel, aluminium, chrome, special alloys, hard steel types, etc.



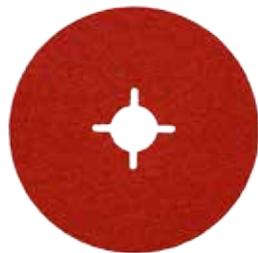
dimensions	grit	code	center hole	stock	
$\varnothing 115 \times 22$	24	K3K/24/11522	*	●	50
	36	K3K/36/11522	*	●	50
	50	K3K/50/11522	*	●	50
	60	K3K/60/11522	*	●	50
	80	K3K/80/11522	*	●	50
	120	K3K/120/11522	*	●	50
$\varnothing 125 \times 22$	24	K3K/24/12522	*	●	50
	36	K3K/36/12522	*	●	50
	50	K3K/50/12522	*	●	50
	60	K3K/60/12522	*	●	50
	80	K3K/80/12522	*	●	50
	120	K3K/120/12522	*	●	50
$\varnothing 180 \times 22$	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



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

CERAMIC + ADDITIVE



> Ceramic with grinding aid

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	
$\varnothing 115 \times 22$	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
$\varnothing 125 \times 22$	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
$\varnothing 180 \times 22$	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

SILICON CARBIDE

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	O	●	50
	24	DC/24/18022	O	●	100
	36	DC/36/18022	O	●	100
	50	DC/50/18022	O	●	100
	60	DC/60/18022	O	●	100
	80	DC/80/18022	O	●	100
	120	DC/120/18022	O	●	100
	150	DC/150/18022	O	●	100
	180	DC/180/18022	O	●	100
	220	DC/220/18022	O	●	100
	320	DC/320/18022	O	●	100
	400	DC/400/18022	O	●	100



> 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

