

# HERMES COATED ABRASIVES

Program brochure



for an  
excellent finish





# HERMES ABRASIVES - MORE THAN GRINDING TOOLS!



**EXPERTISE & CONSULTING**

Whenever you need support: our experts are there for you.

Whether it's choosing the right grinding tool, process optimization, product testing or training your employees.

Whether at your or at our premises, by phone or email - you can count on us.





**RESPONSIBILITY & SUSTAINABILITY**

Responsible action and sustainable management are and have always been key components of our corporate strategy.

We are continuously developing our activities in this regard, are regularly certified and are measured against our successes at all times.

## HERMES CONNECT

**ONLINE-SERVICE PORTAL**

Get information, order goods and track them - around the clock! Hermes Connect is your key source for all important services and information on our abrasive tools: stock availability and prices as well as a direct shop function and your personal order overviews.





**CONTACT**

Contact us at any time so that we can find the right solution for you.

In the contact area on our website [HERMES-ABRASIVES.COM](https://www.hermes-abrasives.com) you can find with just a few clicks the right contact person responsible for you.



### Abrasive cloth

[illegible]

**A/O:** Aluminum oxide; **S/C:** Silicon carbide; **Z/O:** Zirconia alumina; **CER:** Ceramic grain; **R:** Resin; **RAS:** Resin, antistatic; **RPC:** Resin, Procut: Size coat with abrasive additives; **RPL:** Resin, Prolub: Additional stearate coating to prevent premature clogging; **PES:** Polyester; **Index w:** waterproof; \* A/O + CER; \*\* A/O + Cork; \*\*\* S/C + Cork; \*\*\*\* No grain

**Abrasive cloth, velour-backed**

[illegible]

**Abrasive cloth, self-stick**

[illegible]

### Abrasive stitch-bonded cloth

[illegible]

## Abrasive fiber

[illegible]

## Abrasive film

[illegible]

**Abrasive film, velour-backed**

[illegible]

### Abrasive film, self-stick

[illegible]

**Foam with net, velour-backed**

[illegible]

## Net cloth

[illegible]

**Net cloth, velour-backed**

[illegible]

## Sponges

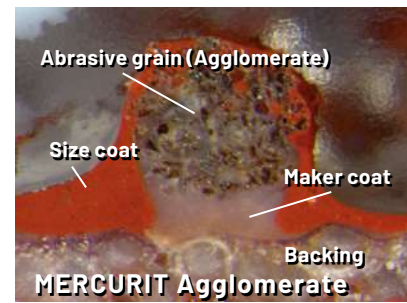
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## Abrasive paper

### Abrasive paper, velour-backed

### Abrasive paper, self-stick

**A/O:** Aluminum oxide; **S/C:** Silicon carbide; **Z/O:** Zirconia alumina; **CER:** Ceramic grain; **R:** Resin; **RAS:** Resin, antistatic; **RPC:** Resin, Procut: Size coat with abrasive additives; **RPL:** Resin, Prolub: Additional stearate coating to prevent premature clogging; **PES:** Polyester; **Index w:** waterproof; \* A/O + CER; \*\* A/O + Cork; \*\*\* S/C + Cork; \*\*\*\* No grain



### Key to kind of tool

## Key to backings

## Key to bonding

## Abrasive grain material and grain standards

### Grit size comparison (Abrasive paper, film, cloth, stitch-bonded cloth and fiber)

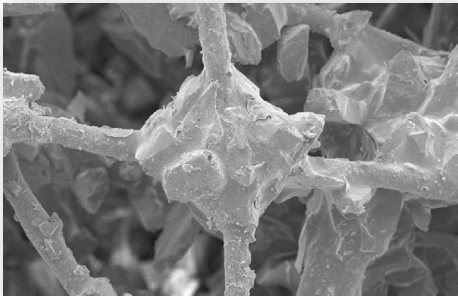
The differences of the respective grit size standards are defined in the relevant test standards.

3 benefits of webrax non-woven abrasive

**1. Backing**  
Our non-woven abrasives are manufactured from a special fiber web. During this process, the abrasive grit is firmly anchored by a bond and is correspondingly durable.  
The following designs are available:  
Non-woven // non-woven, on XW-cloth // non-woven, high-density // Non-woven, reinforced with cloth // non-woven, reinforced on vulcanized fiber

**2. Types of grain**  
We use the following types of grain in grit range 80 to 1500: A/O (Al<sub>2</sub>O<sub>3</sub>) and S/C (SiC).  
**Warning:** Information on grit sizes is not comparable with that relating to abrasive paper.

**3. Bonding**  
The resin bond allows the product to be used under both dry and wet conditions.



Open structure of **webrax** non-woven abrasive

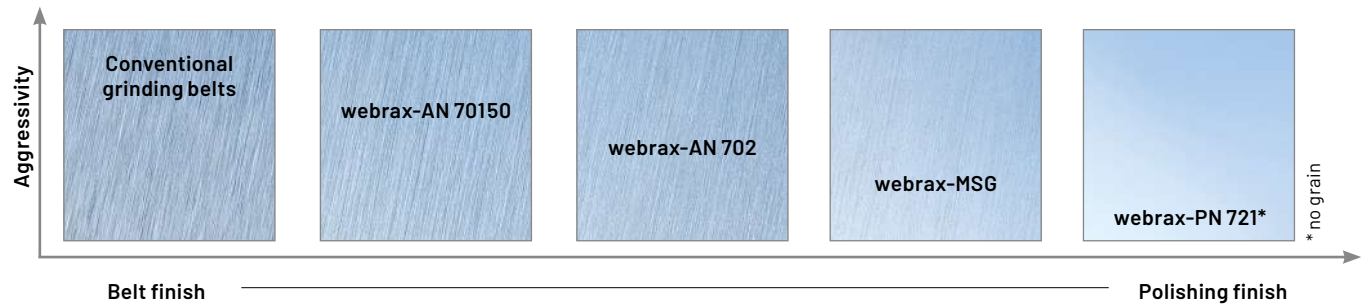
Grit size comparison for webrax non-woven abrasive (incl. details of product colors)

Standard Hermes	+ 80	+ 100	+ 120	+ 150	+ 180	+ 240	+ 280	+ 320	+ 400	+ 500	+ 800	no grain
Grit size name	coarse	medium		fine			very fine		super fine		ultra fine	
<b>webrax-MAG</b>	brown	-	brown	-	-		-	-	-	-	-	-
<b>webrax-MSG</b>	black	-	-	black	black		black	-	black	black	-	-
<b>webrax-AN 70150</b>	brown	red	-	-	red/blue		blue	-	-	-	grey	-
<b>webrax-AN 701 Flex</b>	brown	red			green		blue					
<b>webrax-AN 702</b>	brown	brown	-	-	brown		brown	brown	brown	-	-	-
<b>webrax-PN 721</b>	-	-	-	-	-		-	-	-	-	-	yellow
<b>webrax-CW</b>	med				fin							
<b>webrax-UW</b>	coarse	medium		fine								

Cutting speed recommendations v<sub>c</sub> for dry grinding

	Cleaning	Decorative grinding	Deburring	Polishing
<b>webrax discs</b>				
All	-	8 - 25 m/s	20 - 25 m/s	-
<b>webrax belts and wide belts</b>				
MAG, MSG	5 - 10 m/s	8 - 15 m/s	-	-
AN 702	5 - 10 m/s	8 - 15 m/s	-	-
AN 70150, AN 701 flex	-	8 - 15 m/s	20 - 25 m/s	
PN 721	5 - 10 m/s	-	-	5 - 20 m/s when using polishing paste or liquid
<b>webrax wheels and rollers</b>				
LMO (Flap wheels and rollers)	5 - 10 m/s	8 - 15 m/s	-	-
LMI (impregnated flap wheels and rollers)	-	-	20 - 30 m/s	-
GWS (Wheels and rollers convolutely wrapped)	-	8 - 15 m/s	20 - 30 m/s	-
CW (Convoluted wheels)	-	-	25 - 35 m/s	30 - 35 m/s
LGG (Laminated wheels)	-	8 - 15 m/s	20 - 30 m/s	-
UW (Unitized wheels)	-	-	25 - 35 m/s	30 - 35 m/s

Grinding patterns compared using grinding belts, grit size 180



Grain	Type	Code	Backing	Grit range																Delivery forms
				80	100	120	150	180	220	240	280	320	360	400	500	600	800	1000	1500	

webrax non-woven abrasive

<b>A/O</b>	MAG	70000	Non-woven on XXw cloth	+	•	•														
	AN 701 50	70150	Non-woven, reinforced with cloth	+	•	•		•		•										
	AN 701 flex	70170	Non-woven, reinforced with cloth	+	•	•		•		•										
	AN 702	70200	Non-woven, reinforced with cloth	+	•	•		•		•	•	•								
	AN 707	70700	Non-woven, reinforced with cloth	+	•					•										
	OA 708	70800	Non-woven	+		•		•		•	•									
	OA 708 flex	70870	Non-woven	+				•		•	•									
	OA 710	71002	Non-woven	+	•	•	•	•		•										
	OA 713	71300	Non-woven, high-density	+	•			•		•										
<b>S/C</b>	AN 701 50	70150	Non-woven, reinforced with cloth													•				
	MSG	70500	Non-woven on Xw cloth	+	•		•	•		•		•	•							
	OS 709	70900	Non-woven	+				•		•				•	•		•			
	OS 709 flex	70970	Non-woven	+										•			•			
	OS 715	71502	Non-woven	+	•	•	•	•		•				•	•					
	OS 716	71600	Non-woven, high-density	+				•		•										

webrax non-woven abrasive, velour-backed

<b>A/O</b>	OA 708 VEL	70807	Non-woven	+				•		•	•									
	OA 710 VEL	71007	Non-woven	+	•															
	OA 713 VEL	71307	Non-woven, high-density	+				•												
<b>S/C</b>	OS 709 VEL	70907	Non-woven	+														•		

webrax non-woven abrasive, on fiber backing

<b>A/O</b>	AN 703 50	70350	Non-woven, reinforced on vulcanized fiber	+	•	•														
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webrax cleaning non-web abrasives

<b>A/O</b>	GP 70604 Olive	70604	Non-woven	+																
<b>S/C</b>	Multiclean	70650	Non-woven, high-density	-																
<b>None</b>	GP 70600 White	70600	Non-woven	-																
	PN 721	72100	Non-woven, reinforced with cloth	-																

webrax-CW, convoluted wheels

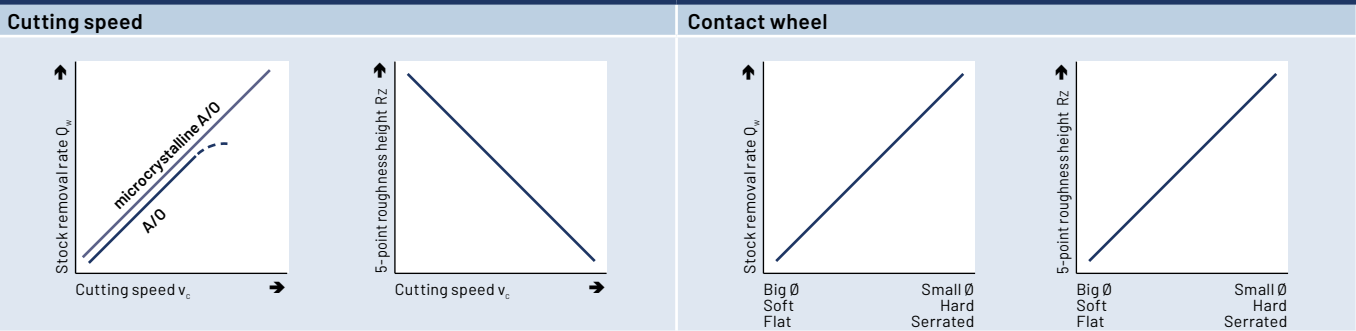
<b>A/O</b>	CW 8A-MED DE	74800	Non-woven, high-density	+	•															
<b>S/C</b>	CW 7S-FIN DE	74720	Non-woven, high-density	+				•												
	CW 9S-FIN-X2 DE	74921	Non-woven, high-density	+				•												

webrax-UW, unitized wheels

<b>A/O</b>	UW 2A-MED DF	75200	Non-woven, high-density	+	•															
	UW 3A-MED DF	75300	Non-woven, high-density	+	•															
	UW 6A-MED DF	75600	Non-woven, high-density	+	•															
	UW 8A-CRS DF	75800	Non-woven, high-density	+	•															
<b>S/C</b>	UW 2S-FIN DF	75220	Non-woven, high-density	+				•												
	UW 3S-FIN DF	75320	Non-woven, high-density	+				•												
	UW 6S-FIN DF	75620	Non-woven, high-density	+				•												



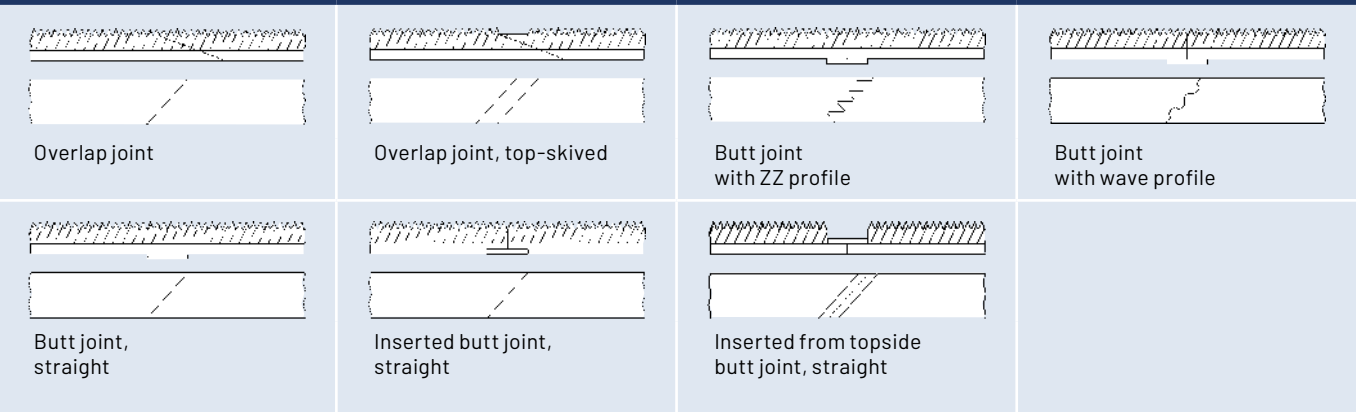
Parameter of belt grinding








Cutting speed recommendations

Metal				Glass, china, ceramics, leather, rubber, cork, felt, plastic			
Narrow belts and Wide belts	Cutting speed $v_c$ (m/s)			Narrow belts and Wide belts	Cutting speed $v_c$ (m/s)		
	min	Recommendation	max		min	Recommendation	max
Carbon steel	29	35	39	Glass	8	13	18
Tool steel (forging parts)	20	30	30	Crystal-glass (lead glass)	15	20	25
Stainless steel	20	30	30	China, ceramics	10	13	17
Grey cast iron	30	35	40	Leather, rubber, cork, felt	20	25	30
Brass and bronze	27	35	37	Plastic	18	22	26
CrNi-base alloy	16	22	28				
Aluminum, Al-alloy	28	35	40				
Titan (dry grinding)	4	8	12				
Titan (wet grinding)	10	12	15	- Duroplastic	6	10	12
				- Plastic (dry grinding)	8	15	18
				- Plastic (wet grinding)			
Wood, lacquer, processed wood boards, mineral fiber boards and melamine							
Narrow belts	Cutting speed $v_c$ (m/s)			Wide belts	Cutting speed $v_c$ (m/s)		
	min	Recommendation	max		min	Recommendation	max
Solid wood, hard	10	20	24	Solid wood	12	20	24
Solid wood, soft	10	12	24	Veneer	10	20	24
Veneer				Plywood	10	20	24
- Lever stroke sanders	10	12	20	Filler	6	8	10
- Edge sanders	6	10	12	Lacquer	2	6	12
- Profile sanders	6	8	12	Particle board / MDF	12	22	36
Lacquer, general	4	8	12	Mineral fiber boards	12	22	26
- Nitro cellulose	2	4	8	Melamine	8	12	20
- Polyester, clear	6	8	12				
- Polyester, pigmented	6	10	12				
- PU	4	8	12				
- Acrylic, pigmented	8	10	12				
- Acid cure lacquer	6	8	12				

Joints for narrow and wide belts

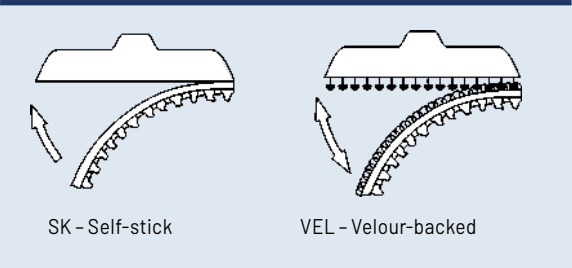


Triangulars, punched

EB	System	Dimensions in mm velour-backed	
021	 6 x / Ø 52	Schwarz & Decker, Bosch, Makita, Metabo	88 x 93
020	 6 x	Festo	88 x 95
022	 2 x 3 + 1 x	AEG, Atlas Copco	99 x 147
021	 6 x / Ø 52	Kress	100 x 105
023	 2 x 2 + 2 x 1	Flex Porter Cable	68 x 121

Ø = Bolt circle

Fastening systems



Strips, punched

EB	System	Dimensions in mm		
		for clamps	velour-backed	self-stick
001	2 x 5	115 x 280	115 x 230 115 x 240	115 x 230 115 x 240
002	2 x 5 / 2 x 2	115 x 280	115 x 230 115 x 240	115 x 230 115 x 240
003	2 x 4	93 x 230	93 x 178 93 x 184 93 x 195	93 x 178 93 x 184 93 x 195
004	2 x 4	81 x 166	81 x 153 80 x 133	81 x 153 80 x 133
005	2 x 3 / 2 x 1	93 x 230	—	—
006	2 x 2 / 1 x 3	93 x 230	—	—
008	8 x / Ø 87	—	115 x 115	—
009	2 x 3	115 x 140	100 x 115	—
010	2 x 5	93 x 230	—	—
011	4 x 2 / 1 x 2	—	100 x 237	—
012	2 x 7	—	70 x 420	—

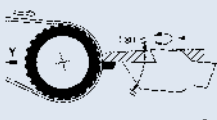
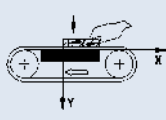
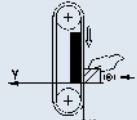
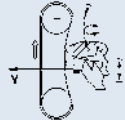
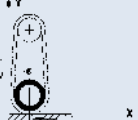
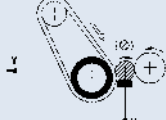
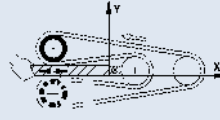




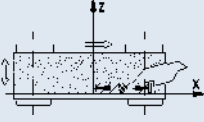
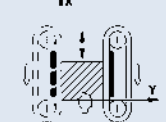
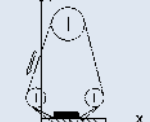
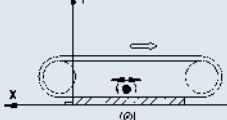
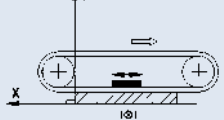
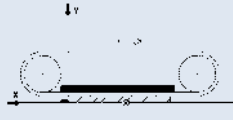
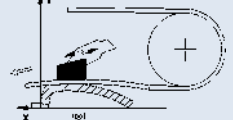



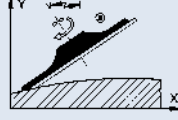
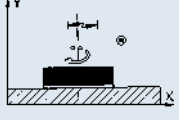
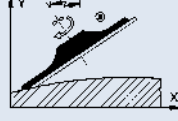
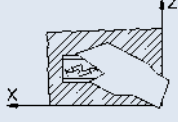
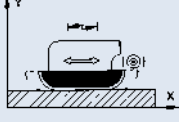
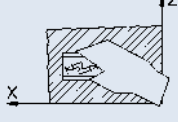
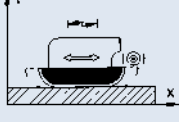
Ø = Bolt circle

Discs, punched

Ø	Hole system	Ø	Hole system	Ø	Hole system	Ø	Hole system	Ø	Hole system
73 mm	EB 130 6 x / Ø 41 mm	125 mm	EB 032 3 x / Ø 70 mm + 3 x / Ø 86 mm	125 x 18 mm	EB 119 8 x / Ø 90 mm with center hole	150 x 10 mm	EB 137 8 x / Ø 120 mm + 8 x / Ø 65 mm with center hole	150 x 18 mm	EB 135 8 x / Ø 120 mm + 6 x / Ø 80 mm with center hole
75 mm	EB 150 MULTI HOLE	125 mm	EB 033 5 x / Ø 72 mm	150 mm	EB 026 8 x / Ø 65 mm	150 x 10 mm	EB 237 48 x / Ø 123-39 mm with center hole	185 x 18 mm	EB 136 8 x / Ø 160 mm + 8 x / Ø 120 mm with center hole
115 mm	EB 026 8 x / Ø 65 mm	125 mm	EB 034 4 x / Ø 42 mm + 4 x / Ø 64 mm	150 mm	EB 027 6 x / Ø 80 mm	150 x 16.5 mm	EB 151 MULTI HOLE with center hole	200 mm	EB 028 8 x / Ø 127 mm
125 mm	EB 026 8 x / Ø 65 mm	125 mm	EB 150 MULTI HOLE	150 mm	EB 037 8 x / Ø 116 mm + 8 x / Ø 65 mm	150 x 18 mm	EB 036 8 x / Ø 120 mm with center hole	200 mm	EB 031 8 x / Ø 151 mm + 8 x / Ø 103 mm
125 mm	EB 030 4 x / Ø 41 mm	125 x 18 mm	EB 019 8 x / Ø 65 mm with center hole	150 mm	EB 150 MULTI HOLE	150 x 18 mm	EB 127 6 x / Ø 80 mm with center hole	225 mm	EB 122 8 x / Ø 70 mm

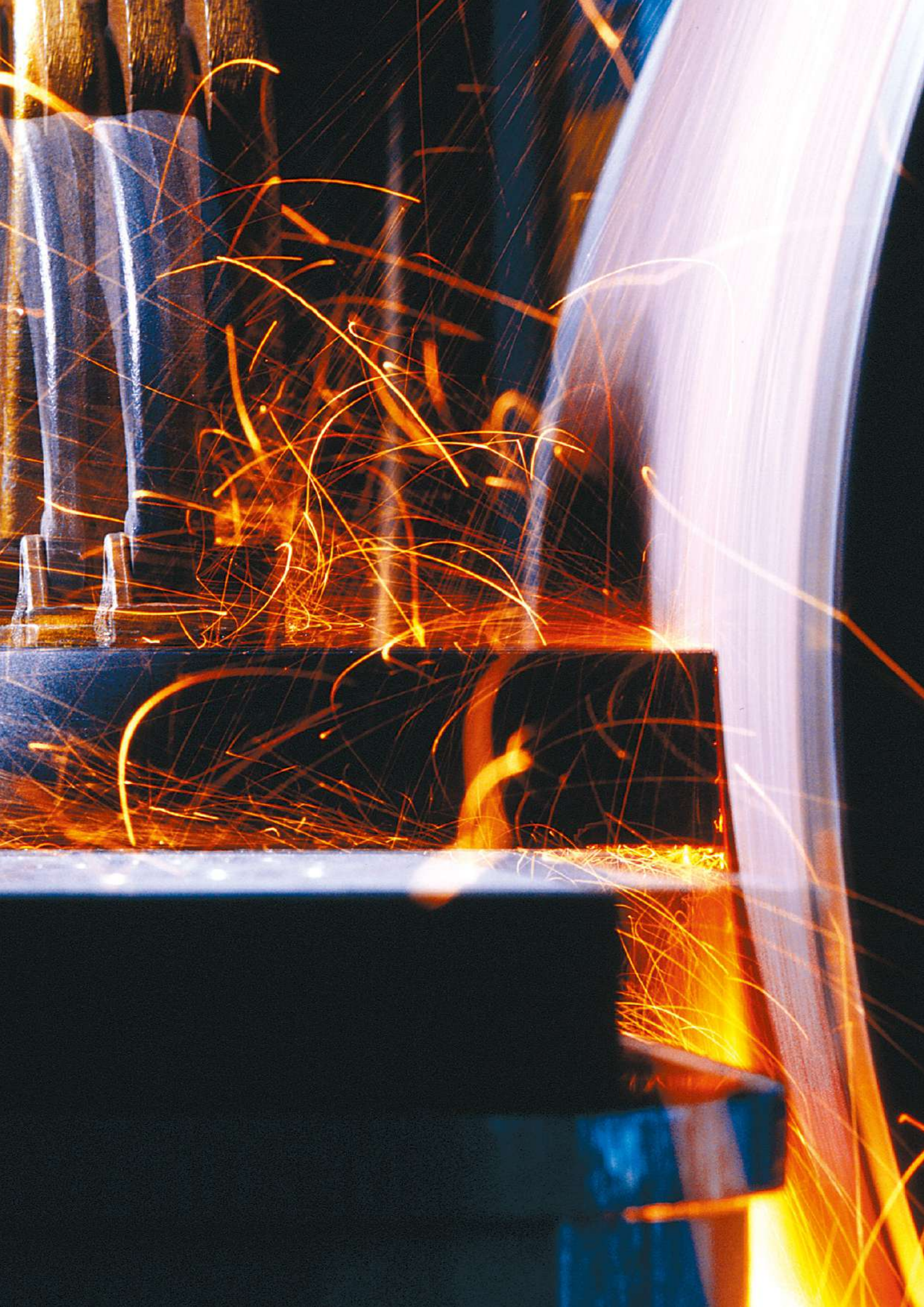
Ø = Bolt circle

### Kind of tools and grinding methods

Narrow belts				
	Backstand belt grinder	Horizontal platen grinder	Vertical platen grinder	Stack of belt grinder
				
	Conveyorized through feed belt grinder	Centerless grinder	Double side flat grinder (single belt)	
				
	Stationary platen grinder	Plunge grinder - heavy stock removal	Swing frame grinding machine	Swing frame grinding machine
Wide belts				
	Edge sander	Drawer sander	Profile sander	
				
	Lever stroke sander with roller	Lever stroke sander with pad	Lever stroke sander with contact bar	Lever stroke sander with hand block
				
	Wide belt machine	Wide belt machine	Wide belt machine	
Discs				
	Portable disc grinder	Random orbital sander		
Flap discs				
	Portable disc grinder			
Sheets, strips				
	Hand sanding	Orbital sander		
Rolls				
	Hand sanding	Orbital sander		

## Notices





# HERMES REFERENCE

## SAFETY

In order to guarantee the users of our abrasive tools the greatest possible safety at work, corresponding safety pictograms are depicted on the product labels, and we expressly point out that they must be observed.



Further instructions for the correct use of abrasive tools can be found in the leaflets of the FEPA safety recommendations. If you do not have the leaflets, please request them by e-mail at [hsd@hermes-schleifwerkzeuge.com](mailto:hsd@hermes-schleifwerkzeuge.com)

## STORAGE OF ABRASIVES

Hermes abrasives are quality tools and require appropriate storage conditions. Quality can be impaired by incorrect storage. Additionally, careful storage ensures you maximum benefit for at least 5 years.

Tools that have been stored for longer than 3 years or have demonstrably have not been stored in accordance with the following storage regulations may no longer be used.



- Room temperature 18 - 22 °C
- Relative humidity 45 - 65 %
- Store in original packaging if at all possible, and on shelves or pallets/racks
- Use deliveries in the order they arrived



- Close to radiators
- Extreme temperature fluctuations (cold/hot)
- Store directly on concrete or stone floors
- Store in unheated rooms in winter



THE SYMBOL OF SAFETY





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Safety first  
[www.abrasivessafety.com](http://www.abrasivessafety.com)