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Grinding Wheels P27

Safety Requirements for the Use, Care and Protection of Abrasive Wheels

ANSI B7.1-1978/Approved Feb. 18, 1988

TYPE 1 STRAIGHT WHEELS

Flanges Not Matched

Both the fixed and loose flanges between which a wheel is mounted must be of the same diameter (minimum 1/3 diameter of wheel) and properly relieved. See Fig. 5 for an example of correct mounting. If they are not the same diameter, the wheel is under a bending stress which is likely to cause fracture (See Fig. 6).

Distorted Flanges

Uneven flange pressures, caused by distortion of the flanges due to excessive tightening, create a dangerous condition. When flanges are sprung or distorted, the effective area of contact is reduced and the pressure is moved nearer the hole (See Fig. 7)

Outer Flange Omitted

Both flanges serve a useful purpose and it is extremely dangerous to omit either. In Fig. 8 the outer flange has been omitted and the nut tightened directly against the wheel.

Substitute Flange

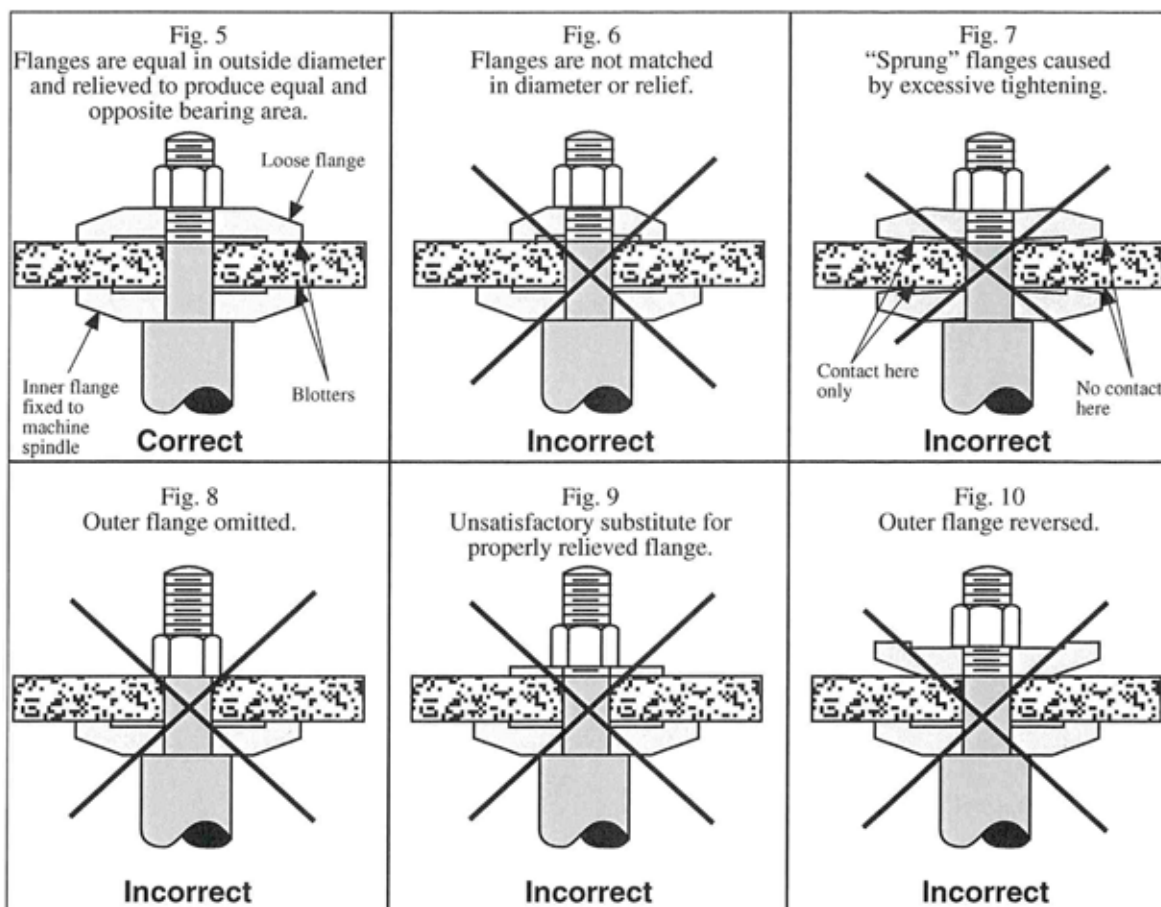
A washer is a dangerous substitute for a properly relieved flange. (See Fig 9). The bending stress imposed is likely to cause fracture of the wheel.

Outer Flange Reversed

The condition illustrated in Fig. 10 results in unequal pressure bearing against the wheel, and has the same effect as using flanges of unequal diameter.

Causes of Wheel Breakage

If the breakage of abrasive wheels could be prevented, there would be no need for a guard. Conversely, if all machines could be completely guarded there would be no cause for worry about wheel breakage. However, both must be considered. Everything must be done to prevent wheel breakage and proper guards must be used.





Grinding and Cut Off Wheels

- **Made with aluminum oxide for rapid metal removal**
- **IBS wheels generate less heat than standard wheels — this helps to avoid heat cracks due to overheating.**
- **Outlasts ordinary wheels by up to 300%.**

GRINDING WHEEL SAFETY

DO

1. Always handle and store wheels in a careful manner.
2. Always visually inspect all wheels before mounting for possible damage in transit.
3. Always check maximum operating speed established for wheel against machine speed.
4. Always check mounting flanges for equal and correct diameter.
5. Always use a machine guard covering at least one-half of the grinding wheel.
6. Always allow newly mounted wheels to run at operating speed, with guard in place, for at least one minute before grinding.
7. Always wear protective goggles or other protective eye-wear when grinding.

DON'T

1. Don't use a wheel that has been dropped. The impact may result in breakage.
2. Don't force a wheel onto the machine or alter the size of the arbor hole. Don't use a wheel that fits the arbor too loosely. If the wheel doesn't fit the machine, get one that does.
3. Don't exceed the maximum operating speed established for the wheel.
4. Don't use mounting flanges which are warped, nicked, sprung, or which are not clean.
5. Don't tighten the mounting nut excessively. On multiple screw mountings, 15 pounds per screw is enough.
6. Don't grind on the edge of the wheel unless the wheel is specifically designed for that purpose.
7. Don't start the machine unless the machine guard is in place.
8. Don't stand directly in front of a grinding wheel when a grinder is started.
9. Don't grind material for which the wheel is not designed.
10. Don't use relieved or recessed flanges with threaded hole cup wheels, cones or plugs.

CUT-OFF WHEEL SAFETY

AND CUTTING PROCEDURES

1. Cut-off wheels should never be stored on edges. Instead, they should be laid on solid flat surfaces away from excessive heat to prevent warpage.
2. Machines must have adequate power transmission and capacity, spindle speeds and proper guarding of the wheel. It is best to have extra power to insure good cutting efficiency.
3. Check the speed of the machine spindle against the maximum speed specified for the wheel by the manufacturer. The maximum specified speed for the wheel should never be exceeded.
4. Flanges should be clean and straight and of same diameter so wheel will run true. For wheel diameters above 10" it is recommended that the flange be at least 1/3 the diameter size of the wheel.
5. The bore size of the wheel is so constructed that wheel should fit freely on the machine spindle without any slack. Never attempt to force a wheel on the spindle!
6. Always use blotters when supplied with wheels.
7. Be sure the flanges are tightened securely but not too tightly to avoid springing the flanges and changing the pressure area.
8. Be sure the work piece is securely held down, including both sides of the cut, if practical. Cut-off wheels withstand a great deal of radial stress but not any side stress. Even reinforced wheels are not completely unbreakable. Side pressure must be avoided to insure straight cuts and avoid possible wheel breakage.
9. The wheel must be brought into contact with the work without bumping or impact. The wheel should cut freely without forcing and the speed of the wheel should not be reduced by the cutting operation.
10. Abrasive cutting generates a great deal of localized heat which causes rapid expansion of the piece being cut. Wheels operated at speeds significantly below efficient speed or if fed through the cut too slowly will generate excessive heat. Result: Rapid wheel wear fraying around the edge of reinforced wheel and wheel breakage.



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Grinding Wheels P27

APPLICATION CHART

| Indicates most common usages

Grinding Wheels

Cut-Off Wheels

	NITRO	CERAMIC	HI-ALLOY	MID-ALLOY	ALUM-ALLOY		CERAMIC	HI-ALLOY	MID-ALLOY
Materials / Applications						Steel			
Unalloyed & alloyed structural steel									
Structural steels with increased strength									
Tool Steel									
High Speed Steels									
Stainless Steel Shapes									
Super alloys (Inconel-Hastalloy) etc.									
Sheet metal									
Stainless sheet									
Grinding edges									
Weld removal									
Thin walled sectional tool									
						Castings			
Cast Steel									
Grey Cast Iron									
Nodular Cast Iron									
Malleable Cast Iron									
						Non-Ferrous Metals			
Brass, Bronze									
Copper									
Aluminum Alloys									

NITRO: Our fastest grinding wheel ever. This is a superior blend of high-performance grain that is 50% faster cutting than aluminum oxide.

Ceramic: Our toughest and longest lasting wheel. A patented ceramic aluminum oxide blend that is 2-3 times tougher than standard aluminum oxide.

Hi-Alloy: These are our high performance, heavy-duty wheels for various applications. Unique Zirconium and Aluminum oxide blends that provide longer life and faster performance than standard zirconium and aluminum oxide wheels.

Mid-Alloy: Unique Aluminum oxide blends for exceptional value and performance.

Alum-Alloy: Special aluminum oxide formulation for optimum performance with minimum loading and glazing.

A.N.S.I., DSA Approvals

For safety reasons grinding and cut-off wheels with high peripheral speeds can only be used in Germany if they have been tested and approved by the German Grinding Wheels Committee (DSA). These DSA Standards are equal to and sometimes exceed A.N.S.I. Safety Code B7.1 1989 standards by a wide margin.

Warning!

Improper use may cause property damage or serious injuries. Comply with A.N.S.I. Safety Code B7.1 and O.S.H.A. regulations. Use safety goggles and machine guards.

Proper Grinding Wheel Technique

Use the following grinding methods to achieve the desired aggressiveness of stock removal and quality of finish.

- For fast material removal increase the grinding angle between the wheel and the work piece.
- For blending and finishing decrease the grinding angle and apply light pressure and fluid motion.

Methods of Cutting

Abrasive wheels can cut materials such as steel, cast iron, non-ferrous metal, stone and ceramics, glass, fire bricks, plastics and exotic material such as Titanium, Inconel, Hastalloy, etc., fast, accurately and economically.

Also suited for red-hot material exceeding 1000°C e.g. rolled stock, continuous castings or forgings. Also when cooled down, this material can still be cut.

In particular materials of high tensile strength which are difficult to saw, e.g. high temperature alloys, high alloyed composite steels, but also stainless steels are the major use of abrasive cutting wheels.

A properly selected wheel and a high performance cut-off machine are necessities for economical abrasive cutting.

Cut-Off Machine Design

1. Adequate motor power and positive power transmission from drive to spindle. The power required depends on the wheel diameter and the cross-section being cut.
2. The feed speed should be adequately rated in order to permit efficient cutting of cold material up to 7.9"/sec. and red-hot material up to 13.8"/sec.
3. The work holding device should ensure rigid damping of work piece.
4. A well-functioning dust-extractor.
5. Wheel and belts must be well-guarded.

There are a number of well designed cut-off machines on the market, from manually operating swing frame cut-off machines (free-hand cutting operation) to remote controlled machines with automatic bar feed and all functional parts totally enclosed.



IBS, INCORPORATED

Grinding Wheels P27

IBS Hi-Alloy ERGO-TECH Cup Grinding Wheels

The saucer shaped grinding wheel features a "built-in" grinding angle which allows the operator to keep their elbow lower and their shoulder more relaxed than they would with a Type 27 or Type 28 wheel.



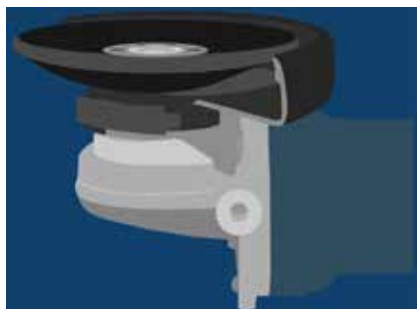
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for GRINDING ONLY

- The **unique design of the IBS Hi-Alloy Cup Grinding Wheel** allows **more contact between the wheel and the workpiece**, resulting in **more controlled grinding and blending without gouging with less pressure required**.
- **Patent pending ergonomic design** reduces worker fatigue, increasing productivity.
- **Ideal for both flat surfaces and rugged edge** grinding or beveling, making this a versatile wheel for multiple applications.
- **Especially effective on curved surfaces**, where the operator must reach or stretch to perform the job, improving user comfort and increasing productivity.
- The **special 20° design** versus the old Type 28 angle is **designed to fit under standard angle grinder guards**, making this a safer wheel with less chance of injury to workers for maximum workplace safety.
- **Built with 3 full layers of high tensile fiberglass reinforcement** for maximum workplace safety.
- **Designed with a combination of abrasive materials and an A30S grit** for an "all purpose" formulation, perfect for most metals.



SAFETY ADVANTAGE:
IBS Hi-Alloy ERGO-TECH Cup Grinding Wheels are designed to fit under most standard angle grinder guards when mounted with Depressed Center Wheel flanges provided with the tool.



The wheel has 3 full diameters of high tensile fiberglass reinforcement for maximum safety.



STANDARD TYPE 27 POSTURE



IBS ERGO-TECH POSTURE

IBS HI-ALLOY ERGO-TECH CUP GRINDING WHEELS

IBS No.	Dimensions Dia. x Thickness x Bore	MAX RPM	Qty
60000	4-1/2 X 1/4 X 5/8-11	13,300	10
60004	4-1/2 x 1/4 x 7/8	13,300	10



Nitro (Superfast) & Nitro XL Green Grinding Wheels

Our fastest grinding wheel ever! **NITRO** wheels are ideal for extremely fast stock removal on stainless steel, high nickel-based alloys, aluminum and steel. Cuts 20 percent faster than leading brands. Significantly faster grinding reduces time and labor — which means greater cost savings. The **NITRO XL (Xtra Life)** features the same specialty grain and bond combination as the original NITRO, but with the added benefit of a thicker, longer lasting wheel.

Features

- Proprietary high performance abrasive grain
- 20% cooler cutting

Benefits

- 50% faster cutting time than aluminum oxide
- 20% cooler cutting
- No discoloring or warping of stainless steel
- Better finish
- Reduced operator fatigue
- Smother, quieter grinding action with more control

Typical Applications

- Tank fabrication
- Power Plant Maintenance and Repair
- Welding / Metal Fabrication Shops

Storage

"NITRO" & "NITRO XL" SUPERFAST GRINDING WHEELS should be stacked flat, not on their edges, in a dry area.

WARNING:

Improper use may cause grinding wheel breakage and serious injury. Grinding wheels should always be used in strict accordance with National Standards Institute (ANSI) Safety Code B7.1 and OSHA regulations.



Type 27

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NITRO XL (XTRA LIFE) GRINDING WHEELS

IBS No.	Type	Arbor	Grit	Dimensions	RPM	Qty
67030	T27	Non Hubbed	36	4-1/2 x 1/4 x 7/8	13,300	10
67035	T27	Hubbed	36	4-1/2 x 1/4 x 5/8-11	13,300	10
67031	T27	Non Hubbed	36	5 x 1/4 x 7/8	12,200	10
67036	T27	Hubbed	36	5 x 1/4 x 5/8-11	12,200	10
67040	T27	Non Hubbed	36	7 x 1/4 x 7/8	8,500	10
67045	T27	Hubbed	36	7 x 1/4 x 5/8-11	8,500	10

NITRO (SUPERFAST) GRINDING WHEELS

IBS No.	Type	Arbor	Grit	Dimensions	RPM	Qty
67005	T27	Non Hubbed	36	4 x 3/16 x 5/8	15,000	10
67010	T27	Non Hubbed	36	4-1/2 x 3/16 x 7/8	13,300	10
67015	T27	Hubbed	36	4-1/2 x 3/16 x 5/8-11	13,300	10
67020	T27	Non Hubbed	36	7 x 3/16 x 7/8	8,500	10
67025	T27	Hubbed	36	7 x 3/16 x 5/8-11	8,500	10

GRINDING WHEEL NUTS



IBS No.	Thread Size	Minimum Wheel Thickness
56494	5/8-11	1/16

For use with 4-1/2" and 5" angle grinders. When mounting, grinding wheel nuts must be nested. GRINDING WHEEL NUTS are SOLD IN PAIRS ONLY.



IBS, INCORPORATED

Grinding Wheels P27

IBS Hi Alloy Grinding Wheels



IBS' super abrasive zirconia grain for rapid cutting combined with the innovative T27 and T28 design provide spectacular cut rate for maximum removal with unsurpassed wheel life.

- Outlasts standard aluminum oxide wheels.
- Allows for maximum stock removal.
- Fewer wheel changes means less downtime.
- Unique Type 28 design means less user fatigue.

TYPE 27

TYPE 28

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IBS No.	Type	Dimensions Dia. x Thickness x Bore	MAX RPM	Pkg Qty	Box Qty
60007	T28	7 x 1/4 x 5/8-11	8,600	1	10
61002	T27	4-1/2 x 1/4 x 7/8	13,300	1	10
61001	T27	4-1/2 x 1/4 x 5/8-11	13,300	1	10
61007	T27	7 x 1/4 x 7/8	8,600	1	10
62008	T27	7 x 1/4 x 5/8-11	8,600	1	10
62009	T27	9 x 1/4 x 5/8-11	6,800	1	10

IBS Alum-Alloy Grinding Wheels



TYPE 27

Specially formulated to resist loading when grinding aluminum or other non-ferrous materials. This grinding wheel features aggressive material removal while providing extended wheel life. The optimum wheel for grinding soft, non-ferrous materials, such as: aluminum, copper and brass

- For use on non-ferrous metals — excellent for a wide range of applications.
- Aluminum oxide formulation prevents loading or glazing.
- Internally reinforced with fiberglass layers combines safety with controlled performance.
- Soft abrasive bond to expose cutting edges — for aggressive material removal without loading.

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IBS No.	Type	Dimensions Dia. x Thickness x Bore	MAX RPM	Pkg Qty	Box Qty
63004	T27	4-1/2 x 1/4 x 5/8-11	13,300	1	10



GRINDING WHEEL NUTS

IBS No.	Thread Size	Minimum Wheel Thickness
56494	5/8-11	1/16"

For use with 4-1/2" and 5" angle grinders. When mounting, grinding wheel nuts must be nested. **GRINDING WHEEL NUTS are SOLD IN PAIRS ONLY.**

IBS Mid-Alloy Depressed Center Grinding Wheels

For general purpose grinding on all ferrous metals. Excellent for use on a wide range of grinding applications. Internally reinforced with fiberglass layers for long life and maximum safety.



Use on
ANGLE GRINDERS



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IBS No.	Dimensions Dia. x Thickness x Bore	MAX RPM	Pkg Qty	Box Qty
64002	4" x 1/4" x 5/8"	15,000	1	10
61114	4-1/2" x 1/4" x 5/8-11	13,300	1	10
63001	4-1/2" x 1/4" x 7/8"	13,300	1	10
00036	5" x 1/4" x 7/8"	12,000	1	10
61004	7" x 1/4" x 7/8"	8,600	1	10
62004	7" x 1/4" x 5/8-11	8,600	1	10
62006	9" x 1/4" x 5/8-11	6,800	1	10



GRINDING WHEEL NUTS

IBS No.	Thread Size	Minimum Wheel Thickness
56494	5/8-11	1/16"

For use with 4-1/2" and 5" angle grinders. When mounting, grinding wheel nuts must be nested. **GRINDING WHEEL NUTS** are SOLD IN PAIRS ONLY.

**A
B
R
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IBS Mid-Alloy Depressed Center Grinding Wheels "Dish" Type 28

Special wheel for heavy duty use on steel and non-ferrous metals. Heavy surface grinding of masonry, concrete, and stone materials. Due to its shape it has 2-1/2 times greater bending strength than flat depressed center grinding wheels. A 15° angle built into the design means it can be used almost horizontally for less fatigue and less possibility of edge chipping.



- Aluminum Oxide
- Fast Stock Removal
- Long Service Life

Use on
ANGLE GRINDERS



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IBS No.	Dimensions Dia. x Thickness x Bore	MAX RPM	Pkg Qty	Box Qty
63064	9" x 1/4" x 5/8-11	6,800	1	10



IBS, INCORPORATED

Grinding Wheels P27

TriFlex Grinding, Blending & Finishing Wheels



TriFlex Grinding, Blending, & Finishing Wheels are flexible abrasive wheels designed for blending and finishing stainless steel, carbon steel, and aluminum surfaces in just one step.

FOR USE ON: Stainless steel, carbon steel and aluminum surfaces

FEATURES & BENEFITS:

- **Engineered with abrasive grain consistent throughout the wheel** for an even optimal finish for the entire life of wheel – resulting in reduced labor and inventory costs.
- **Innovative blend of materials** results in a wheel that is tough enough to grind and blend yet soft enough to finish in one step for fewer disc changes and faster processing, saving time and money.
- **Made with a blend of cotton fibers and abrasive materials** that are naturally non-loading on all metals making them ideal for use on a variety of materials for reduced inventory costs.
- **Has no backing material that could gouge work surface**, providing a better, more consistent finish throughout the life of the disc for reduced labor and inventory costs.
- **Uniquely engineered with laminates of non-woven abrasive impregnated into cotton fabric**, providing a cushion action for greater flexibility and a better surface finish.
- **The thicker design and flexibility of the wheel** result in longer life – outlasts Surface Conditioning Discs 4-5 times saving time and money.



Size	36 Grit	54 Grit	MAX RPM	Qty
4-1/2 X 7/8	40361	40363	13,300	10
4-1/2 X 5/8-11	40362	40364	13,300	10

For Use with Angle Grinder ONLY

A
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1/4" Air Die Grinder (T03)

- Designed for tight, tough quarter jobs that require fast metal removal.
- Very maneuverable and perfect for those hard-to-reach areas.
- 1/4" capacity collet with two collet wrenches included.



IBS No.	Description	RPM	HP
69282	1/4" Air Die Grinder	22,000	.33
69283	1/4" Air Die Grinder W/ Regulator	25,000	.40.

Grinder NOT for use with cut-off wheels over 3" in diameter.
Refer to ASTM B7.1-2001

1/4" 90° Angle Air Die Grinder (T03)

- Great for tight or angled grinding jobs that an in-line die grinder won't reach.
- Rugged ball-bearing motor provides up to 22,000 RPM.
- Efficient rear exhaust air flow system is preferred by professionals everywhere.
- Lever throttle action and 90° angle provide mobility and control.
- Speed (RPM) 22,000.



IBS No.	Description	RPM	HP
127357	1/4" 90° Angle Air Die Grinder	22,000	.30

Grinder NOT for use with cut-off wheels over 3" in diameter.
Refer to ASTM B7.1-2001

Flipout Grinder Nut (P31)

The Flipout Grinder Nut is a unique speed nut that saves time and money by making wheel and disc changes a wrench-less job.



- 5/8-11 Thread
- Quick & Easy Wheel Changes
- No need to purchase the added expense of a built-in arbor on every wheel.
- No searching for a lost wrench!

IBS No.	Thread Size	Description
56495	5/8-11	Flipout Grinder Nut

Grinding Wheel Nuts (P31)

For use with 4-1/2" and 5" angle grinders. When mounting, grinding nuts must be nested. **SOLD IN PAIRS ONLY**



GRINDING WHEEL NUTS

IBS No.	Thread Size	Minimum Wheel Thickness
56494	5/8-11	1/16"

Mandrels (P31)

Mandrels are made of high strength alloy steel, precision machined and heat treated for product safety.



IBS No.	Dimensions (Arbor x Shank)	Use With
69026	1/4" x 1/4"	Cut-Off Wheels
69027	3/8" x 1/4"	Cut-Off Wheels
69030	1/4" x 1/4"	3" Grinding Wheels



IBS, INCORPORATED

Cut-Off Wheels P27

DIAMOND Cut-Off Wheels

Diamond Cut-Off Wheels are our longest lasting cut-off wheels for **sheet metal, mild steel and composite** applications. Made with the highest quality diamond grit allowing longer life, more consistent cuts, and fewer wheel changes, this wheel will last more than 10 times longer than any abrasive cut-off wheel used to cut sheet metal and mild steel.

NOTE: Designed for cutting sheet metal, mild steel and composites. Not for cutting hardened metals or exotic alloys.



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3" Use on
Variable Speed
DIE GRINDERS



for CUT-OFF ONLY

- **Speed Regulated Die Grinders and Angle Grinders are recommended** as these wheels work best when run at slower speeds - typically 1/2 of the MAX RPM listed (i.e. RPM rating on the 3" wheel is 20,000 and therefore a Die Grinder with a speed regulator to run this wheel at 10,000 RPM is recommended to achieve optimum life and results). Running at slower speeds improves performance and enhance the overall life of the wheel.
- Can Also be used to cut angle iron, pipe, electrical conduit, re-bar, metal stud, structural metal make them a **versatile option to reduce wheel change outs**.
- Features **Vacuum Brazed Diamond Grit** that adheres to the wheel longer and better and generates less dust than standard abrasive cut-off wheels which makes for a cleaner, safer cut.
- Unlike regular abrasive cut-off wheels that change diameter during the cutting operation, **Diamond Cut-Off Wheels maintain a maximum cutting depth throughout the life of the wheel**.
- **Bi-directional rotation** can be used on reversible tools to direct sparks and debris away from the operator.
- **Both wheels can be used in WET or DRY applications, and save time and money on multiple job applications and wheel change-outs.**

IBS No.	Description	MAX RPM
69300	3X0.5X3/8 Diamond Cut-Off Wheel	20,000

NOTE: RPM rating on the 3" wheel is 20,000 and therefore a Die Grinder with a speed regulator is recommended. A slower RPM is recommended (as much as 1/2 the MAX) to improve performance and enhance the overall life of the wheel.

RIPPER Cut-Off Wheels

High Performance Cutting Technology

For Use on Stainless Steel, Sheet Metal,
Ferrous & Non-Ferrous Metals, and Copper Tubing



- **New abrasive technology with a highly advanced bond system is engineered for durability** which means it will outlive other wheels by 3 to 10 times - resulting in fewer wheel change outs and reduced labor costs.
- **Manufactured with an extraordinarily tough abrasive blend that continuously exposes new abrasive material** for a constant aggressive cutting edge that won't load and will cut cooler – for a wheel that cuts faster and lasts longer.
- **Each wheel is protected with our unique moisture blocker** eliminating up to a 50% loss in performance that results when an abrasive absorbs moisture in the air - assuring optimal life and consistent performance for the life of the wheel.



TYPE 27



TYPE 1

Use on
ANGLE GRINDER



for CUTTING ONLY

RIPPER — CUT-OFF WHEELS

IBS No.	Dimensions Dia. x Thickness x Bore	Type	MAX RPM	Pkg Qty	Box Qty
62541	4-1/2" x .045" x 7/8"	27	13,300	5	50
69540	4-1/2" x .040" x 7/8"	1	13,300	10	50
62560	6" x .045 x 7/8"	27	10,185	5	25
69560	6" x .045 x 7/8"	1	10,185	5	25

RIPPER — .032 THIN CUT-OFF WHEELS

IBS No.	Dimensions Dia. x Thickness x Bore	Type	MAX RPM	Pkg Qty	Box Qty
62540	4-1/2" x .032" x 7/8"	27	13,300	10	50

Use on
ANGLE GRINDER



for CUTTING ONLY

RIPPER — COMBINATION CUT / GRIND WHEEL

IBS No.	Dimensions Dia. x Thickness x Bore	Type	MAX RPM	Pkg Qty	Box Qty
62545	4-1/2" x .075" x 7/8"	27	17,900	5	25

RIPPER Extra Thin, .032 wheel:

FEATURE:

Extra thin cutting disc at only .032 thick is thinner than standard cut off wheels means:

- **Less surface to surface friction** means the wheel cuts fast and with less friction for a cool cut with minimal material loss for a longer life with fewer wheel change outs and reduced labor and inventory costs.
- **Narrow cut requires less pressure with minimal vibration** for improved safety which reduces operator fatigue and time loss.
- **Fast-cutting, exceptionally precise, clean, practically burr-free, smooth-running cut** for optimal results and less rework.

BENEFIT:

A thinner wheel will last longer, cut faster and cut burr free, which means fewer change outs for reduced labor and inventory costs, improved safety, accuracy and production, and minimize rework and operator fatigue.

RIPPER Combination Cut/Grind Wheel:

- **Designed with 3 full surface fabric layers to provide the reinforcement, strength and extremely high side-stability** to allow the wheel to perform aggressively like a grinding wheel while also remaining thin enough to cut giving the user the ability to cut, notch, debur and grind with a single product – resulting in fewer wheel changes for reduced labor and inventory costs.



IBS, INCORPORATED

Cut-Off Wheels P27

IBS Ceramic Cut-Off Wheels for Die Grinders

The IBS Ceramic Cut-Off Wheel is our fastest cutting, longest lasting **ABRASIVE WHEEL!** That means fewer wheel change-outs, reduced labor costs, inventory, and downtime for increased cash flow and efficiency.



TYPE 1

- **Heat-treated CERAMIC GRAIN** — Cuts up to 50% faster than zirconium and up to 6 times faster than aluminum oxide. Ceramic grain fractures cleaner and is the sharpest of any abrasive grain. This fracturing means that new, sharper cutting edges are constantly exposed. The result is optimum performance.
- **Thin** — 1/32" thickness means less friction, less heat build up, faster cutting and maximum life.
- **Designed for tough cutting applications** — Out performs zirconium in all applications.
- **Key applications** — Stainless steel, sheet metal, ferrous and non-ferrous metals and copper tubing.
- **For Optimum Performance** — Apply continuous wheel pressure so that new cutting edges are continuously being exposed.

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3" & 4" Use on DIE GRINDERS 4-1/2" Use on ANGLE GRINDER



for CUT-OFF ONLY



for CUTTING ONLY

IBS CERAMIC CUT-OFF WHEELS FOR DIE GRINDERS

IBS No.	Dimensions Dia. x Thickness x Bore	MAX RPM	Pkg Qty	Box Qty
69350	3" x 1/32" x 3/8"	25,100	10	50
69354	4" x 1/32" x 3/8"	20,140	10	50

IBS CERAMIC CUT-OFF WHEELS FOR ANGLE GRINDERS

IBS No.	Dimensions Dia. x Thickness x Bore	MAX RPM	Pkg Qty	Box Qty
69358	4-1/2" x .040" x 7/8"	17,902	5	50

IBS Hi Alloy Cut-Off Wheels for Die Grinders

IBS Hi Alloy Cut-Off Wheels are made of premium zirconium grain for rapid cutting and maximum life. Zirconium grain (synthetic diamond) is the toughest material available for cutting:



TYPE 1

- **Resharpens as it cuts** — for rapid cutting of the toughest steels including stainless. Reduces downtime.
- **Won't load** — lasts up to 5 times longer than aluminum oxide wheels. Excellent on aluminum. Saves money.
- **Runs cool** — won't burn up. Longer life means less replacement. Reduces labor costs associated with the time spent to replace parts.

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for CUT-OFF ONLY USE WITH GUARDS

Use on ANGLE GRINDER



for CUTTING ONLY

IBS HI ALLOY CUT-OFF WHEELS FOR DIE GRINDERS

IBS No.	Dimensions Dia. x Thickness x Bore	Grit	MAX RPM	Pkg Qty	Box Qty
69308	3" x 1/32" x 3/8"	60	25,100	10	25/50/100
69313	3" x 1/16" x 3/8"	60	25,100	10	25/50/100
69312	3" x 1/16" x 1/4"	60	25,100	10	25/50/100
69408	4" x 1/32" x 3/8"	60	20,140	10	25/50
69414	4" x 1/16" x 3/8"	60	20,140	10	25/50

IBS HI ALLOY CUT-OFF WHEELS FOR ANGLE GRINDERS

IBS No.	Dimensions Dia. x Thickness x Bore	Grit	MAX RPM	Pkg Qty	Box Qty
69425	4-1/2" x .040" x 7/8"	60	17,902	5	25
69609	6" x .042" x 7/8"	60	14,200	5	25

IBS Hi-Alloy Cut-Off Wheels for Angle Grinders Fast Cut for Stainless Steel Cut-Off Wheel

- **Thin Type 27 configuration** for use on right angle grinders. Easier to use with more control.
- **Unique bonding system** allows for fast burr free cutting.
- **Maximum performance with minimum wear** means less wheel changes and downtime.
- **Externally reinforced with fiberglass layers** combining safety with controlled performance.



TYPE 27

IBS HI ALLOY CUT-OFF WHEEL FOR ANGLE GRINDERS

IBS No.	Dimensions Dia. x Th. x Bore	MAX RPM	Pkg Qty	Box Qty
62450	4-1/2" x .045" x 7/8"	13,300	1	10
62455	5" x .040 x 7/8	12,000	1	25

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for CUTTING
ONLY

Mid Alloy Flat Cut Off Wheel Premium Performance

Premium performance cut-off wheel for steel, cast iron and non-ferrous metals.

- Aluminum Oxide
- Fast Cutting Action
- Long Service Life



TYPE 1

MID ALLOY FLAT CUT-OFF WHEELS "Premium Performance"

IBS No.	Dimensions Dia. x Th. x Bore	MAX RPM	Pkg Qty	Box Qty
63502	4" x 3/32" x 5/8"	19,000	1	25
63503	4-1/2" x 3/32" x 7/8"	13,300	1	25
63505	5" x .040 x 7/8	12,000	1	25
63504	6" x .045" x 7/8"	10,000	1	25

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IBS, INCORPORATED

Cut-Off Wheels P27

Mid Alloy Flat Cut-Off Wheel "Diamond Bore Type"

Designed for portable circular saws. Features Diamond bore with reusable 5/8" bushing.

- Aluminum Oxide
- Fast Cutting Action
- Long Service Life



TYPE 1

MID ALLOY FLAT CUT OFF WHEEL "Diamond Bore Type"

IBS No.	Dimensions Dia. x Th. x Bore	MAX RPM	Pkg Qty	Box Qty
63842	7" x 3/32" x 5/8" ♦	8600	1	10

♦ Diamond Shaped Arbor

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CIRCULAR SAWS



for CUTOFF ONLY

Mid-Alloy Depressed Center Cut-Off Wheel

General purpose cut-off wheel for steel, cast iron, difficult to cut materials and non-ferrous metals.

- Aluminum Oxide
- Fast Cutting Action
- Good Service Life



TYPE 27

MID ALLOY DEPRESSED CENTER CUT-OFF WHEELS

IBS No.	Dimensions Dia. x Th. x Bore	MAX RPM	Pkg Qty	Box Qty
63006	4-1/2" x 3/32" x 7/8"	13,300	1	10
63007	4-1/2" x 3/32" x 5/8-11	13,300	1	10
63012	7" x 1/8" x 5/8-11	8,600	1	10

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High Speed Portable Cut-Off Wheel

Designed for cutting of steel, non-ferrous metals on portable cut-off machines. A durable, hard-working wheel for a variety of applications on the job site. Excellent for rebar, steel pipe, sheet metal and structural steel or stainless.

- Aluminum Oxide
- Fast Cutting Action
- Long Service Life



TYPE 1

HIGH SPEED PORTABLE CUT-OFF WHEELS

IBS No.	Dimensions Dia. x Th. x Bore	MAX RPM	Pkg Qty	Box Qty
63509	9" x 3/32" x 7/8	6800	1	25
63034	12" x 1/8" x 1	6300	1	10
64602	12" x 1/8" x 20mm	6300	1	10
64603	14" x 1/8" x 1	5460	1	10
64604	14 x 1/8 x 20mm	5460	1	10

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HIGH SPEED
SAWS



for CUTOFF ONLY

Heavy Duty Wheels for **DUCTILE, CAST IRON** — designed for sewer and water construction and maintenance. Cuts ductile iron, cast iron, and concrete-lined pipe.



TYPE 1

HEAVY DUTY WHEELS FOR DUCTILE CAST IRON

IBS No.	Dimensions Dia. x Th. x Bore	MAX RPM	Pkg Qty	Box Qty
64612	12" x 1/8" x 20mm	5100	1	10
64614	14" x 1/8" x 1"	6300	1	10
64615	14 x 1/8 x 20mm	5460	1	10

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HIGH SPEED
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for CUTOFF ONLY



Cut-Off Wheel Stationary Use

General purpose cut-off wheel for cutting structural steel, bar stock, tubing and non-ferrous metals on stationary machines.

- Aluminum Oxide
- Fast Cutting Action
- Good Service Life



TYPE 1

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STATIONARY
SAWS



for CUTOFF
ONLY

STATIONARY MID-ALLOY CUT-OFF WHEELS

IBS No.	Dimensions Dia. x Th. x Bore	MAX RPM	Pkg Qty	Box Qty
66002	12" x 1/8" x 1"	5100	1	20
66016	14" x 1/8" x 1"	4400	1	10
66004	16" x 5/32" x 1"	3800	1	10

14" Hi-Alloy Chop Saw Cut-Off Wheels

- Made of premium zirconium grain for rapid cutting and maximum life.
- Re-sharpens as it cuts — for rapid cutting of the toughest steels including stainless.
- Won't load — last up to 5 times longer than aluminum oxide wheels.
- Runs cool — won't burn up. Longer life means less replacement. Reduces labor costs associated with time spent to replace parts.



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for CUTOFF
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14"HI-ALLOY CHOP SAW CUT-OFF WHEEL

IBS No.	Dimensions Dia. x Th. x Bore	MAX RPM	Pkg Qty	Box Qty
69502	14" x 7/64" x 1"	4366	1	10

Chop Saw Cut-Off Wheels

Cut-off wheels for cutting drywall studs, rebar and other small cross sections on low-powered chop saws.

- Aluminum Oxide
- Fast Cutting Action
- Long Service Life



TYPE 1

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CHOP SAW MID ALLOY CUT-OFF WHEELS

IBS No.	Dimensions Dia. x Th. x Bore	MAX RPM	Pkg Qty	Box Qty
64501	12" x 1/8" x 1"	5100	1	10
64502	14" x 3/32" x 1"	4365	1	10
64503	16" x 3/32" x 1"	3800	1	10



Safety Information

Warning — In normal power brushing operations the material being removed, such as burrs, scale, dirt, weld slag, or other residue will fly off the brush with considerable force along with brush filaments which break off due to fatigue.

THE POTENTIAL OF SERIOUS INJURY EXISTS for both the brush operator and others in the work area (possible 50 or more feet from the brush). To protect against this hazard, wear SAFETY GOGGLES or FULL FACESHIELDS WORN OVER SAFETY GLASSES WITH SIDE SHIELDS, ALONG WITH PROTECTIVE CLOTHING.

You must follow all operator and safety instructions, as well as all common safety practices which reduce the likelihood of physical injury, or reduce its severity.

Safety Goggles — Safety goggles or full face shields worn over safety glasses with side shields MUST BE WORN by all OPERATORS and OTHERS IN THE AREA of power brush operations. Comply with the requirements of ANSI Z87.1-1979 "Occupational Eye and Face Protection."

Guards — Keep all machine guards in place.

Speeds — Observe all speed restrictions indicated on brushes, containers, labels, or printed in pertinent literature. "MSFS" means Maximum Safe Free Speed (RPM) — spinning free with no work applied. For reasons of safety, "MSFS" should not be exceeded under any circumstances.

Safety Standard — Comply with the Safety Standards of the Industrial Division of the American Brush Manufacturer's Association and the American National Standards Institute Standard ANSI B165.1-1979 — Safety Requirements Power Brushes and ANSI B165.2. Staple Set Power Brush Safety.

Protective Equipment — Appropriate protective clothing and equipment must be used where there is a possibility of injury that can be prevented by such clothing or equipment.

WARNING! FAILURE TO OBSERVE SAFETY PRECAUTIONS MAY RESULT IN INJURY.

BRUSH USAGE RECOMMENDATIONS

Pressure — Avoid excessive pressure when using a power brush. Excessive pressure causes over-bending of the filaments and heat build-up resulting in filament breakage, rapid dulling, and reduced brush life. Instead of greater pressure on a brush, it is suggested that you try: 1) a brush with a more aggressive cutting action (increased wire size, decreased filament length, change to a different brush type, i.e., knot type instead of crimped wire type) or 2) higher speed (increased RPM, increase brush diameter).

Important Note: Never exceed the recommended Maximum Safe Free Speed RPM (MSFS) rating of the brush.

Self-Sharpening — When using wire wheel brushes periodically reverse the direction of rotation to take advantage of the self-sharpening action that will result. This may be accomplished by removing the brush from the spindle and turning side for side and remounting securely.

Brushing Problems — Do Not Allow Unsafe Conditions to Continue. Occasionally, due to worn bearings, a bent spindle, an unusual application, operator abuse or inappropriate use, a brush may fail. A brush which is not received in acceptable condition for trouble-free operation may also fail. Do not use or continue to use a failed brush or one which is functioning improperly (i.e., throwing filaments, out-of-balance, etc.) as this increases the possibility for further brush failure and hazard of injury. The cause of the failure should be evaluated and corrected.

This information is based on the collective experience of the ABMA Industrial Division members and provided solely as a public service for the guidance of users of the member's products. These recommendations are not necessarily complete with respect to any particular application and common sense safety considerations should be adhered to generally. Any applicable federal, state, local law or regulation, must be strictly adhered to, and is controlling over any recommendation contained herein.



General Information

Power Brush Applications

Deburring — Power brushes are widely used to remove burrs created by other machining operations. Power brushes can completely remove burrs without creating secondary burrs or leaving two sharp edges. Unlike grinding tools, brushes are selective to an edge; they will remove the burr but none of the base material.

Surface Finishing — Power brushes are excellent tools for improving surface finishes to gain a desired appearance. Brushes do not remove the base metal. They remove only the metal particles left on the surface which have been ground or abrasive polished. Power brushing also tends to relieve stress created by other machining operations. Many different surface finishes can be obtained by using power brushes.

Edge Blending — Power brushes are ideal for developing a rounded corner at the juncture of two surfaces. Power brushes perform this application without removing material on the surface adjacent to the edge or changing the part tolerance. This reduces stress concentration and part fatigue, increases part life and improves the surface finish.

Roughening — Power brushes are uniquely suited for creating better bonds on surfaces such as rubber, leather, plastics, and non-ferrous metals. Surfaces can be roughened prior to painting or bonding to achieve better adhesion.

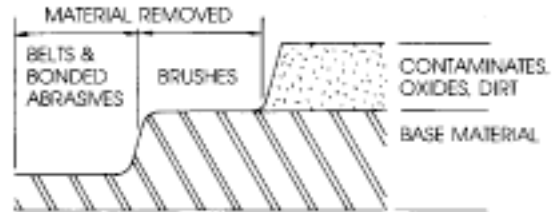
Cleaning — Power brushes are distinctly suited for removal of surface film, dirt, rust, heat treat scale, weld slag, corrosion and paint. Power brushes also remove varnish and insulation from electrical wire, motor stators, etc. Fiber, synthetic and fine stainless steel brushes can be used for wet-cleaning operations.

Advantages of Power Brushes

Rugged Construction — the only surface cleaning and conditioning tool tough enough to stand up under prolonged heavy use.

Easy on Equipment — brushes are non-abrasive so they do not produce equipment-destroying abrasive dust.

True Selective Cutting — brushes act as an impact tool removing surface contamination with millions of tiny hammer blows without cutting away any base material as abrasives will.



Power brushes remove surface contaminants such as oxides, rust, dirt or other residuals and leave a smooth clean surface.

Stress relieving and surface conditioning — Brushing action produces the same effect as shot peening (a method used to increase the life of highly stressed parts in aircraft and race cars) without adding extra operations. Brushing will not change part tolerances.

Brushes are non-loading — Unlike woven, bonded and coated abrasives, brushes will not load when brushing soft materials.

Brush Fill Materials Wire Types

HT — Is high tensile, heat-treated steel wire which has excellent fatigue resisting and fast cutting qualities. This wire is used in all steel filled power brushes in .008 diameter and above unless otherwise indicated.

TC — Is hard draw wire generally used in .005 and .006 diameter where aggressive cutting action is required for fine surface work.

Stainless (Type 302) — Is highly corrosion resistant and should be used where contamination or after-rust is a problem, such as in brushing aluminum or stainless steel parts. **ALL STAINLESS STEEL BRUSHES ARE MADE WITH TYPE 302 STAINLESS.**

To the layman, most stainless steel looks alike. Stainless steel brush wire is slightly magnetic because it is cold worked to make it hard. Type 302 Stainless Steel will lose its magnetic properties if a wire strand is heated red with a match. If the wire strand retains its magnetic properties after heating it is not Type 302 Stainless Steel.

Power Brush Operating Instructions

Brushing Speeds

1. Power brushes as cutting tools have a most efficient speed and pressure for specific operations. In most operations, the highest speed and lightest pressure will assure fastest cutting action and longest brush life.
2. Using as fine a wire as possible usually results in longer brush life. Increasing the speed of a brush increases the face hardness and cutting action; therefore, a Fine Wire brush rotating at a higher speed will often produce the same results as a Coarser Wire brush rotating at slower speed. Finer Wires operating at a higher speed is generally preferred and will normally provide a longer brush life.
3. Maximum Safe Free Speed — MSFS (RPM) specified in this catalog and on the product are the maximum speeds which the brushes may be used safely and are not necessarily the optimum speed for a given application. Operating speed should be determined by the application, but should not exceed the MSFS (RPM) for which the brush is rated.

Brushing Pressure

1. Remember . . . the tips of a wire brush do the work. Operate the brush with the lightest pressure so only the tips of the wire come in contact with the work.
2. If heavier pressures are used, the wires will be over-stressed, resulting in a wiping action; and if this is continued, the life of the brush will be shortened due to wire fatigue.
3. Apply the work to the face of the brush in such a way that as much of the brush face as possible is in full contact with the work. Applying the work to the side or edge of the brushing tool will result in wire breakage and shortened brush life.
4. Reversing the brush rotation periodically will tend to increase the life of the brush. This results in the re-sharpening of the wire tips or ends, insuring faster cutting action.



CORRECT
Tips doing the work



INCORRECT
Excessive pressure can cause wire breakage

Brushing Action

There are many variables in Power Brushing conditions. In many cases, one or more Power Brushes may accomplish the same results; however, if one brush does not accomplish the desired results, follow the suggestions below:

Brushing Results	Recommended Changes
Works Too Fast	Increase trim length Reduce wire size Reduce fill density Reduce brush dia. or RPM
Works Too Slow	Reduced trim length Increase wire size Increase fill density Increase brush dia. or RPM
Burr Rolled or Peened	Increase fill density Reduce Wire Size
Short Brushing Life	Increase trim length Reduce wire size
Non-Uniform	Increase trim length
Brushing Action	Decrease fill density Use brushing fixture

Flexibility

Long trim brushes are more flexible and are able to follow contoured surfaces. Conversely, short trim brushes are faster acting and suited for more severe brushing action.

Use Brushed Instead of:

- Abrasive Belts
- Harsh Chemicals
- Non-Woven Nylon Products (which wear rapidly)
- Hand Filing
- Sand Blasting
- Steel Wool
- Buffing Wheels
- Hand Sanding
- Tumbling or Vibratory Finishing
- Grinding Wheels



IBS, INCORPORATED

Brush Info Tables

Horse Power

The factors affecting the horse power required for power brushing are as follows:

1. Speed of the brush.
2. Brushing pressure required in application.
3. Resistance between the work and the brush.

The chart to the right provides a guide for determining the horsepower required, based on medium brushing action for 1" brush face.

Brush Dia.	Motor Size	RPM
4"	1/4 HP	3,450
6"	1/2 HP	3,450
8"	3/4 HP	3,450
10"	1 HP	1,750
12"	1 HP	1,750
15"	1-1/2 HP	1,750

TABLE OF SURFACE SPEEDS (PERIPHERAL SPEED IN FT/MIN.)

RPM	Diameter (Inches)							
	2	3	4	6	8	10	12	15
1000	525	785	1050	1575	2100	2625	3150	3925
1500	785	1175	1575	2350	3150	3925	4725	5900
1750	915	1375	1850	2750	3650	4550	5500	6800
2500	1300	1950	2625	3925	5250	6550	7850	9825
3000	1575	2350	3125	4725	6275	7850	9425	11775
3450	1800	2700	3600	5400	7200	9000	11000	13500
4000	2100	3150	4175	6275	8375	10475	—	—
6000	3125	4750	6275	9425	—	—	—	—
10,000	5250	7850	10500	—	—	—	—	—
15,000	7850	11775	15750	—	—	—	—	—
20,000	10450	15700	20950	—	—	—	—	—

RECOMMENDED SURFACE SPEEDS FOR BRUSHING APPLICATIONS

Application	Surface Ft Per Min	Application	Surface Ft Per Min
Removing Burs	5500 to 7500	Cleaning (Dry)	4000 to 5500
Removing Scale	7500 to 10000	Cleaning (Wet)	1900 to 4000
Cleaning Welds	7200 to 9400	Surface Polishing	6400 to 8000
Edge Blending	4700 to 7500	Surface Buffing	8000 to 10000

WIRE GAUGES & DECIMAL EQUIVALENTS IN INCHES AND MILLIMETERS

Wire sizes in this catalog are show in decimals of an inch. Corresponding American Steel Wire (formerly Washburn & Moen) gauges and millimeter sizes are listed below.

No. of Gauge	20	23	24	25	26	28	30	32
Diam. (inches)	.035	.026	.023	.020	.018	.016	.014	.0128
Diam. (mm)	.89	.66	.58	.51	.46	.41	.36	.33
No. of Gauge	33	34	35	36	38	43	47	
Diam. (inches)	.0118	.0104	.0095	.009	.008	.006	.005	
Diam. (mm)	.30	.26	.24	.23	.20	.15	.13	

ENGLISH METRIC EQUIVALENTS

Brush Diameter		Brush Face Width		Arbor Hole Sizes	
English	Metric	English	Metric	English	Metric
3"	76mm	1/8"	3mm	1/4"	6.4mm
4"	102mm	1/4"	6mm	3/8"	9.5mm
6"	152mm	3/8"	10mm	1/2"	12.7mm
7"	178mm	1/2"	13mm	5/8"	15.9mm
8"	203mm	5/8"	16mm	3/4"	19.0mm
10"	254mm	3/4"	19mm	7/8"	22.2mm
12"	305mm	7/8"	22mm	1"	25.4mm
14"	356mm	1"	25mm	1-1/8"	28.6mm
15"	381mm	1-1/8"	29mm	1-1/4"	31.8mm
16"	406mm	1/4"	32mm	1-1/2"	38.1mm
		1-1/2"	38mm	1-3/4"	44.5mm
		2"	51mm	2"	50.8mm

Equivalent Units

1 inch = 25.4 millimeters

1 millimeter = 0.03937 inch



SMALL ANGLE GRINDER REFERENCE CHART				
Make	Model Numbers	Male Thread Size	Model Description	RPM
AEG	WS601	5/8-11 UNC	4-1/2" Angle Grinder	10,000
	WS750	5/8-11 UNC	4-1/2" Lightweight Utility Grinder	10,000
BLACK & DECKER	2750/4247/6147	5/8-11 UNC	4-1/2" Angle Grinder	10,000
	4246-09	M10 X 1.50	4-1/2" Angle Grinder	10,000
	6247	M10 X 1.50	4" Angle Grinder	10,000
	4250-10/4252	5/8-11 UNC	5" Angle Grinder	10,000
BOSCH	3255/1377	M14 X 2.0	4-1/2" Mini Grinder	11,000
	1338	M14 X 2.0	5" Mini Grinder	11,000
	7351-103	M14 X 2.0	4-1/2" Air Mini Grinder	11,000
HITACHI	G10/G10SA	M10 X 1.50	4" Angle Grinder	11,000
	PDP-115A/PDS-115A	M10 X 1.50	4-1/2" Angle Grinder	11,000
	PDM-115	5/8-11 UNC	4-1/2" Angle Grinder	9,500
	PDM-125	5/8-11 UNC	5" Angle Grinder	9,500
INGERSOLL-RAND	8245	5/8-11 UNC	HD Angle Grinder	11,000
JET	490004	M10 X 1.25	JEG400	11,000
	490045	5/8-11 UNC	JEG450	11,500
	490005	5/8-11 UNC	JEG500	9,800
MAKITA	9501BKW	M10 X 1.25	4" Sander Grinder	10,000
	9503BHKIT	5/8-11 UNC	4-1/2" Angle Grinder	10,000
	M-952	M10 X 1.25	4" Angle Grinder	10,000
	9005B/GA5000	5/8-11 UNC	5" Angle Grinder	10,000
	9505BHKIT	5/8-11 UNC	5" Angle Grinder	10,000
METABO	AG550	M14 X 2.0	4-1/2" Angle Grinder	10,000
	AG705	M14 X 2.0	5" Angle Grinder	10,000
	EW-9150	M14 X 2.0	6" Angle Grinder	8,500
MILWAUKEE ELECTRIC TOOL	6145	1/2-13 UNC	4-1/2" Sander Grinder	10,000
	6146	1/2-13 UNC	5" Sander Grinder	10,000
PORTER CABLE	7645	5/8-11 UNC	5" Grinder	10,000
RYOBI	G-1150	5/8-11 UNC	4-1/2 Super Grinder	10,000
	SG-1000	3/8-16 UNC	4" Grinder	11,000
	G-1155-C	5/8-11 UNC	4-1/2" Grinder	11,000
	G-1255-C	5/8-11 UNC	5" Grinder	10,000
	SG-1150-C	5/8-11 UNC	4-1/2" Angle Grinder	11,000
SIOUX	1240	M10 X 1.50	4-1/2" HD Disc Grinder	11,000
	1245	5/8-11 UNC	5" Angle Grinder	10,000
SKIL	9405(915)	M10 X 1.50	4-1/2" HD Disc Grinder	12,500
	9611	5/8-11 UNC	4-1/2" Sander/Grinder	12,000



IBS, INCORPORATED

Wire Brushes P35

Crimped Wire Bench Wheels

- In these wheels, traditional individual crimped wires (monofilaments) are substituted by several wires making cable crimped wire.
- Highest quality heat treated steel wire.
- Perfect balance.
- Maximum wire fill provides faster cutting action and long life.
- Ground face for aggressive cutting action.
- For heavy-duty brushing: deburring, weld smoothing, rust and paint removal.
- All Wheels come with Multi-Fitting Arbor Hole Adapter



Hub Color Coding System allows many of our brushes to be easily identified. The symbol to the left will be shown throughout the catalog. **RED** are **CARBON STEEL**, **BLUE** are **STAINLESS STEEL**, and **GREEN** are made with solid **BRASS** wire. This color coding system helps reduce the chances of cross contamination, a common error in the industry.

IBS No.	Dia. in.	Wire Size	Arbor Hole	Trim Length	Face Width	Maximum Safe Free Speed RPM	Qty
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NARROW FACE WHEELS

50039	6	.008	1/2 - 2"	1-1/8"	3/4	6,500	1
50040	6	.012	1/2 - 2"	1-1/8"	3/4	6,500	1
50041	8	.012	1/2 - 2"	1-5/8"	3/4	4,500	1

Arbor Hole Features: Plastic Multi-Fitting Hole Adapter



MULTI-FITTING ARBOR HOLE ADAPTER
(fits up to 7 different sizes)

MEDIUM FACE WHEELS

50042	6	.012	1/2 - 2"	1-1/8"	1	6,500	1
50043	8	.012	1/2 - 2"	1-5/8"	1	4,500	1
50044	10	.012	1/2 - 2"	2-5/8"	1-1/8"	3,600	1

- 1/2", 5/8", 3/4", 7/8", 1", 1-3/16" & 2"
- Allows one brush to fit (7) seven different arbor sizes by knocking out the arbor hole bushings.
- Reduces inventory — no adapter needed.

Knot-Type Wire Wheel Brushes

- High impact action.
- Perfect balance.
- Individually spaced holes for the knots in the internal plate prevents knots from shifting on the brush.
- Removes rust, scale, and weld splatter.
- For heavy-duty brushing, such as weld cleaning, surface conditioning and roughing.



Standard Twist



Standard Twist



Beveled Twist

KNOT-TYPE WIRE WHEEL BRUSHES

IBS No.	Dia. in.	Wire Size	Arbor Hole	Trim Length	Face Width	Maximum Safe Free Speed RPM	Qty
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Standard Twist Wheels

50045	3	.015	3/8 - 1/2	5/8	3/8	20,000	1
50046	4	.015	3/8 - 1/2	3/4	1/2	20,000	1
50047	6	.015	1/2 - 5/8	1-3/8	1/2	12,500	1

Beveled Twist Wheels

50048	4	.020	5/8 - 11	7/8	NA	15,000	1
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Knot-Type Wire Wheel Brushes

STRINGER BEAD TWIST



Technical Information:

- The twisted wire gives these models:
 - Long working life.
 - High removal capacity
 - Ability to work at high speeds

- Very narrow face** for weld cleaning.
- High tensile, heat-treated steel wire** for max. fatigue resistance, long life, and aggressive cutting action.
- Perfect balance.
- For heavy-cleaning of weld splatter and slag, and removal of rust and scale.

IBS No.		Dia. in.	Wire Size	Arbor Hole	Trim Length	Face Width	Max Safe Free Speed	Qty
Steel	Stainless							
50049	50050	4	.020	5/8-11	3/4	3/16	20,000	1
50051	50052	4-1/2	.020	5/8-11	1-1/8	3/16	15,000	1

DUALLY Knot-Type Wire Wheel Brush (P25)

STRINGER BEAD TWIST



Featuring a new patent-pending design, the Dually Wire Wheel is the choice for the most demanding inter-pass welding applications such as pipeline construction boiler and pressure vessel fabrication and shipbuilding.

- Features a dual-hex nut design** that simplifies periodic flipping of the wheel for maximum cleaning action, long life and safer use.
- 13/16" Trim Length is shorter** than standard Stringer Bead Twist Wheels, offering maximum strength and cleaning action.

IBS No.	Dia. in.	Wire Size	Arbor Hole	Trim Length	Face Width	Max Safe Free Speed	Qty
Steel							
79801	4-1/2	.020	5/8-11	13/16	3/16	20,000	1

Wire Cup Brushes

- For heavy-duty cleaning of large areas.
- Perfect balance.
- Excellent for deburring, roughening, removal of weld, scale, paint, rust and corrosion.

Technical Information:

- The twisted wire gives these models:
 - Longer life
 - Higher removal capacity
 - Possibility to work at high speeds
- Designed for use in portable machines.
- Suitable for brushing over large areas with a higher removal capacity.



IBS No.		Dia. in.	Wire Size	Arbor Hole	Trim Length	Max Safe Free Speed	Qty
Steel	Stainless						

Knot Type

50053	50054	4	.020	5/8-11	1	8,500	1
50055		6	.020	5/8-11	1-3/8	6,000	1

Crimped Wire Type

50056		4	.009	5/8-11 & M14 X 2.0	1-3/16	8,500	1
50057		6	.020	5/8-11	1-1/8	6,000	1



IBS, INCORPORATED

Wire Brushes P25 & P35

Small Angle Grinder Brushes

- Perfect for use with many styles of small angle grinders now on the market.
- For smaller, hard-to-reach locations that need deburring, roughening, cleaning, conditioning, etc.



STEEL
STAINLESS
BRASS

IBS No.		Dia. in.	Wire Size	Arbor Hole	Trim Length	Max Safe Free Speed	Qty
Steel	Stainless						

Knot Type

50058	50059	2-3/4	.020	5/8-11	3/4	15,000	1
50060		3-1/2	.020	5/8-11	7/8	15,000	1

Cable Crimped Wire Type

50061		3	.009	5/8-11	7/8	13,000	1
50062	50063	3-1/2	.012	5/8-11	1-3/16	13,000	1

WIRE WHEEL ADAPTERS - METRIC (P25)



IBS No.	Fixed Thread Size	Adapted Thread Size	Qty
07771	5/8-11 UNC	M10 x 1.25	1
07772	5/8-11 UNC	M10 x 1.50	1

Crimped Cup Wire Brush with Protective Guard

- Cup brush featuring a protective guard for **PROTECTION & VISIBILITY**.
- The guard acts as a shield that prevents wire, dust and any other kind of projections from reaching the user during work.
- The guard is still flexible enough to make it suitable for work not only on open surfaces but also on difficult areas.
- The guard is made of a transparent material that allows the user to see the working area.
- The guard also provides easier handling of the brush, protecting end users against potential pricking caused by the wire.



STEEL
STAINLESS
BRASS

IBS No.	Dia. (in.)	Wire Size	Arbor Hole	Trim Length	MAX Safe (Free Speed)	Qty
50024	3"	.009	5/8-11	7/8"	13,000	1



Laminated Wire Brushes & Wheels

- Laminated wire wheels and brushes have a longer life and are easy and comfortable to use.
- The coating protects the wires and prevents them from being damaged. Less wire fractures and breakage provides higher performance and longer life compared to an equivalent uncoated wire.
- Laminated wire is easier, more comfortable, and safer for handling — avoiding and pricking and injury to the user.



Crimped Cup



Knot Wire Cup



Knot Wire Wheel

IBS No.	Diam.	Wire Size	Trim Length	Arbor Hole	Wire Type	Style	RPM Max	Qty
50025	3"	.012	7/8"	5/8-11	Crimped	Cup	15,000	1
50026	2-3/4"	.020	3/4"	5/8-11	Knotted	Cup	15,000	1
50027	4-1/2"	.020	1"	5/8-11	Knotted	Wheel	15,000	1

STEEL
STAINLESS
BRASS

Stem Thread Cleaning Brushes Coated Steel

- **Specially designed** internal brushes for **ROTATING PARTS**.
- **Brushes come in a variety of diameters** for various thread sizes.
- **Brushes have a 1/4" stem to be easily mounted in a drill motor or die grinder** — no need to remove the piece for brushing and cleaning. This means faster clean up of rotating parts, saving users time and money.
- **APPLICATIONS:** Removal of burrs, paint, etc., ideal for maintenance work.



IBS No.	Diam.	Wire Size	Shank Diam.	Wire Type	RPM Max	Qty
50031	3/8"	.012	1/4"	Coated Steel	4,500	1
50032	1/2"					1
50033	5/8"					1
50034	3/4"					1
50095	7/8"					1

STEEL
STAINLESS
BRASS

Stem Thread Cleaning Brushes Assortment (Z02)

IBS No. 839R • 5 ITEMS • 5 PCS
Packaged in a Locking Steel Drawer for
easy storage & organization



IBS, Inc.					Stem Thread Brushes
Assortment No. 839R					
50031 3/8" .012 1/4 STEM THREAD BRUSH COATED STEEL	50032 1/2" .012 1/4 STEM THREAD BRUSH COATED STEEL	50033 5/8" .012 1/4 STEM THREAD BRUSH COATED STEEL	50034 3/4" .012 1/4 STEM THREAD BRUSH COATED STEEL	50095 7/8" .012 1/4 STEM THREAD BRUSH COATED STEEL	



IBS, INCORPORATED

Wire Brushes P35

Control Brushes for Fine Finishing

- **Control Brushes incorporate a rigid degradable material which holds the wire**, preventing its opening to provide much better control of the brushing surface and a higher level of ergonomics over the work.
- **Control Brushes avoid wire breakage**, which means outstanding safety improvement and excellent performance improvement because with less breakage there is less debris flying and the wires and brushes last longer, saving time and money.
- They also **provide for safer handling of the brush**, protecting end users against potential pricking caused by the wire.
- Applications include:

Removal of rust, paint, welding scale, edges, etc.;

Specifically designed for fine finishing

Surface processing in metal, wood, rubber, etc.



STEEL
STAINLESS
BRASS



IBS No.	Wire	Brush	Diam.	Wire Size	Arbor Hole	Trim Length	RPM		Qty
							rec	MAX	
50035	Knotted	Heavy Removal	5"	.032	5/8-11	1-3/16"	6,000	6,500	1
50036	Knotted	Heavy Removal	3-1/4"	.032	5/8-11		6,000	8,500	1
50037	Crimped	Light Removal	5"	.020	5/8-11		6,000	6,500	1
50038	Crimped	Light Removal	3-1/4"	.020	5/8-11		6,000	8,500	1

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Wire Brushes P35

Stem Mounted Brushes

- Shape and dimensions for use in difficult places to access holes, corners, etc.
- Mounted on a 1/4" stem on portable or fixed drills with chuck.
- For deburring, weld cleaning, slag removal, rust and paint removal.



IBS No.		Dia. in.	Wire Size	Trim Length	Maximum Safe Free Speed RPM	Qty
Steel	Stainless					

Circular Flared

50064		1-1/2	.008	n/a	20,000	1
50065		1-1/2	.020	n/a	20,000	1
50066		3	.008	n/a	20,000	1

Conflex 1/2" Face

50067		1-1/2	.012	3/8	20,000	1
50068		3	.008	5/8	15000	1
50069	50070	3	.012	5/8	15,000	1

Crimped Wire Cup

04300		1-3/4	.006	3/4	13,000	1
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Knot Type End Brush

50071		3/4	.015	7/8	20,000	1
50094		1	.015	7/8	20,000	1
50072		1-1/4	.020	7/8	20,000	1

Knot Type End Brush - Banded

11141		1-1/8	.020	3/8	18,000	1
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Knot Type Wire Wheel

50073		3-1/4"	.014	5/8	20,000	1
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Solid End Brush

50074	50075	1/2	.006	3/4	20,000	1
50076		1/2	.015	3/4	20,000	1
50077		3/4	.020	1	20,000	1
50078		1	.020	1-3/16	20,000	1
	50079	1	.012	1-3/16	20,000	1

Stem Mounted Wire Brushes Assortment (Z02)

IBS No. 702R • 8 ITEMS • 8 PCS
Packaged in a Locking Steel Drawer for easy storage & organization



IBS, Inc. SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR INDUSTRIALDRILL.COM © © © 800-675-1206				Stem Mounted Wire Brushes 1/4" Shank	
				Assortment No. 702R	
50074 1/2 .006 SOLID END BRUSH 1/4 SHANK 7/8 TRIM STEEL	50078 1 .020 SOLID END BRUSH 1/4 SHANK 1-1/8 TRIM STEEL	50066 3 .008 CIRCULAR FLARED END 1 SHANK CIRC CRIMP STEEL	50067 1-1/2 .0118 CONFLUX WIRE WHEEL 1/4" SHANK		
50077 3/4 .020 SOLID END BRUSH 1/4 SHANK 7/8 TRIM STEEL	50065 1-1/2 FLARED END BRUSH 1/4 SHANK CIRC CRIMP STEEL	04300 1-3/4 .006 WIRE CUP BRUSH 1/4 SHANK CRIMP 3/4 TRIM STEEL	50069 3 .0118 CONFLUX WIRE WHEEL 1/4 SHANK		



IBS, INCORPORATED

Wire Brushes P25

Polyflex® Encapsulated Brushes

ENCAPSULATED WITH A SPECIALLY FORMULATED ELASTOMER

Features & Benefits of the Elastomer

The brush wires are molded into a specially formulated elastomer — providing a controlled brushing face for very aggressive cutting action. As the elastomer wears away, new tips are continually exposed and keep a perpetual short trim for a very long brush life and fewer change-overs.

Constructed for perfect balance — No vibration during use allows for lower equipment maintenance and consistent performance.

Made with "HT" heat-treated carbon steel wire — Provides greater tensile strength again allowing for fewer change-overs. Fatigue resistant to provide a longer brush life and is 100% recyclable.

COLOR CODED ELASTOMERS

BURGUNDY

Standard

Wears away easily and is suitable for most manufacturing applications.

ORANGE

Heavy Duty

Somewhat harder than the burgundy. It is used for more demanding applications found in heavy steel fabrications and for demanding deburring applications

APPLICATIONS

Heavy burr removal in slots and narrow confined areas.

Surface refinement and juncture blending.

Rubber and plastic flash removal.

Heavy duty cleaning.

Polyflex® Encapsulated Brushes - Conflex Brushes

MOUNTED ON 1/4" STEMS BURGUNDY ELASTOMER

ENCAPSULATED CONFLEX BRUSHES

IBS No.	Dia. in.	Wire Size	Trim Length	Face Width	Maximum Safe Free Speed RPM	Qty
35305	2	.0118	1/2	1/4	20,000	1
35315	3	.0118	1	1/4	20,000	1



End Brushes

Mounted on 1/4 stems - Hollow Center with Orange Elastomer

ENCAPSULATED END BRUSHES

IBS No.	Dia. in.	Wire Size	Trim Length	Maximum Safe Free Speed RPM	Qty
35535	1/2	.0104	7/8	18,000	1
35545	1	.0104	7/8	18,000	1



Nylon Abrasive Brushes

Abrasive nylon wheel brushes offer superior **safety** and **flexibility** over wire wheels, providing a gentler, more consistent finish without shedding broken wires or creating rust-inducing contaminants. They are ideal for light-duty stripping, deburring, and cleaning delicate materials like wood, aluminum, and plastics, as they do not scratch or gouge surfaces like wire wheels can.

- **Safe & Long Lasting:** Unlike wire wheels that throw sharp wire fragments, nylon bristles are **less likely to break**, and they do not create dangerous debris lasting up to **10 times longer**.
- **Surface Protection:** Nylon brushes remove coatings (paint, rust) without altering the underlying material, avoiding deep scratches to protect critical part dimensions.
- **No Contamination:** Nylon bristles mean no risk of rust or contamination and assuring clean finishes.
- **Conformability:** The flexible bristles **conform** to complex shapes and contours better than stiff wire, offering a more **uniform finish** without gouging the base material that also improves **operator control** and reduces fatigue.
- **Non-Loading: Flexible open-web construction** resists loading and buildup to deliver consistent, cool cutting and longer wheel life.
- **Non-Sparking & Versatile:** Means wheels can be safely used on a wide range of materials, including wood, plastic, and metal.
- **Uniform abrasive distribution:** Wheels maintain **consistent performance** and predictable surface finishes throughout the wheel life.
- **Multiple grits available:** Covers a wide range of cleaning, blending, and finishing applications.
- Optimum performance at the recommended working speed 2,500 R.P.M. - MAX RPM=4,500

Wheel



Size	80 Grit	150 Grit	Qty
3"	96660	96670	10
4"	96760	96770	10

Cup Brush



Size	80 Grit	150 Grit	Qty
2"	97460	97470	10
3"	97660	97670	10

End Brush



Size	80 Grit	150 Grit	Qty
1"	94160	94170	10



Nylon Abrasive Wheels Assortment (Z02)

IBS No. 866R • 10 ITEMS • 10 PCS
Packaged in a Locking Steel Drawer for easy storage & organization



IBS, Inc. SPECIALTY PRODUCTS FIRST MAINTENANCE & REPAIR INDUSTRIALBELT.COM • P.O. BOX 870-1000				Nylon Abrasive Wheels Assortment No. 866R	
94160 1" NYLON ABRASIVE END BRUSH 80G COARSE - MAX RPM=4,500	94170 1" NYLON ABRASIVE END BRUSH 150G MEDIUM - MAX RPM=4,500	96660 3" NYLON ABRASIVE WHEEL 80G COARSE - MAX RPM=4,500	96670 3" NYLON ABRASIVE WHEEL 150G MEDIUM - MAX RPM=4,500		
97460 2" NYLON ABRASIVE CUP BRUSH 80G COARSE - MAX RPM=4,500	97470 2" NYLON ABRASIVE CUP BRUSH 150G MEDIUM - MAX RPM=4,500				
97660 3" NYLON ABRASIVE CUP BRUSH 80G COARSE - MAX RPM=4,500	97670 3" NYLON ABRASIVE CUP BRUSH 150G MEDIUM - MAX RPM=4,500	96760 4" NYLON ABRASIVE WHEEL 80G COARSE - MAX RPM=4,500	96770 4" NYLON ABRASIVE WHEEL 150G MEDIUM - MAX RPM=4,500		



IBS, INCORPORATED

Wire Brushes P35

Power Tube Brushes

Also known as internal brushes, power tube brushes provide fast, efficient cleaning and finishing of hard-to-reach surfaces and other difficult-to-access areas.



IBS No.	Dia.	Wire Size	Brush Length	Stem Dia.	Overall Length	Qty
Steel						

Double Stem, Double Spiral

50080	3/8	.006	1-1/2	1/8	6	1
50081	1/2	.006	2	5/32	5	1
50082	5/8	.005	2	7/32	5	1
50083	3/4	.006	2-1/2	1/4	5-1/2	1
50084	1	.006	2-1/2	1/4	5-1/2	1
50085	1-1/4	.0104	2-1/2	1/4	5-1/2	1

Use with power tools for heavy duty cleaning and deburring

Plastic Handle Scratch Brushes

- A tighter, longer and narrower hand scratch brush for **LONG LIFE AND MAXIMUM REMOVAL**.
- The high wire density provides higher brushing pressure which means a stronger and stiffer hand brush for maximum removal capacity.
- This special design has a narrower face to allow easy access into slots as small as 1/4"



IBS No.	Total Length	Usable Length	Face Width	Trim Length	Fill Material	Qty
50028	10"	5"	5/8"	1-1/8"	Coated Steel (.014")	1
50029					Stainless Steel (.012")	1
50030					Brass (.012")	1

Power Tube Brushes Assortment (Z02)

IBS No. 704R • 6 ITEMS • 6 PIECES

PACKAGED IN A CLEAR PLASTIC BOX



Power Tube Brushes Assortment (Z02)

IBS No. 816R • 6 ITEMS • 6 PIECES

PACKAGED IN A LOCKING STEEL DRAWER



ABRASIVES

Hand Wire Scratch Brushes

- For removing rust, scale, paint, solder etc.
- Use to clean threads, files, metal parts and castings



CURVED HANDLE WIRE SCRATCH BRUSH

IBS No.	# of Rows	Block Size	Wire Size	Trim Length	Fill Material	Qty
50086	3 x 19	14 x 7/8	.012	1-3/16	Standard Wire	12
50087	3 x 19	14 x 7/8	.012	1-3/16	Stainless	12

SHOE HANDLE WIRE SCRATCH BRUSH

IBS No.	# of Rows	Block Size	Wire Size	Trim Length	Fill Material	Qty
50088	4 x 16	10 x 1-1/8	.012	1-3/16	Standard Wire	12
50089	4 x 16	10 x 1-1/8	.012	1-3/16	Stainless	12
50090	4 x 16	10 x 1-1/8	.012	1"	Brass Wire	12

SMALL WIRE SCRATCH BRUSH

IBS No.	# of Rows	Block Size	Wire Size	Trim Length	Fill Material	Qty
50091	3 x 7	7-1/2 x 1/2	.006	1/2	Stainless	12
50092	3 x 7	7-1/2 x 1/2	.006	1/2	Brass	12
50093	3 x 7	7-1/2 x 1/2	.012	1/2	Nylon	12

Hand Wire Scratch Brushes Assortment (Z02)

IBS No. 703R • 9 ITEMS • 45 PIECES



IBS, Inc.
SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR
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Scratch Brushes

Assortment No. 703R

50028 10IN .014 RED HAND WIRE BRUSH COATED STEEL 	
50029 10IN .012 BLUE HAND WIRE BRUSH STAINLESS STEEL 	
50030 10IN .012 GRN HAND WIRE BRUSH BRASS 	
50091 3 X 7 SS SMALL SCRATCH BRUSH  	50092 3 X 7 BRASS SMALL SCRATCH BUSH  
50093 3 X 7 NYLON SMALL SCRATCH BRUSH  	44088 5/16 ACID BRUSH  
44089 3/8 ACID BRUSH  	44090 1/2 ACID BRUSH  



IBS, INCORPORATED

Mounted Points P29

Mounted Points ALUMINUM OXIDE • VITRIFIED

BONDED

These mounted points are versatile with a holding edge and stable form. They are ideal for use on carbon and heat-treated steel and cast steels. They are typically used in structured steel fabrications and die making foundries. All sizes feature a 1/4" shank.

IBS No.	Shape	Shape No.	Dimensions Dia. x Length	RPM	Grain Size	Qty
31001		A1	3/4 x 2-1/2	17,000	30	1
31011		A2	1 x 1-1/4	28,000	30	1
31021		A3	1 x 2-3/4	13,000	30	1
31031		A4	1-1/4 x 1-1/4	20,000	30	1
31061		A11	7/8 x 2	19,000	30	1
31071		A12	11/16 x 1-1/4	34,000	30	1
31104		A15	1/4 x 1-1/16	81,000	60	1
31111		A21	1 x 1	34,000	30	1
31144		A24	1/4 x 3/4	93,000	60	1
31161		A26	5/8 x 5/8	53,000	30	1
31201		A34	1-1/2 x 5/8	22,000	30	1
31234		A37	1-1/4 x 1/4	26,000	60	1



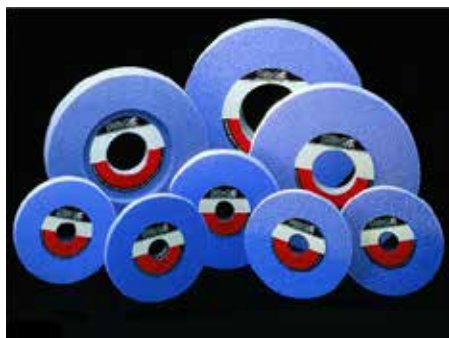
IBS No.	Shape No.	Dimensions	RPM	Grain Size	Qty
33710	W188	1/2 x 1-1/2	40,000	46	1
33725	W189	1/2 x 2	24,000	60	1
33812	W195	5/8 x 3/4	53,000	30	1
33968	W205	3/4 X 1	34,500	60	1
33992	W207	3/4 X 1-1/2	24,000	30	1
34187	W220	1 x 1	25,500	30	1
34217	W222	1 x 2	15,900	30	1
34352	W231	1-1/4 x 1-1/2	17,620	30	1
34457	W238	1-1/2 x 1-1/2	15,600	60	1
34517	W242	2 x 1	17,000	30	1

Stem-Mounted Extensions 6" & 12" (P29)

- **Available in 6" or 12" lengths** — for multiple applications to access hard to reach areas.
- **Quick Change Hex Shank** — allows for use in quick change chucks or in standard chucks giving a positive grip for safety and speed.
- **Double Set Screw** — holds the tool firmly in place ensuring no slippage or tool failure and provides added safety.
- **Forged of the finest quality tool steel** — for durability and long life.
- **Allen wrenches included.**



IBS No.	Description	Qty
139272	6" Stem Mounted Extension	1
139273	12" Stem Mounted Extension	1



Premium Blue Aluminum Oxide Bench Grinding Wheels

HIGH SPEED STEEL APPLICATIONS

- Offers a friable grain and a cooler bond. Excellent on materials 55C and above, but can be used on general purpose tool steel.
- The bond allows free cutting action while pulling heat away from the part and into the matrix of the wheel.
- Recommended for grinding aluminum and stainless steels, as well as very hard steels.

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for GRINDING &
DEBURRING

Guide to Grit Sizes Aluminum Oxide

24 - 30 Rough
36 - 46 Gen Purpose Work
60 - 80 Finish Grinding

PREMIUM BLUE ALUMINUM OXIDE

Dimensions Dia. x Th. x Arb	Fine 120G	Medium 60G	Coarse 36G	MAX RPM
6 x 3/4 x 1	38116	38113	38111	4456
6 x 1 x 1	38126	38123	38121	4456
8 x 1 x 1	38206	38203	38201	3600

Bench Grinding Wheels Aluminum Oxide

GENERAL PURPOSE GRINDING AND FINISHING

- Wheels are individually precision balanced, trued and faced for smooth operation. All wheels are speed tested.
- All wheels come complete with nested bushings. Check the chart below for bushing size.
- Typical usage includes hand tool sharpening, minor deburring and touching up.



BENCH GRINDING WHEELS

Dimensions Dia. x Th. x Arb	Fine	Medium	Coarse	MAX RPM
6 x 3/4 x 1	69451	69450		4138
6 x 1 x 1	69455	69454	69453	4138
8 x 1 x 1-1/4	69463	69462	69461	3600
10 x 1 x 1-1/4	69467	69466	69465	2483

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DEBURRING

BUSHING GUIDE

Wheel		Bushing				
Dia.	Hole	1/2	5/8	3/4	1	1-1/4
6"	1"	X	X	X		
7"	1"	X	X	X		
8"	1-1/4"		X	X	X	
10"	1-1/4"			X	X	
12"	1-1/2"				X	X
14"	1-1/2"				X	X



IBS, INCORPORATED

Grinding Wheels P37

Flared Grinding Cupstones

HIGH PERFORMANCE TYPE 11

Designed with a large grinding surface, combined with a thick layer of rough abrasive, these cupstones remove more material than other wheels. Flared Grinding Cupstones are for use on right angle grinders for smoothing weld seams, cleaning castings and preparing surfaces for plating or painting.

- **Made with aluminum oxide grain** - ideal for rough grinding, snagging work and cleaning castings on metal, steel & stainless steel surfaces.
- **Larger grinding surface contact** than standard grinding wheels removes more material and last longer than standard grinding wheels.
- Applications: Weld grinding, surface grinding, edge grinding.

IBS No.	Diameter 1	Thickness	Diameter 2	Wall Thickness	Arbor	MAX RPM	Pkg
38130	4"	2"	3-1/2"	1"	5/8-11	9,072	1
38131	5"	2"	3-3/4"	1-1/2"	5/8-11	7,258	1
38132	6"	2"	4-3/4"	1-1/2"	5/8-11	6,084	1

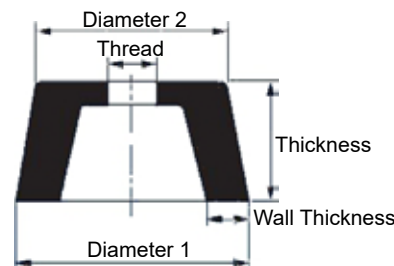


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FOR METAL &
STAINLESS
A16QB



Grinding Cones

HIGH PERFORMANCE TYPE 18 & 18R

Used for grinding and finishing metals in hard to reach areas, these abrasive cones remove heavy amounts of material. Aluminum oxide grains in combination with a strong bond deliver long product life and a consistent cut-rate when grinding metal. They have a 5/8-11 threaded insert that attaches to the spindle on a grinder.

- **Made with aluminum oxide grain** for fast stock removal - ideal for grinding and snagging in hard to reach places.
- **Dual grit compound bonded to wheel's outer edge** maintains effective flat grinding edge.
- **Ideal shapes** for use in corners and inside castings.
- For use on straight grinders.
- Perform best at recommended peripheral speed of 6,900 - 9,800 SFPM.



TYPE 18
Cone Cylinder



TYPE 18R
Cone Cylinder
Radius End

Use on
ANGLE & STRAIGHT
GRINDERS



FOR METAL &
STAINLESS
A24RB

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Type 18	Type 18R	Diam	Length	Arbor	MAX RPM	Pkg
38133	38134	1-1/2"	2-1/2"	5/8-11	24,191	10
38135	38136	2"	3"	5/8-11	18,100	10



DANGER

Do Not Use Grinding Wheels Unless You Follow These Rules
Damaged or Improperly Used Wheels Can Cause Serious Injury

Do Not Overspeed Wheel

DO's

1. **DO ALWAYS HANDLE AND STORE** wheels in a careful manner.
2. **DO VISUALLY INSPECT** all wheels before mounting, for possible damage in transit.
3. **DO CHECK MAXIMUM OPERATING SPEED** established for wheel against machine speed.
4. **DO CHECK MOUNTING FLANGES** for equal and correct diameter. (Should be at least 1/3 diameter of the wheel. Relieved around hole for type 1 only).
5. **DO USE MOUNTING BLOTTERS** supplied with wheels.
6. **DO BE SURE WORK REST** is properly adjusted. (Center of wheel or above: no more than 1/8" away from wheel).
7. **DO ALWAYS USE A GUARD** covering at least one half of the grinding wheel.
8. **DO ALLOW NEWLY MOUNTED WHEELS** to run at operating speed, with guard in place for at least one minute before grinding.
9. **DO ALWAYS WEAR SAFETY GLASSES** or some type of eye protection when grinding.
10. **DO TURN OFF COOLANT** before stopping wheel to avoid creating an out-of-balance condition.

DON'TS

1. **DON'T** use a wheel that **HAS BEEN DROPPED**.
2. **DON'T FORCE** a wheel on to the machine **OR ALTER** the size of the mounting hole — if the wheel won't fit the machine, get one that will.
3. **DON'T EVER EXCEED MAXIMUM OPERATING SPEED** established for the wheel.
4. **DON'T** use mounting flanges on which the bearing surfaces **ARE NOT CLEAN AND FLAT**.
5. **DON'T TIGHTEN** the mounting nut **EXCESSIVELY**.
6. **DON'T grind on the SIDE OF THE WHEEL** unless wheel is specifically designed for that purpose.
7. **DON'T start the machine UNTIL THE WHEEL GUARD IS IN PLACE**.
8. **DON'T JAM** work into the wheel.
9. **DON'T STAND DIRECTLY IN FRONT** of a grinding wheel whenever a grinder is started.
10. **DON'T grind material for which the WHEEL IS NOT DESIGNED**.

This page is designed as a guide for the individual user of grinding wheels whether he be in the employ of a large corporation or in the confines of his home work shop. It is based on the premise that the grinding is a safe operation when a few basic rules are followed. These rules are based on material contained in the American Standards Association Safety Code B7.1 — "Use, Care Protection of Abrasive Wheels." FOLLOW THEM



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Abrasives, Bench Rolls, Files P26

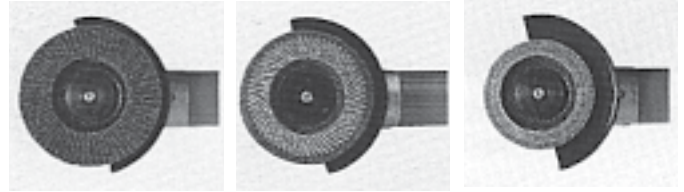
Applications

- Rough and medium grinding of welded seams in one grinding operation.
- Rust removal
- Deburring
- Working of fillet welds
- Edge grinding
- Snagging
- Surface grinding

Grit Recommendations

Grit Size	Materials
36	For aggressive grinding and weld removal.
60	For alloyed and low-alloyed steels, stainless steels of low tensile strength.
80	High-alloyed, stainless, high temperature heat-treatable steels, and high tensile non-ferrous steels.
120	Recommended for a fine finish of metal surfaces.

A coarser grit offers the advantage of a high stock removal rate and service life. A finer grit should only be used if a compromise is necessary for surface finish vs. stock removal rate.



New Wheel The wheel grinds continuously as it wears A fully consumed POWER FLAP

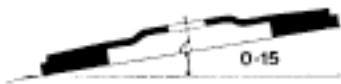
IBS Power Flap Discs have a unique feature in that their glass fiber backing and abrasive material wear simultaneously during the grinding operations. Therefore, the grinding efficiency is not impaired and the backing disc does not damage the surface of the work piece.

Quality and performance differences are not visible during short performance tests. The excellent performance features of the Power Flaps' extremely long service life and consistent high stock removal rate are only evident after long use and only after the flap disc has been consumed.

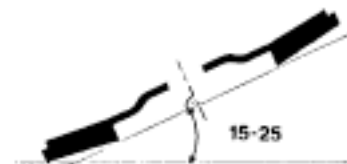
Optimum Results Using Flat and Conical Wheels

The choice between using a flat or conical wheel depends on the type of application:

The Flat IBS Power Flap wheel reaches its optimum efficiency at an angle of application between 0° - 15° .



The Conical IBS Power Flap wheel offers advantages when grinding with steeper angles of 15° - 25° .



Points to note for good surface finish:

If a lower grinding angle is possible, the flat Power Flap wheel achieves better surface finish than the conical type with the same grit size.

When grinding stainless and high temperature steels these angles can be slightly exceeded if necessary.

CLEAR-CUT Zirconium Power Flaps



THREE UNIQUE RECESSES

Provide an unobstructed view of the work piece and controlled material removal.



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CLEAR-CUT Zirconium Power Flaps

represent a truly unique concept in grinding technology — featuring a transparent operation. This allows the user to monitor the results without having to put the machine down. This makes stock removal and finishing easier to control — reducing costly processing errors.

- **3 Unique Cutouts/Recesses** give the user a free view of the work piece during operation to monitor the progress and give a better finish in less time.
- **The cutouts also provide cool grinding** prevents disc loading that results in longer disc life and change outs to reduce labor costs.
- **Cooler grinding** also prevents marring and discoloration of the work surfaces for an optimum finish.
- **Zirconium Grain** for high stock removal, faster grinding and longer life than aluminum oxide abrasives
- **Perfectly engineered and balanced flaps** for low vibration and noise means less user fatigue.

USE ON

- Rust & Acid proof steels
- High tensile sheets
- Structured steel
- Wood, varnish, filler
- GFK
- Hardox
- Tool Steel
- Non-ferrous Metals
- Plastics

APPLICATIONS

- Galvanized Parts
- Welding Seams
- Leveling
- Cleaning
- Surface grinding
- Flat Iron
- Bur removal
- Rust removal
- Edge grinding

IBS No.	Size	Grit	Qty
46640	4-1/2 x 7/8 Clear-Cut Zirc Disc	40	10
46680	4-1/2 x 7/8 Clear-Cut Zirc Disc	80	10



IBS, INCORPORATED

Abrasives, Bench Rolls, Files P26

CURVE Ceramic Power Flaps



CURVE Ceramic Power Flaps are the ultimate tool for grinding fillet welds on steel and stainless steel work pieces. Because the flaps are wrapped right around the disc periphery CURVE Ceramic Power Flaps provide an unequalled quick and highly abrasive grind, saving time and money. They provide long service life, and consistent, easy-to-use performance while grinding. Experience drastic reduction in time to grind your fillet welds, and improved finish results!

- **Ceramic abrasive grit** handles demanding grind jobs and achieves fine surface finishes.
- Capable of handling all grinding tasks usually reserved for conventional flap discs, the **CURVE will grind on the edge and the top of the disc**, eliminating the need to rotate the workpiece or grind upside-down.
- **Works faster than grinding wheels** without the risk of undercutting the workpiece.
- **Ceramic grit guarantees cool grinding** on poor heat-conducting materials — without thermal damage to the workpiece.
- **Leaves a smooth finish** allowing for easy visual inspection for defects, such as porosity and inclusions.
- **Applications include:** fillet weld grinding, chamfering and deburring.
- For use on stainless steel, steel and aluminum.
- **Available in 60 grit.**



Size	RPM	60 Grit
4-1/2 x 7/8	13,300	40560
4-1/2 x 5/8-11	13,300	41560

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STRONG Zirconia Flap Discs



STRONG Zirconia Flap Discs remove more material in less time than any other abrasive for angle grinders. These discs feature an extended flap length for continued aggressive grinding up to the last grain while the patented design provides maximum metal-removal and longest tool life of any flap disc.

APPLICATIONS:

- Ideal for the most demanding applications, including: grinding weld seams, edge grinding, chamfering and deburring.
- Choose zirconia grit 36 for coarse grinding work or zirconia grit 50 for edge work like chamfering and deburring.

ZIRCONIA OXIDE ABRASIVE



FEATURES:

- Provides the fastest possible stock removal rates versus any other flap disc, including hi-density and ceramic grain.
- Extremely long tool life.
- State-of-the-art high speed abrasive grain ensures maximum aggressiveness.
- Engineered to maintain consistent, aggressive removal through the entire disc life.
- Reduces labor costs by reducing grinding times.
- Fewer tool changes required which reduces downtime and saves money.
- **Available in 36 and 50 grit.**

Size	RPM	36 Grit	50 Grit
4-1/2 x 7/8	13,300	42536	42550
4-1/2 x 5/8-11	13,300	43536	43550



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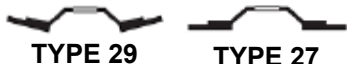
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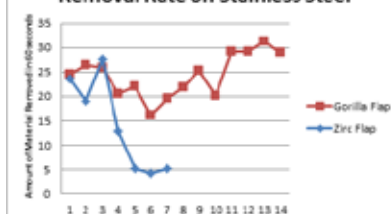
for GRINDING,
BLENDING &
FINISHING

IBS Gorilla Flap Ceramic Discs with Fiberglass Backing

- **High Performance Grinding Technology and Grain** results in **200% more stock removal** and **more than twice the life** than similar flap discs on hard materials, making this disc more effective, saving time and money.
- **Lower profile** allows this disc to fit under the safety guard for safer operation.
- The **advanced abrasive grain** makes it **50% more productive in stock removal rates** compared with reinforced grinding wheels — meaning less change outs saving time and money for the user.
- The **combination** of extremely high **stock removal + long service life + lower profile** means **REDUCED labor, inventory and injury**.



Removal Rate on Stainless Steel



As the chart shows, Zirconium Flap Discs begin to fail on harder materials such as stainless steel after only the 3rd use while the Gorilla Flap Ceramic Disc continues to perform long after the Zirconium disc wears out.

TYPE 29 - (Conical)

Size	RPM	60 Grit	36 Grit	Qty
4-1/2 x 5/8-11	13,300	46860	46836	10
4-1/2 x 7/8	13,300	46760	46736	10
5 x 5/8-11	12,200	56860	56836	10
5 x 7/8	12,200	56760	56736	10

TYPE 27- (Flat)

Size	RPM	60 Grit	36 Grit	Qty
4-1/2 x 5/8-11	13,300	46360	46336	10
4-1/2 x 7/8	13,300	46260	46236	10
5 x 5/8-11	12,200	56360	56336	10
5 x 7/8	12,200	56260	56236	10

IBS Zipper Ceramic/Zirconia Trimable Flap Discs



- **Constructed and manufactured in North America** with high quality, cloth abrasive material for superior quality and life.
- **Ceramic/Zirconia** alternating flap configuration provides cool cutting, high stock removal, long life and better finishes on stainless steel, titanium and all heat-treated steels.
- The **5/8-11 spin on threaded hub incorporated into the trimmable plastic backing results in a low profile design** that mounts securely under the grinder safety guard for added safety and user protection.



TYPE 27

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- **Plastic backing** is trimmable and also lighter weight than standard flap discs, making them easier to work with and better user ergonomics for more user comfort.
- **Trimmable backing** allows for more of the disc to be used for fewer disc changes and better production rates — lowering costs.

Size	RPM	120 Grit	80 Grit	60 Grit	36 Grit	Qty
4-1/2 x 7/8	13,300	36704	36703	36702	36701	10
4-1/2 x 5/8-11	13,300	36708	36707	36706	36705	10

IBS Edge Flap Discs

Our **uniquely designed flap discs** are designed with a small backing plate, which exposes more of each flap without the need to trim the backing plate, creating a disc that is more effective on inside edges, corners, and hard-to-reach spaces and can be used to grind and blend corner weld beads and around stainless tank fittings without the backing getting in the way.

- A **smaller backing plate design** allows for **easier and more effective grinding into corners** for a more flexible and versatile flap disc for better finishes, **saving users time and money.**
- **Ceramic grain with added grinding aid** provides the fastest stock removal on harder metals like stainless steel — reduces time & saves money!




TYPE 27

Size	RPM	80 Grit	60 Grit	40 Grit	Qty
4-1/2 x 7/8	13,300	42680	42660	42640	10
4-1/2 x 5/8-11	13,300	43680	43660	43640	10

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IBS, INCORPORATED

Abrasives, Bench Rolls, Files P26

THE TORNADO — Maximum Density Power Flap

Special zirconium composition abrasive for 45% more stock removal



- **Removes 45% more stock** than HD Power Flaps.
- **Superior performance to standard zirconium abrasives** for a more efficient and aggressive cut — reduces downtime.
- **Coolest running for minimal wear** means fewer wheel change outs.
- **Maximum Density** — more abrasive material than HD Power Flaps for maximum life.
- **Most Economical** — longest life and a comparable price means fewer wheel change outs reduced inventory and labor costs.



TYPE 29

Use on
ANGLE
GRINDERS

QUICK GUIDE
CLEANING
GRINDING
DEBURRING
BLENDING
FINISHING
POLISHING



for GRINDING,
BLENDING &
FINISHING

Size	RPM	80 Grit	60 Grit	40 Grit	Qty
4-1/2 x 7/8	13,300	46480	46460	46440	10
4-1/2 x 5/8-11	13,300	46580	46560	46540	10

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IBS High Density Power Flaps

- **High density design is 60% thicker** than standard flap disc products.
- **Extended life** - fewer wheel change outs and reduced costs.
- **Hi-Alloy abrasive composition yields consistent performance** new zirconium granules are continually exposed throughout the life of the product — eliminates rework and saves labor.
- **Faster cut & longer life than aluminum oxide abrasives** means fewer wheel change outs and reduced inventory costs.



TYPE 27



TYPE 29

Use on
ANGLE GRINDERS

QUICK GUIDE
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for GRINDING,
BLENDING &
FINISHING

IBS POWER FLAP DISCS

TYPE 27 — HIGH DENSITY

Size	RPM	120 Grit	80 Grit	60 Grit	40 Grit	Qty
4-1/2 x 7/8	13,300	—	40480	40460	40440	10
4-1/2 x 5/8-11	13,300	—	41480	41460	41440	10
7 x 5/8-11	8,600	—	41780	41760	41740	5

TYPE 29 — HIGH DENSITY

Size	RPM	120 Grit	80 Grit	60 Grit	40 Grit	Qty
4 x 5/8	13,300	—	47480		47440	10
4-1/2 x 7/8	13,300	—	42480	42460	42440	10
4-1/2 x 5/8-11	13,300	43499	43480	43460	43440	10
7 x 7/8	8,600	—	—		42740	5
7 x 5/8-11	8,600	—	—	43760	43740	5

IBS, INCORPORATED

Abrasives, Bench Rolls, Files P33



IBS SILVERBACK FLAP DISCS
with FIBERGLASS BACKING

TYPE 29 - (Conical)

Size	RPM	40G	60G	80G	120G	QTY
4-1/2 x 7/8	13,300	50008	50010	50012	50014	10
4-1/2 x 5/8-11	13,300	50009	50011	50013	50015	10



IBS SILVERBACK ROLOC FLAP DISCS

Size	RPM	40G	60G	80G	120G	QTY
2"	30,300	50016	50017	50018	50019	10
3"	19,100	50020	50021	50022	50023	10

IBS SilverBack Non-Loading Flap Discs

A Revolutionary Solution for
Grinding & Finishing
Aluminum and Soft Metals

- The open net structure of the SilverBack disc eliminates clogging and, therefore, lasts longer and cuts better than traditional flaps on softer materials such as aluminum and composites.
- The open net structure cuts cooler – minimizing the risk of overheating the sanded surface for a cleaner and smoother finish – reducing time and steps for finishing aluminum.
- Tough aluminum oxide grain bonded to the net material requires lower pressure and therefore reduces operator fatigue.
- The elimination of clogging and overheating means these discs last longer resulting in fewer discs needed to complete job – saving time and money.
- The combination of extremely high stock removal + long service life + lower profile means REDUCED labor, inventory and injury.

Silverback Non-Loading RoLoc Discs Assortment (Z02)

IBS No. 821R • 10 ITEMS • 22 PIECES

PACKAGED IN A LOCKING STEEL DRAWER

 IBS, Inc. SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR INDUSTRIALBOLT.COM ☎ 800-678-1906		SilverBack RoLoc Disc	
Assortment No. 821R			
50016 2IN 40G ROLOC SILVERBACK FLAP DISC  	50017 2IN 60G ROLOC SILVERBACK FLAP DISC  	50018 2IN 80G ROLOC SILVERBACK FLAP DISC  	50019 2IN 120G ROLOC SILVERBACK FLAP DISC  
50020 3IN 40G ROLOC SILVERBACK FLAP DISC  	50021 3IN 60G ROLOC SILVERBACK FLAP DISC  	50022 3IN 80G ROLOC SILVERBACK FLAP DISC  	50023 3IN 120G ROLOC SILVERBACK FLAP DISC  
06525 2IN ROLOC BACKING PAD  	06535 3IN ROLOC BACKING PAD  		

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IBS, INCORPORATED

Abrasives, Bench Rolls, Files P26

IBS Mini-Flaps

When it comes to labor-saving innovation, IBS leads the industrial marketplace once again with the IBS Mini Flap.

This premium Hi-Alloy product uniquely combines the power and versatility of Power Flap technology with the flexibility of Type 28 (conical) design in one durable disc. The IBS Mini Flap is the first of its kind and represents a significant advancement in grinding technology. These discs will grind and finish all in one operation like their Power Flap counterparts, with added flexibility for use in tough-to-grind corners and edges without gouging.

Features & Benefits

- Simultaneously grind & finish in one application
- Consistent aggression throughout disc life
- Grinds cool, reducing bluing and burning of work surface.
- Overlapping flap construction virtually eliminates edge wear.
- Coarser grits provide for rapid stock removal.
- Small diameters permit access to confined & hard to reach areas.
- Interrupted flap surface reduces glazing and loading



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POLISHING

2" & 3"
Use on Angle
AIR DIE GRINDERS



for GRINDING,
BLENDING &
FINISHING



Size	40 Grit	60 Grit	80 Grit	MAX RPM	Back Up Pad	Qty
2	65240	65260	65280	30,000	06525	10
3	65340	65360	65380	20,000	06535	10

Use IBS Back Up Pad No. 06530 3" 5/8-11 for Angle Grinders

3 x 5/8-11 for use with 4-1/2" Angle Grinder

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Ceramic Flex Flaps & Mini Flaps

- **Ceramic grain provides the fastest stock removal on harder metals like stainless steel and last longer** — making it a powerful alternative to zirconium and aluminum oxide — reduces time and saves money.
- **Flex Flap discs are ideal for blending and finishing on ferrous materials** where accessibility is a problem and the work area is curved or profiled —for better finishes saving users time and money.
- **Mini Flap Discs combine the power and versatility of a Power Flap disc in a compact design** for smaller areas for use with pneumatic die grinders — providing easier access in hard to reach areas.



CERAMIC ROLOC FLEX FLAPS

Size	80 Grit	60 Grit	40 Grit	MAX RPM	Qty
2"	67280	67260	67240	30,000	10
3"	67380	67360	67340	20,000	10



CERAMIC ROLOC MINI FLAPS

Size	80 Grit	60 Grit	40 Grit	MAX RPM	Qty
2"	64280	64260	64240	30,000	10
3"	64380	64360	64340	20,000	10

Ceramic Roloc Flex Flap & Mini Flap Discs (Z02)

IBS No. 841R • 14 ITEMS • 30 PIECES

PACKAGED IN A LOCKING STEEL DRAWER



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**Ceramic Roloc Flex Flap
and Mini Flap Discs**

Assortment No. 841R

67340 3IN 40GRIT CERAMIC FLEX FLAP ROLOC 	67360 3IN 60GRIT CERAMIC FLEX FLAP ROLOC 	67380 3IN 80GRIT CERAMIC FLEX FLAP ROLOC 	
64340 3IN 40GRIT CERAMIC MINI FLAP ROLOC 	64360 3IN 60GRIT CERAMIC MINI FLAP ROLOC 	64380 3IN 80GRIT CERAMIC MINI FLAP ROLOC 	
67240 2IN 40GRIT CERAMIC FLEX FLAP ROLOC 	67260 2IN 60GRIT CERAMIC FLEX FLAP ROLOC 	67280 2IN 80GRIT CERAMIC FLEX FLAP ROLOC 	06535 3IN ROLOC BACKING PAD 
64240 2IN 40GRIT CERAMIC MINI FLAP ROLOC 	64260 2IN 60GRIT CERAMIC MINI FLAP ROLOC 	64280 2IN 80GRIT CERAMIC MINI FLAP ROLOC 	06525 2IN ROLOC BACKING PAD 





IBS, INCORPORATED

Abrasives P26

Sanding Belts

A staple in many autobody and repair shops due to their effectiveness and versatility, these sanding belts are ideal for metalworking and light woodworking applications and are available in both Zirconia and Surface Conditioning materials.



ZIRCONIA+ SANDING BELTS

An ultra-tough, synthetic abrasive that provides a cool cut in high stock removal applications.

- **Micro-crystalline structure** allows for controlled breakdown and self-sharpening.
- **Tougher and sharper** than aluminum oxide.
- **Zirconia grain with added grinding aid** provides fast, cool cut and extended life in heavy duty grinding applications and harder metals like stainless steel - reduces time and saves money.
- **Ideal for fiberglass, rubber, plastics & mild steel** applications.



SURFACE CONDITIONING SANDING BELTS

Abrasive non-woven surface conditioning material used for sanding and finishing of all surfaces including wood and metal. Ideal for use in cleaning, finishing, blending and deburring applications.

- **Non-woven material** removes surface imperfections and grinding marks.
- **Use in place of coated sanding belts** — when a finer grit is needed.
- **Available in** coarse, medium and very fine

ZIRCONIA+ SANDING BELTS

Diameter	120 Grit	80 Grit	60 Grit	36 Grit	Pkg
1/2 x 18	35120	35080	35060	35036	10

SURFACE CONDITIONING SANDING BELTS

Diameter	Coarse	Medium	Very Fine	Pkg
1/2 x 18	35001	35002	35003	5

Sanding Belt Assortment (Z02)

IBS No. 848R • 7 ITEMS • 35 PIECES

PACKAGED IN A LOCKING STEEL DRAWER

**IBS, Inc.**
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Sanding Belts
1/2 x 18

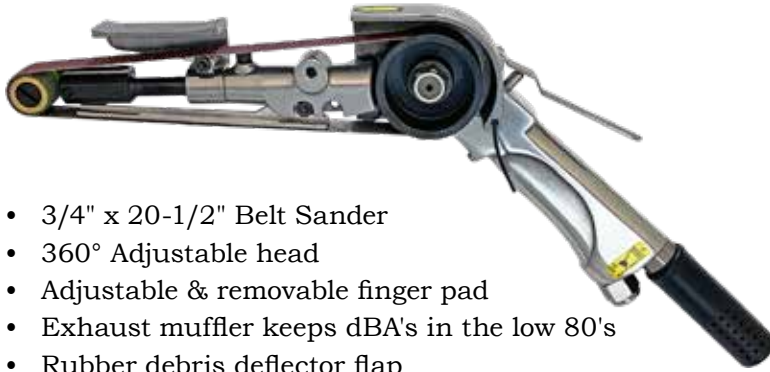
Assortment No. 848R

35036 1/2 X 18 36G ZIRC+ SANDING BELT	
35060 1/2 X 18 60G ZIRC+ SANDING BELT	
35080 1/2 X 18 80G ZIRC+ SANDING BELT	
35120 1/2 X 18 120G ZIRC+ SANDING BELT	
35001 1/2 X 18 SURFACE CONDITIONING MATERIAL SANDING BELT COARSE	
35002 1/2 X 18 SURFACE CONDITIONING MATERIAL SANDING BELT MEDIUM	
35003 1/2 X 18 SURFACE CONDITIONING MATERIAL SANDING BELT VERY FINE	



3/4" Pneumatic Belt Sander**IBS No. 69286**

Our Pneumatic Belt Sander is lightweight and built for heavy use. It features an adjustable head so you can always make your perfect preferable working angle. This belt sander can be used on steel, aluminum, wood, plastic, rubber, etc. and works very well in corners and on irregular shapes. We have belts available for our 3/4" X 20-1/2" belt sander in grits of 36, 40, 60, 80, and 120. Always remember to keep your air tools oiled before and after each use.



- 3/4" x 20-1/2" Belt Sander
- 360° Adjustable head
- Adjustable & removable finger pad
- Exhaust muffler keeps dBA's in the low 80's
- Rubber debris deflector flap
- 360° adjustable exhaust, also detachable
- Includes 2 sanding belts

SPECS:

Belt Size in. (mm):	3/4" x 20-1/2"
Horse Power HP:	0.45
Free Speed RPM:	16,000
MAX Length in/mm:	18.5" (470mm)
Hose Size in/mm:	3/8 (9.5mm)
Air Cons cfm /cmm:	7 (0.20cmm)
Noise Level dB (A):	80s
Weight lbs (kgs):	3.1 (1.4kgs)
Air Inlet (NPT):	1/4"



IBS, INCORPORATED

Abrasives P26

Flap Bands & Expanding Drums

A longer lasting, more productive alternative to flap wheels and spiral bands. Flap Bands provide aggressive stock removal in confined spaces and are excellent for grinding and finishing inside pipes and tubing.

- **Layered flaps are tightly packed** providing more productive aggressive stock removal than flap wheels.
- **Individual flaps wear back evenly, constantly exposing new sharp grains** which provides aggressive stock removal throughout the product life and reduces labor costs by removing material faster.
- **Flaps affixed to a firm fiber core** — giving greater durability than spiral bands.
- **No seams or splices to rip or tear** and surface imperfections which also protects and extends the life of the drum.

RUBBER EXPANDING DRUMS

Rubber drum remains in the tool collet for quick changeovers of bands.

To avoid slippage and for best performance, drums should be run at or near 75% of the max RPM for the Flap Bands (drill motors will not reach an adequate speed).

This keeps the drums expanded to hold the Flap Bands securely and keep them from slipping on the drum.



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QUICK GUIDE

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Use on
1/4" AIR DIE
GRINDERS



for GRINDING,
BLENDING &
FINISHING

Diameter	80 Grit	60 Grit	40 Grit	MAX RPM	Qty	Use Drum	Drum Shank
1-1/4 x 3/4	51025	51024	51022	26,000	1	50950	1/4
1-3/4 x 1-3/16	51165	51164	51162	19,100	1	50954	1/4
2-1/2 x 1-3/16	51265	51264	51262	12,700	1	50956	1/4
3-1/2 x 1-3/16	51445	51444	51442	7,600	1	50960	5/16

Flap Band Assortments (Z08)

IBS No. 734R • 10 ITEMS • 16 PCS (INCLUDES DIE GRINDER)

IBS No. 733R • 9 ITEMS • 15 PIECES

Packaged in a locking steel drawer for easy storage & organization.

IBS, Inc. SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR INDUSTRIALBOLT.COM • 800-678-1906			Flap Bands
Assortment No. 733R			
51022 1-1/4 X 3/4 FLAP BAND 40G	51162 1-3/4 X 1-3/16 FLAP BAND 40G	51262 2-1/2 X 1-3/16 FLAP BAND 40G	
51024 1-1/4 X 3/4 FLAP BAND 60G	51164 1-3/4 X 1-3/16 FLAP BAND 60G	51264 2-1/2 X 1-3/16 FLAP BAND 60G	
50950 1-1/4 X 3/4 FLAP BAND RUBBER EXPANDING DRUM	50954 1-3/4 X 1-3/16 FLAP BAND RUBBER EXPANDING DRUM	50956 2-1/2 X 1-3/16 FLAP BAND RUBBER EXPANDING DRUM	



Surface Conditioning Bands & Rubber Drums

Ideal for applying cosmetic grain finishes on Aluminum and Stainless Steel. Reduces surface roughness and uneven edges between adjoining surfaces. Conditions coated abrasive grind lines.

- **Versatile sizes** that can be used where belts cannot access.
- **Exhibits high finishing rate** while maintaining consistent finish which reduces finishing steps.
- **Unique shape** allows use on flat and contoured surfaces and hard-to-reach areas.
- **Constructed of resin-reinforced non-woven fiber** that resists loading and avoids under-cutting or gouging of the work piece.
- **Surface Conditioning Bands require** the use of Expanding Rubber Drums.
- **Ideal for deburring, cleaning, blending and finishing.**
- **Removes surface defects, rust, oxides, corrosion, paint and scale.**
- **Use on portable drills, die grinders, straight shaft and angle grinders.**



Expanding Rubber Drum

- Fabricated from rubber for controlled expansion and balance at high speeds.
- Band locks on non-slip drum.

Use on

1/4" AIR DIE GRINDERS



for **CLEANING, DEBURRING, BLENDING & FINISHING**

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Diameter	Coarse	Medium	Very Fine	MAX RPM	Qty	Use Drum
1/2 x 1/2	51029	51030	51031	30,000	1	51032
1 x 1	51034	51035	51036	18,000	1	51037
1-1/2 x 1	51039	51040	51041	10,000	1	51042

NOTE: The maximum allowable RPM for Surface Conditioning Bands is the same as the maximum RPM of the expanding rubber sanding drum used to drive the band, provided the drum and the band have the same nominal diameter. **CAUTION:** Protect yourself from product breakage and flying particles. Always wear eye and face protection, and make sure machine guards are in place. Comply with **ANSI B7.1**.

Surface Conditioning Bands Assortment (Z02)

IBS No. 774R • 12 ITEMS • 27 Pcs

Packaged in a locking steel drawer for easy storage & organization.

IBS, Inc. SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR INDUSTRIALSOLV.COM 800-678-1996			Surface Conditioning Bands
			Assortment No. 774R
51029 1/2 X 1/2 SURFACE CONDITIONING BAND COARSE 	51034 1 X 1 SURFACE CONDITIONING BAND COARSE 	51039 1-1/2 X 1 SURFACE CONDITIONING BAND COARSE 	
51030 1/2 X 1/2 SURFACE CONDITIONING BAND MEDIUM 	51035 1 X 1 SURFACE CONDITIONING BAND MEDIUM 	51040 1-1/2 X 1 SURFACE CONDITIONING BAND MEDIUM 	
51031 1/2 X 1/2 SURFACE CONDITIONING BAND VERY FINE 	51036 1 X 1 SURFACE CONDITIONING BAND VERY FINE 	51041 1-1/2 X 1 SURFACE CONDITIONING BAND VERY FINE 	
51032 1/2 X 1/2 SURFACE CONDITIONING BAND DRUM 	51037 1 X 1 SURFACE CONDITIONING BAND DRUM 	51042 1-1/2 X 1 SURFACE CONDITIONING BAND DRUM 	



IBS, INCORPORATED

Abrasives P30

Flap Wheels

Industrial Grade — Aluminum Oxide Mounted

- **Non-loading.** The flexibility provided by the coated abrasive flaps prevents loading which occurs with non-flexible grinding products.
- **Hugs concave or convex surfaces** allowing access to hard to reach areas such as small diameter tubing, channels, recessed areas, small openings, etc.
- **Mandrel mounted** on fixed 1/4" solid shank.
- **Full pack grit**, resin bonded segments.
- **Removes work marks** and surface imperfections.
- **Polishes** die work, spot welds, fiberglass molds.
- **Deburrs** stainless steel; blends and polishes.



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Use on
1/4" AIR DIE
GRINDERS



for GRINDING,
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Diameter	Shank	240 Grit	120 Grit	80 Grit	60 Grit	40 Grit	MAX RPM	Qty
3/4 x 3/4	1/4	65057	65056	65055	65054	65053	25,000	1
1 x 1	1/4	65028	65029	65025	65021	65023	25,000	1
1-1/2 x 1	1/4		65036	65034	65030	65032	25,000	1
2 x 1	1/4	65048	65044	65042	65038	65037	25,000	1
3 x 1	1/4		65052	65050	65046	65045	25,000	1

USE WITH STEM MOUNTED EXTENSIONS

IBS No.	Description	Qty
139272	6" Stem Mounted Extension	1
139273	12" Stem Mounted Extension	1

Flap Wheels Assortment (Z08)

IBS No. 398R • 20 ITEMS • 32 PCS PACKAGED IN A LOCKING STEEL DRAWER



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Flap Wheels

Assortment No. 398R				
65056 3/4 X 3/4 120G FLAP WHEEL 	65029 1 X 1 120G FLAP WHEEL 	65036 1-1/2 X 1 120G FLAP WHEEL 	65044 2 X 1 120G FLAP WHEEL 	65052 3 X 1 120G FLAP WHEEL 
65055 3/4 X 3/4 80G FLAP WHEEL 	65025 1 X 1 80G FLAP WHEEL 	65034 1-1/2 X 1 80G FLAP WHEEL 	65042 2 X 1 80G FLAP WHEEL 	65050 3 X 1 80G FLAP WHEEL 
65054 3/4 X 3/4 60G FLAP WHEEL 	65021 1 X 1 60G FLAP WHEEL 	65030 1-1/2 X 1 60G FLAP WHEEL 	65038 2 X 1 60G FLAP WHEEL 	65046 3 X 1 60G FLAP WHEEL 
65053 3/4 X 3/4 40G FLAP WHEEL 	65023 1 X 1 40G FLAP WHEEL 	65032 1-1/2 X 1 40G FLAP WHEEL 	65037 2 X 1 40G FLAP WHEEL 	65045 3 X 1 40G FLAP WHEEL 



Pressure Sensitive Adhesive (PSA) Premium Gold Abrasive Discs

PSA Premium Gold Abrasive Discs are used on portable disc sanders, ideal for sanding paint, primer, metal, wood, fiberglass, plastic and more.

- **Adhesive backed**, for convenient attaching to a backing pad, with quick replacement and ease of use saves users time and money.
- **Semi-open and load-resistant coating** provides an aggressive cutting action with minimal loading for longer life which means less change-outs, saving time and money.
- **Premium paper backing** is more durable than standard discs — resists tearing for added durability and value, saving time and money.
- **Packaged in roll form**, 100 per roll, for convenient use and easy dispensing.



Use on
ORBITAL SANDERS



for **CLEANING
& FINISHING**

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IBS No.	Size	Grit	Pkg Qty
40600	6" PSA Premium Gold Abrasive Discs	80G	100
40602		120G	100
40604		180G	100
40605		220G	100
40606		320G	100
40610	Backing Pad for PSA Premium Gold Abrasive Discs		1

SEMI-FLEX (P32) Silicon Carbide Discs

These discs combine the product advantages of various abrasives in one application.

- Engineered to be flexible, these discs adjust to the work surface and have a comfortable grinding behavior for excellent performance.
- Spiral design allows the disc to run cooler.
- Silicone Carbide grain prevents loading, increases production and is aggressive on rough surfaces.
- Applications include: Non-ferrous metals, Concrete, Marble, Fiberglass, Enamels and Porcelain



Use on
ANGLE GRINDERS



for **GRINDING,
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Silicon Carbide	36 Grit	16 Grit	RPM	Qty
4-1/2 x 7/8	46725	46724	12,000	10



IBS, INCORPORATED

Abrasives P26

GORILLA-GRIND Rough Grinding Discs

HIGH PERFORMANCE COATED ABRASIVES FOR STEEL & STAINLESS STEEL

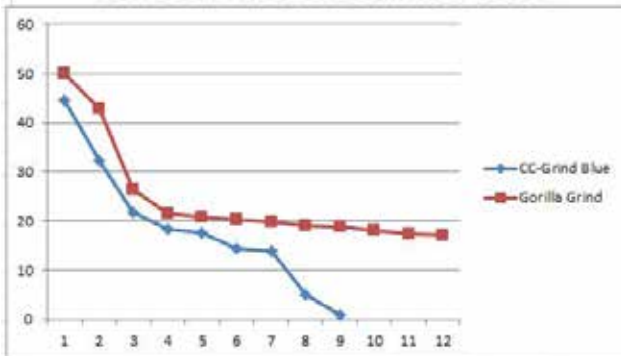


The Gorilla Grind Grinding Disc is more aggressive than reinforced grinding wheels. The innovative design provides a quieter, smoother and cleaner operation meaning increased productivity. The Gorilla Grind also runs smoother and quieter than standard grinding wheels giving the operator a safer, cleaner and more comfortable grinding experience.

The Gorilla Grind outperforms similar products in speed and life. Gorilla Grind removes material up to 20% faster than other brands, and the Gorilla Grind Disc lasts up to 30% longer!

- **High Performance Grinding Technology and Grain** results in 20% more stock removal and 30% longer life than similar grinding discs making this disc more effective saving time and money.
- The innovative **shape and rigidity of the wheel** combined with the advanced abrasive grain makes it 50% more productive in stock removal rates compared with reinforced grinding wheels – meaning less change-outs – saving time and money for the user.
- The **innovative shape and rigidity** allows user to put more direct contact with the work surface resulting in 50% less noise and vibration compared to standard grinding wheels which means less user fatigue and more productivity.
- **Less bonding material and more direct abrasive grain** results in 80% less dust produced compared to reinforced grinding wheels – for a cleaner and safer working area.
- Easy handling with **large surface contact area** means a more uniform surface finish with drastically reduced risk of gouging the surface.
- The combination of **extremely high stock removal rate + long service life + high user comfort** means REDUCED labor, inventory, injury and fatigue.

Removal Rate on Stainless Steel



Use on
ANGLE GRINDERS



for CLEANING &
GRINDING

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IBS No.	Description	MAX RPM	Qty
41551	4-1/2 X 5/8-11 Gorilla Grind Disc	13,300	10
41552	4-1/2 X 7/8 Gorilla Grind Disc	13,300	10
41553	6 X 5/8-11 Gorilla Grind Disc	10,200	10
41554	6 x 7/8 Gorilla Grind Disc	10,200	10

APPLICATIONS

- Surface grinding
- Weld removal
- Deburring/edge grinding
- Machining cutting torch burrs

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CC-GRIND-VIEW VICTOGRAIN Grinding Discs HIGH PERFORMANCE COATED ABRASIVES FOR STEEL & STAINLESS STEEL



CC-Grind-View is a grinding disc with unique design and the **VICTOGRAIN® high-performance abrasive grain**. The **viewing pane** enables users to monitor their work progress while using the product. Designed for surface grinding, chamfering, deburring and work on weld seams.

- **Open “View” window design** provides a clear line of sight to the workpiece for **better accuracy and safer grinding**.
- **VICTOGRAIN** — high performance for maximum stock removal and longer life.
- **Better wheel angle design** is **more ergonomic** than a conventional grinding wheel to **reduce noise, vibration and dust** for a cleaner, and more comfortable user experience.
- **Fiberglass-reinforced plastic backing pad** means no separate backing pad required, reducing cost and providing a **more consistent and reliable** application.

CC-GRIND-VIEW is ideal for:

- Surface grinding
- Weld removal
- Chamfering
- Deburring/edge grinding
- Machining cutting torch burrs



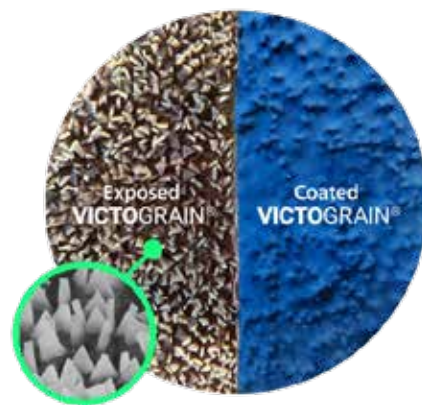
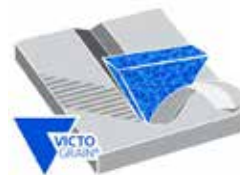
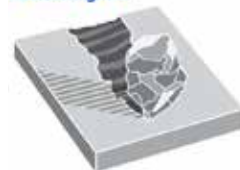
VICTOGRAIN

HIGH PERFORMANCE ABRASIVE GRAIN

The **VICTOGRAIN®** abrasive grain triangles are **identical in shape and size, optimally aligned**, and their **cutting edges are applied to the workpiece at the optimum angle**, meaning the grain needs very little energy to penetrate the workpiece offering an extremely large chip space for maximum cutting efficiency.

The **VICTOGRAIN®** design results in **lower heat** resulting in a wheel that provides **optimal, consistent performance, cool grinding** and an **extremely long service life** with **uniform workpiece surface roughness**.

Conventional abrasive grain



The **VICTOGRAIN®** has been engineered with a **very fine crystalline structure** that ensures optimal wear characteristics as **sharp cutting edges are always exposed**, with the minimum amount of abrasive breaking off from the triangle providing very aggressive stock removal with a long service life.

Use on
ANGLE GRINDERS



for **CLEANING & GRINDING**

QUICK GUIDE

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IBS No.	Dimensions (Dia. x Arbor)	MAX RPM	Qty
61158	5 x 7/8	13,300	10



IBS, INCORPORATED

Abrasives P26

CC-GRIND-SOLID Rough Grinding Discs

HIGH PERFORMANCE COATED ABRASIVES FOR STEEL & STAINLESS STEEL

The **CC-Grind-Solid** is **100% (or 2x) more aggressive** than a grinding wheel – which reduces labor time, increases productivity, and gives the operator a quiet, safe, comfortable and cleaner grinding experience.

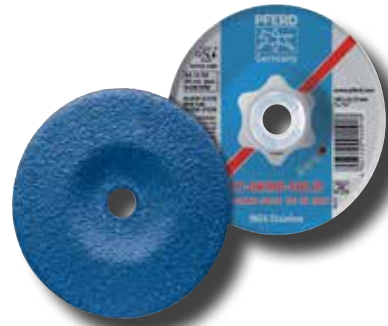
- **40% more productivity** due to ultimate stock removal rates compared with reinforced grinding wheels.
- **50% less noise and vibration** means less user fatigue.
- **80% less dust** produced compared to reinforced grinding wheels – for a cleaner and safer working area.
- Easy handling with **large surface contact area** means a more uniform surface finish with drastically reduced risk of gouging the surface.
- Innovative **high-strength layer structure** of the fiberglass backer with the high-performance coated abrasive means no expensive back-up pad, faster tool changes and a thicker wheel for longer life!
- The combination of **extremely high stock removal rate + long service life + high user comfort** means REDUCED labor, inventory, injury and fatigue.

CC-GRIND-SOLID is ideal for the following jobs:

- Surface grinding
- Weld removal
- Chamfering
- Deburring/edge grinding
- Machining cutting torch burrs



CC GRIND SOLID FOR STEEL provides extremely high removal rate combined with long service life and high user comfort.



CC GRIND SOLID FOR STAINLESS STEEL Ideal on stainless steel (INOX) and alloys, provides high, cool stock removal with low grinding pressure.

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for **CLEANING & GRINDING**

Dimensions (Dia. x Arbor)	Steel	Stainless	MAX RPM	Qty
4-1/2 x 7/8	40550	40555	13,300	10
4-1/2 x 5/8-11	41550	41555	13,300	10
7 x 7/8	40750	40755	8,500	5
7 x 5/8-11	41750	41755	8,500	5

Close up of the layer structure



High-strength disc design for ergonomic, safe work.

Rough grinding & weld removal



Excels on rough grinding applications.

Available with quick change hub



Quick and easy wheel change-outs.

CC-GRIND-STRONG Rough Grinding Discs

HIGH PERFORMANCE COATED ABRASIVES FOR STEEL & STAINLESS STEEL

The **CC-Grind-STRONG** is the stepping stone between the classic grinding wheel (the backing pad also grinds) and the modern alternative CC-GRIND® SOLID (fast, ergonomic grinding). It's patented design features a unique, multi-layered design with three coated discs stacked on a 1/8" resin-bonded abrasive backer, which not only serves as a supporting backing, but is also used during grinding.

- **Stacked coated discs** with a bonded abrasive support provides three times the service life compared to **CC-GRIND® - SOLID STEEL** - longer life plus reduced wheel changeouts saves time and money.
- The **highly aggressive abrasive material** results in maximum material removal for efficient productivity, saving users time and money.
- **Patented design** of the stacked discs means a wheel that is significantly more ergonomic than a conventional grinding wheel, reducing noise and vibrations by 50% and dust by 70%.
- The **layered abrasives** provide a superior surface finish compared to conventional grinding wheels because of the reduced vibration and ease of handling, saving finishing time.

CC-GRIND-STRONG is ideal for:

- Surface grinding
- Weld removal
- Chamfering
- Deburring/edge grinding
- Machining cutting torch burrs



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for **CLEANING & GRINDING**

IBS No.	Dimensions (Dia. x Arbor)	MAX RPM	Qty
42350	4-1/2 x 7/8	13,300	10
43350	4-1/2 x 5/8-11	13,300	10



IBS, INCORPORATED

Abrasives P30

Double Sided Abrasive Discs

WITH VISI-COOL

These double sided discs allow the user to grind and finish without having to move a large work piece or grind from an uncomfortable position.

- **Abrasive on both sides** allows the operator to safely grind with both surfaces without changing position or direction, saving time on disc changeouts ultimately saving time and money.
- **Lightweight design and elimination of backing** allows easy control and less operator fatigue for maximum productivity.
- **Thin design** allows access into hard to reach areas like inside channels, tracks and the underside of surfaces for a versatile disc for a variety of applications, saving inventory costs.
- **VISI-COOL openings** allow the operator to see the work surface, while dissipating heat and minimizing the risk of discoloration for maximum life and ease of use.
- Available in **3 different grits** — 40/60/80 for a wide range of applications.
- **Easy-to-use adapter** makes disc mounting simple and changeovers fast and easy — Requires no backing pad, and discs can be changed by hand, saving time and money!



IBS No.	Dimensions Dia. x Arbor	Grit	MAX RPM	Pkg Qty
47540	4-1/2 x 5/8-11	40	13,300	10
47560	4-1/2 x 5/8-11	60	13,300	10
47580	4-1/2 x 5/8-11	80	13,300	10
47590	Adapter for Double Sided Abrasive Disc			1



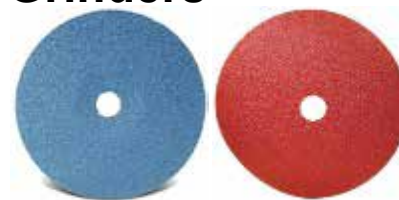
Stainless Steel adapter for simple tool free disc mounting and changeovers. Includes two spacers to fit common spindle lengths.



Resin Fibre Discs for Right Angle Grinders

One of the most popular coated abrasive products used in the industry, these resin fibre discs are constructed with a heavy vulcanized fibre back and coated with abrasive grains and bonded with a tough, heat-resistant resin.

- Each specific disc type has features and benefits unique to the particular application for which it was designed.
- Electrostatic coating process orients the sharpest cutting edge of the grain upward and allows for uniform grain coverage, providing for maximum aggression.
- Individually coated. This process assures consistent grain dispersion to the outermost edge and most important cutting area of the disc.
- Completely sealed (front and back) to maintain the moisture content of the fibre, significantly extending shelf life under extreme challenges of atmospheric conditions.
- Pre-shaped to maintain proper assembly relationship between the disc and back-up pad.



ZIRCONIUM

CERAMIC

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Use on
ANGLE GRINDERS



for **GRINDING,
BLENDING &
FINISHING**

Zirconium	80 Grit	60 Grit	36 Grit	24 Grit	Qty
4-1/2 x 7/8	66480	66460	66436	66424	25
5 x 7/8	66580	66560	66536	66524	25
Ceramic Grain	80 Grit	60 Grit	36 Grit	24 Grit	Qty
4-1/2 x 7/8	67480	67460	67436	67424	25
5 x 7/8	67580	67560	67536	67524	25

Zirconium

- Excellent performance on stainless steel. Recommended for heavy weld & metal grinding.
- High performance disc with a fast cut rate.
- Tough self-sharpening grain.
- Cool grinding action reduces glazing and loading.

Ceramic Grain

- For superior grinding and finishing on all types of carbon steel.
- Twice the life, and three to four times the performance of similar aluminum oxide discs.
- This revolutionary grain, the latest generation of synthetic metal cutting minerals, was developed for the most demanding grinding and finishing applications.
- Very high rate of cut and extended life expectancy.
- Shelf-sharpening grain ensures consistent performance during the entire life of the disc.



Back-Up Pads for Resin Fibre Discs (P31)

Back-Up Pads support the disc and properly distribute the grinding pressure to the workpiece. For best disc cutting performance and durability, it is important that the appropriate back-up pad be selected. Pad nuts are included with Back-Up Pads (5/8-11" thread for all standard spindles.)

Features / Benefits

- Provides disc support; distributes proper grinding pressure to the workpiece.
- Mounting systems designed for easy, fast disc change.
- Shift clutch action assures operator safety if a pad jams during operation.
- Adjustable wrench adapts to all variations of back-up pad threaded nuts.

Size	Thread	IBS No.	RPM
4-1/2	5/8-11	64404	13,000
5	5/8-11	64405	13,000
ADJ Wrench		64411	



IBS, INCORPORATED

Abrasives P30

Solid Mini Roloc Quick Change Grinding Discs

Our **Solid Mini Grinding Discs** use a **Type R plastic roll on lock design** as its base.

- **Grain is fused directly to a tough polymer backing for a stronger, firmer, more versatile grinding disc** that can be used wet or with coolants. These discs can even be easily cleaned, extending the life and usability of the disc.
- **One piece design eliminates the risk of the disc detaching** from the traditional roloc knob for a safer operation.
- **Plastic backing and one piece design allows for the disc to be trimmed** as it wears, to renew the cutting surface and reduce the diameter.
- **Coated with specially processed grit engineered for toughness, sharpness and bond** in Ceramic Plus Grinding Aid and in Zirconia Plus Grinding Aid in 2" & 3" diameters.

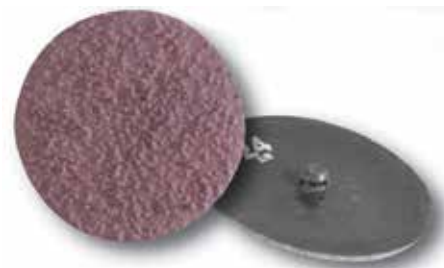
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CERAMIC+ SOLID MINI ROLOC CERAMIC+ GRINDING DISCS

Innovative Ceramic Resin Fibre Disc **for industrial metal applications.**

Provides ultimate grinding performance using new 100% SG Ceramic grain with top coat. Developed especially for use on stainless steel and other alloys for maximum performance.

- A special TOP COAT is applied, combining a grinding and a cooling aid which helps resist loading and aids in cooling, resulting in longer life and less marring and discoloration, making the disc more effective, saving time and money.
- 100% ceramic grain provides long lasting life on stainless steel, carbon steel, and high Nickel and Alloy metals.

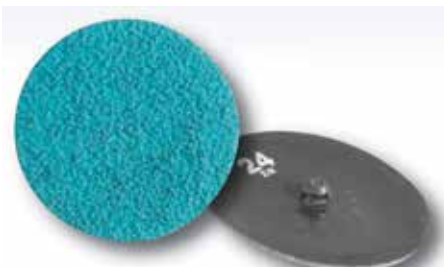


SOLID MINI ROLOC CERAMIC+ QUICK CHANGE GRINDING DISCS

Ceramic+	120 Grit	80 Grit	60 Grit	36 Grit	Qty
2"	36605	36603	36602	36600	10
3"	36612	36610	36609	36607	10

ZIRCONIA+ SOLID MINI ROLOC ZIRC+ GRINDING DISCS

- A special TOP COAT is applied, combining a grinding and cooling aid which helps resist loading and aid in cooling, resulting in a longer life and less marring and discoloration, making the disc more effective, saving time and money.
- 100% zirconia grain provides long lasting life on hard materials and tough grinding applications with very high stock removal which saves time and money.



SOLID MINI ROLOC ZIRC+ QUICK CHANGE GRINDING DISCS

Zirconium+	120 Grit	80 Grit	60 Grit	36 Grit	Qty
2"	36625	36623	36622	36620	10
3"	36632	36630	36629	36627	10

IBS, INCORPORATED

Assortments Z02



Solid Mini Roloc Ceramic+ Grinding Discs

IBS No. 827R • 10 ITEMS • 42 Pcs

PACKAGED IN A LOCKING STEEL DRAWER FOR EASY STORAGE & ORGANIZATION



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SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR
INDUSTRIALBOLT.COM 800-678-1906

Solid Roloc Ceramic+ Grinding Discs

Assortment No. 827R

36600 2IN 36G SOLID ROLOC CERAMIC+ GRINDING DISC 	36602 2IN 60G SOLID ROLOC CERAMIC+ GRINDING DISC 	36603 2IN 80G SOLID ROLOC CERAMIC+ GRINDING DISC 	36605 2IN 120G SOLID ROLOC CERAMIC+ GRINDING DISC 
36607 3IN 36G SOLID ROLOC CERAMIC+ GRINDING DISC 	36609 3IN 60G SOLID ROLOC CERAMIC+ GRINDING DISC 	36610 3IN 80G SOLID ROLOC CERAMIC+ GRINDING DISC 	36612 3IN 120G SOLID ROLOC CERAMIC+ GRINDING DISC 
06525 2IN ROLOC BACKING PAD 	06535 3IN ROLOC BACKING PAD 		

Solid Mini Roloc Zirc+ Grinding Discs

IBS No. 828R • 10 ITEMS • 42 Pcs

PACKAGED IN A LOCKING STEEL DRAWER FOR EASY STORAGE & ORGANIZATION



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Solid Roloc Zirconia+ Grinding Discs

Assortment No. 828R

36620 2IN 36G SOLID ROLOC ZIRC+ GRINDING DISC 	36622 2IN 60G SOLID ROLOC ZIRC+ GRINDING DISC 	36623 2IN 80G SOLID ROLOC ZIRC+ GRINDING DISC 	36625 2IN 120G SOLID ROLOC ZIRC+ GRINDING DISC 
36627 3IN 36G SOLID ROLOC ZIRC+ GRINDING DISC 	36629 3IN 60G SOLID ROLOC ZIRC+ GRINDING DISC 	36630 3IN 80G SOLID ROLOC ZIRC+ GRINDING DISC 	36632 3IN 120G SOLID ROLOC ZIRC+ GRINDING DISC 
06525 2IN ROLOC BACKING PAD 	06535 3IN ROLOC BACKING PAD 		

ABRASIVES



IBS, INCORPORATED

Abrasives P30

Quick Change Grinding Discs

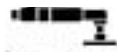
Hi-Alloy Zirconium Grinding Discs

- Superior Grain resharpsens itself during grinding.
- Fast, aggressive cutting action that resists loading.
- Suitable for hard materials and tough grinding applications.
- Uses the same disc holders as the surface conditioning discs to change from grinding to conditioning in seconds.



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Use on
Angle
AIR DIE GRINDERS



for GRINDING,
BLENDING &
FINISHING

Size	120G	80G	60G	36G	Qty
2	09425	09420	09415	09410	10

Use IBS Back Up Pad No. 06525 with 2"

3	09445	09440	09435	09430	10
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Use IBS Back Up Pad No. 06535 with 3"

Use IBS Back Up Pad No. 06530

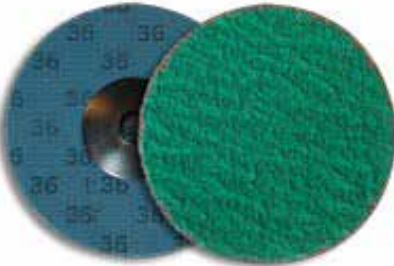
Use Back Up Pad 3" 5/8-11 for Angle Grinders

4	—	09480	09460	09436	5
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Use IBS Back Up Pad No. 06545 with 4"

Zirconium Plus Grinding Aid:

With Grinding Aid for use on High Temperature Alloys, Titanium, & Stainless Steel.



MINI ROLOC GRINDING DISCS ZIRCONIUM PLUS GRINDING AID

Size	120G	80G	60G	36G	Qty
2	36688	36687	36686	36683	10

Use IBS Back Up Pad No. 06525 with 2"

3	36700	36699	36698	36695	10
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Use IBS Back Up Pad No. 06535 with 3"

Use IBS Back Up Pad No. 06530

Use Back Up Pad 3" 5/8-11 for Angle Grinders

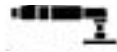
Ceramic Grain:

Ceramic Alumina with grinding aid exposes sharp cutting points that yields a faster and cooler cutting action. Ferrous, Non-Ferrous, Carbon Steel and Exotic Alloys.



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Angle
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for GRINDING,
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Size	120G	80G	60G	36G	Qty
2	40334	40333	40332	40329	10

Use IBS Back Up Pad No. 06525 with 2"

3	40340	40339	40338	40335	10
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Use IBS Back Up Pad No. 06535 with 3"

Use IBS Back Up Pad No. 06530

Use Back Up Pad 3" 5/8-11 for Angle Grinders

IBS, INCORPORATED

Assortments Z02



3" Roloc Grinding Discs

IBS No. 548P • 10 ITEMS • 91 PIECES WITHOUT DIE GRINDER
PACKAGED IN A LOCKING STEEL DRAWER FOR EASY STORAGE & ORGANIZATION

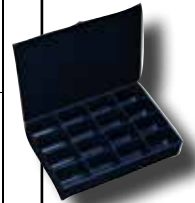


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3" Roloc Grinding Discs

Assortment No. 548P

09440 3 80G ROLOC ZIRC DISC*  	36699 3 80G ROLOC ZIRC+ GRINDING*  	40339 3 80G ROLOC CERAMIC GRAIN*  	
09435 3 60G ROLOC ZIRC DISC*  	36698 3 60G ROLOC ZIRC+ GRINDING*  	40338 3 60G ROLOC CERAMIC GRAIN*  	
09430 3 36G ROLOC ZIRC DISC*  	36695 3 36G ROLOC ZIRC+ GRINDING*  	40335 3 36G ROLOC CERAMIC GRAIN*  	06535 3 ROLOC BACKING PAD*  



Grinder NOT for use with cut-off wheels over 3" in diameter. Refer to ASTM B7.1-2001

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IBS, INCORPORATED

Abrasives P30

Trim-Kut® Discs

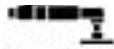


A revolutionary abrasive disc designed to grind and finish a wide variety of materials faster and cooler than any other abrasive disc available today. The patented process of fusing premium abrasive grains to a durable polymer backing results in a highly versatile grinding tool that requires no backing pad.

Trim-Kut® Discs are readily trimmable to either renew the cutting surface, or reduce the diameter.

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Use on
1/4" 90° Angle
AIR DIE GRINDERS



for GRINDING,
BLENDING &
FINISHING

Size	Description	Green 120G	Orange 60G	Red 36G	RPM	Qty
3" 80mm	Mid-Alloy	69399	69360	69336	28,000	25

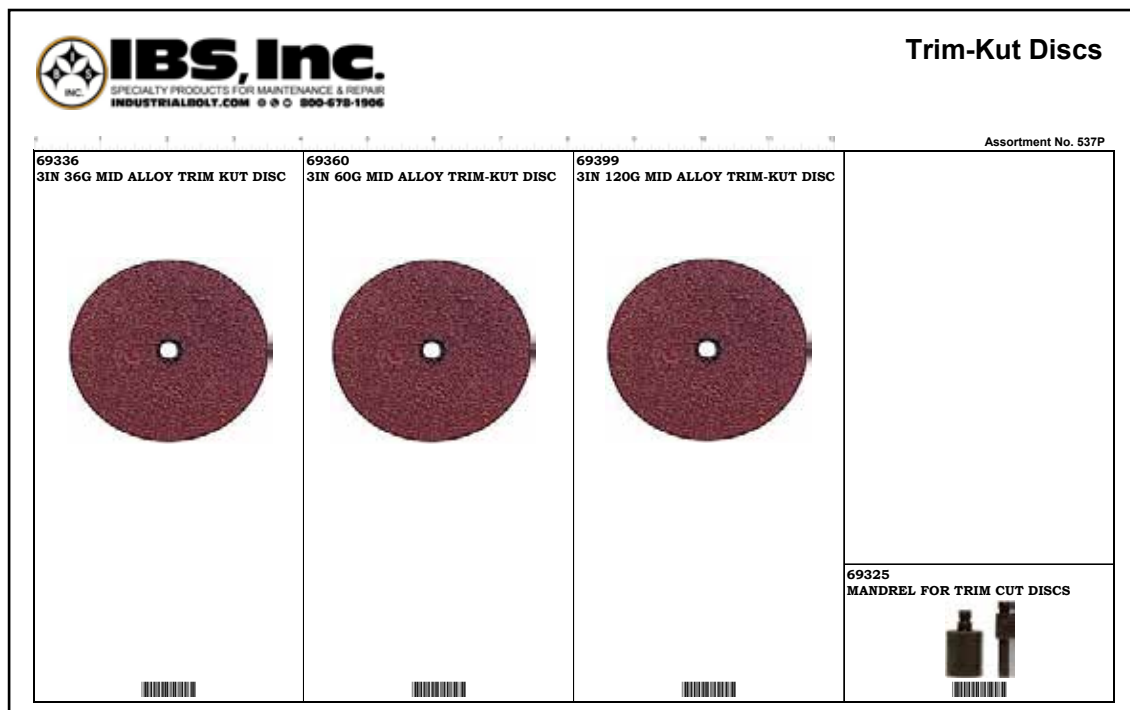
Each package (25) contains 1 (one) Mandrel
TRIM-KUT Discs use IBS Mandrel No. 69325
Any quantity less than 25, Mandrel is sold separately



Trim-Kut® Discs Assortment (Z08)

IBS No. 537P • 4 ITEMS • 76 PIECES

PACKAGED IN A LOCKING STEEL DRAWER



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Trim-Kut® Depressed Center Surface Conditioning Discs

Trim-Kut Depressed Center Surface Conditioning Discs are non-woven material mounted on a stiff, solid backing that produces a firm, yet flexible feel providing exceptional control whether using it to aggressively remove material or to apply finishing pressure.

Ideal for general surface preparation and finishing with more durable surface conditioning material and a solid backing. Ideal for deburring, blending coarse abrasive scratches and removing rust, corrosion, oxides, paint, adhesives and gaskets.

Trim-Kut Surface Conditioning Discs provide a fast initial cut and high rate of productivity. They are tough and long lasting.

- Trim-Kut® design means the **abrasive material is bonded directly to a durable polymer backing**, resulting in a highly versatile grinding/finishing tool that requires no backing pad, reducing costs and set up time.
- Trim-Kut® also means these discs are readily **trimmable** to either renew the cutting surface edge or reduce the diameter for a longer lasting disc with more versatility.
- **Ideal for deburring, blending** coarse abrasive scratches and **removing** rust, corrosion, oxides, paint, scale, adhesives and gaskets.
- Trim-Kut **center locking nut** (IBS No. 64410) sold separately.



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Use on
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GRINDERS



for GRINDING,
BLENDING &
FINISHING

IBS No.	Description	Qty
36710	4-1/2 X 7/8 EXTRA COARSE - BROWN	10
36712	4-1/2 X 7/8 MEDIUM - MAROON	10
36713	4-1/2 X 7/8 VERY FINE - BLUE	10
64410	4-1/2 TRIM-KUT 5/8-11 CENTER LOCKING NUT	1



Use on
ANGLE GRINDERS



for BLENDING &
FINISHING

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Surface Conditioning SCM Flap Discs

Surface Conditioning Discs non-woven materials are reinforced with a tightly knit fabric (scrim) backing that produces a firm, yet flexible heavy-duty material which is capable of withstanding aggressive treatment associated with demanding applications. The thick coating of evenly spread aluminum oxide grain is securely bonded to deliver a consistent, uniform finishing action for the entire life of the product.

- For general surface preparation and finishing with more durable surface conditioning material. Layered flaps provide 5 times more life than traditional discs.

SCM (SURFACE CONDITIONING MATERIAL) FLAP DISCS - TYPE 27

Dimensions (Dia. x Arbor)	V Fine Blue	Medium Maroon	Coarse Brown	MAX RPM	Optimum RPM	Qty
4-1/2 x 7/8	37730	37731	37732	13,300	6,000	5
4-1/2 x 5/8-11	37735	37736	37737	13,300	6,000	5



IBS, INCORPORATED

Abrasives, Shop Rolls, Files P26

Cloth Utility Rolls

Made from a high grade resin bonded cotton cloth material. This combination delivers long life and flexible cutting characteristics allowing for the optimum performance in a wide range of applications.

- Extremely popular as a general purpose deburring, sanding, cleaning and polishing tool in all machine, maintenance and welding shops.
- May be used on all types of materials.
- Excellent for working on turning parts and lathes.
- Supplied in a rugged corrugated storage container for easy dispensing of material.



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Size	Crocus*	320G	240G	180G	150G	120G	100G	80G
1 x 50 yds	40038			05006		05008		05010
1-1/2 x 50 yds	40039	05032	05024	05026	05047	05028	05049	05030
2 x 50 yds			05044	05046		05048		05050

NOTE: Crocus Roll is 800 to 1200 grit and may also be used for polishing applications.

Screen Back Roll

- Made of silicone carbide
- Open screen for high speed sanding.
- Can be used wet or dry.
- Non-clogging, no loading, use both sides for longer life and less labor.
- Ideal for body repairs, cleaning brass, copper, copper tubing and ends, removing glaze from new parts, smoothing rough spots, deburring and cleaning most surfaces.



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Size	180G	120G	80G
1-1/2 x 25 yds	05751	05750	05749

Flex Cut Hand Pads (P30)

Made of non-woven nylon material impregnated with abrasive grit bonded with synthetic resins. The cost-saving alternative to steel wool and emery cloth.



IBS No.	Description	Size	Grain	Color	Qty
50434	Ultra Fine	6 x 9	Silicon Carbide	Gray	10
Ideal for fine finishing and light cleaning of metal, plastic, fiberglass and wood surfaces.		Use for polishing dies, fine bur removal on threaded parts, fine finishing of aluminum doors and frames, fine deburring of metal and plastic surfaces, scuffing acrylics, blending paint, etc.			
50444	General Purpose	6 x 9	Aluminum Oxide	Maroon	10
Ideal for general purpose hand cleaning, blending and finishing.		Use for satin finishing of aluminum extrusions and stainless steel, cleaning printed circuit boards, rust and corrosion removal, jitterbug sanding, etc.			
50454	Heavy Duty	6 x 9	Aluminum Oxide	Tan	10
Ideal for demanding hand cleaning and finishing applications. Long lasting and aggressive.		Use for weld cleaning, deburring, removing heavy rust and oxides decorative scratch finishing of aluminum, finishing stainless steel, blending, etc.			

QUICK GUIDE
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POLISHING

Surface Conditioning Discs

Surface Conditioning Discs non-woven materials are reinforced with a tightly knit fabric (scrim) backing that produces a firm, yet flexible heavy-duty material which is capable of withstanding aggressive treatment associated with demanding applications. A thick coating of evenly spread aluminum oxide grain is securely bonded to deliver a consistent, uniform finishing action for the entire life of the product.



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for BLENDING &
FINISHING

SURFACE CONDITIONING DISCS TYPE "R" — ROLOC

Dimensions (Dia. x Arbor)	V Fine Blue	Medium Maroon	Coarse Brown	MAX RPM	Qty	Box Qty
3/4	06516	06517	06518	35,000	10	100

Use IBS No. 06520 Back Up Pad with 3/4"

2	06521	06522	06523	23,000	10	50
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Use with IBS No. 06525 Back Up Pad with 2"

3	06531	06532	06533	20,000	10	25
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Use IBS Back Up Pad No. 06535 with 3"

Use IBS Back Up Pad No. 06530 3" 5/8-11 for Angle Grinders

4		06542	06543	18,000	5	25
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Use with IBS No. 06545 Back Up Pad with 4"

Ceramic Grain Surface Conditioning Discs

Surface Conditioning Discs with added Ceramic Grain designed for heavier deburring, cleaning, and finishing applications.

- Excellent for weld grinding and spatter removal.
- Firm cutting action works well on flat surfaces.
- Coarser and more aggressive for heavy deburring, rust removal and scale removal.
- Ideal for use on ferrous metals, stainless and other exotic metals.



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CERAMIC GRAIN SURFACE CONDITIONING DISCS TYPE "R"— ROLOC

IBS No.	Size	Grade	Color	MAX RPM	Qty	Box Qty
40421	2	Medium	Maroon	23,000	10	50
40420	2	Coarse	Brown	23,000	10	50

Use IBS Back Up Pad No. 06525 with 2"

40423	3	Medium	Maroon	20,000	10	25
40422	3	Coarse	Brown	20,000	10	25

Use IBS Back Up Pad No. 06535 with 3"

Use IBS Back Up Pad No. 06530 3" 5/8-11 for Angle Grinders

EXTRA TOUGH

With added ceramic grain, coarser and more aggressive than regular surface conditioning discs. Designed for heavier deburring, cleaning and finishing applications.



Roloc Disc Holders (P31)

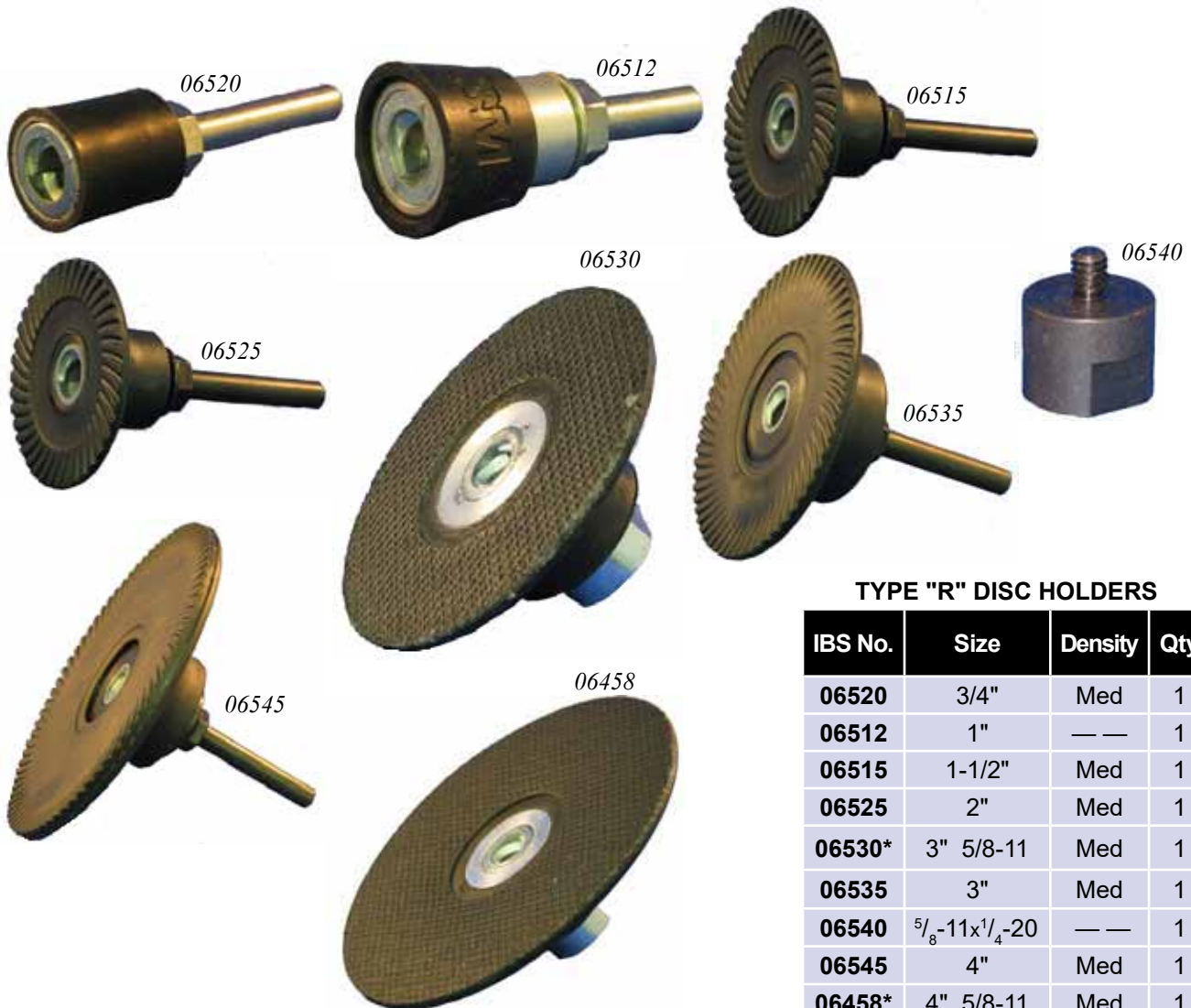
These locking devices reduce disc changing time to seconds. They won't fly off at high speeds and no tools or adhesives are required. A clockwise turn securely anchors the disc to the pad and insures positive centering. Turning them counterclockwise removes the disc from the pad.

2", 3" And 4" Size

- These unique pads are available in 2", 3" & 4" sizes. New design and construction provides unparalleled durability, performance and service life.
- Exceptional combination of flexibility and back support optimizes disc performance.
- Vented pad surface removes heat generated during use, to maximize abrasive disc life.
- Uniform 3 pc composition contributes to a safe, balanced and vibration-free use for longer life.
- Mounting stem included.

5/8-11 Female to 1/4-20 Male Adapter (IBS No. 06540)

- Adapts standard back-up pads with 1/4-20 arbor for use on angle grinders with a 5/8-11 shaft — this makes for better control and easier grinding using an angle grinder versus a die grinder.



TYPE "R" DISC HOLDERS

IBS No.	Size	Density	Qty
06520	3/4"	Med	1
06512	1"	— —	1
06515	1-1/2"	Med	1
06525	2"	Med	1
06530*	3" 5/8-11	Med	1
06535	3"	Med	1
06540	5/8-11x1/4-20	— —	1
06545	4"	Med	1
06458*	4" 5/8-11	Med	1

* Converts Angle Grinders to Roloc system



Roloc™ Surface Conditioning Discs 3/4" - 4"

BACK UP PADS SOLD SEPARATELY
IBS No. 705R • 15 ITEMS • 49

PIECES

PACKAGED IN A LOCKING STEEL DRAWER

IBS, Inc. SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR INDUSTRIALBOLT.COM © © © 800-678-1996				Roloc™ Surface Conditioning Discs 3/4" to 4" Assortment No. 705R	
06516 3/4 FINE ROLOC SURF COND DISC 	06521 2IN FINE ROLOC SURF COND DISC 	06531 3IN FINE ROLOC SURF COND DISC 	06542 4IN MED ROLOC SURF COND DISC 		
06517 3/4 MED ROLOC SURF COND DISC 	06522 2IN MED ROLOC SURF COND DISC 	06532 3IN MED ROLOC SURF COND DISC 	06543 4IN CRS ROLOC SURF COND DISC 		
06518 3/4 CRS ROLOC SURF COND DISC 	06523 2IN CRS ROLOC SURF COND DISC 	06533 3IN CRS ROLOC SURF COND DISC 			

Roloc™ Surface Conditioning Discs with Pads

IBS No. 707R • 16 ITEMS • 48

PIECES

PACKAGED IN A LOCKING STEEL DRAWER

IBS, Inc. SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR INDUSTRIALBOLT.COM © © © 800-678-1996				Roloc™ Surface Conditioning Discs 3/4" to 3" Assortment No. 708R	
06516 3/4 FINE ROLOC SURF COND DISC 	06517 3/4 MED ROLOC SURF COND DISC 	06518 3/4 CRS ROLOC SURF COND DISC 	06520 3/4 ROLOC STYLE BACKING PAD 		
06521 2" FINE ROLOC SURF COND DISC 	06522 2" MED ROLOC STYLE SURF COND 	06523 2" CRS ROLOC STYLE SURF COND 	06525 2" ROLOC STYLE BACKING PAD 		
06531 3" FINE ROLOC SURF COND DISC 	06532 3" MED ROLOC STYLE SURF COND 	06533 3" CRS ROLOC STYLE SURF COND 	06535 3" ROLOC STYLE BACKING PAD 		

2" & 3" Roloc™ Surface Prep Assortment

IBS No. 501P • 17 ITEMS • 66

PIECES

INCLUDES 1/4" 90° ANGEL AIR DIE GRINDER

IBS No. 504P • 16 ITEMS • 65

PIECES WITHOUT DIE GRINDER

PACKAGED IN A LOCKING STEEL DRAWER

IBS, Inc. SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR INDUSTRIALBOLT.COM © © © 800-678-1996				Roloc Style Surface Prep Discs with 1/4 Angle Air Die Grinder Assortment No. 501P	
06521 2" Fine Surface Conditioning Disc 	06532 3" Medium Surface Conditioning Disc 	06535 3" Roloc Back Pad 	127357 1/4 Angle Air Die Grinder 		
06522 2" Medium Surface Conditioning Disc 	06533 3" Coarse Surface Conditioning Disc 	06525 2" Roloc Back Pad 			
06523 2" Coarse Surface Conditioning Disc 	36699 3" 80 Grit Zirc Plus Grinding Disc 	68024 3" 80 Grit Tapered Bristle Disc 	68018 2" 50 Grit Tapered Bristle Disc 		
09420 2" 80 Grit Zirconium Grinding Disc 	36698 3" 60 Grit Zirc Plus Grinding Disc 	06531 3" Fine Surface Conditioning Disc 			
09415 2" 60 Grit Zirconium Grinding Disc 	36695 3" 36 Grit Zirc Plus Grinding Disc 				
09410 2" 36 Grit Zirconium Grinding Disc 					

Grinder NOT for use with cut-off wheels over 3" in diameter. Refer to ASTM B7.1-2001

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IBS, INCORPORATED

Assortments Z02

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 Assortment No. 523P			
06521 2IN FINE ROLOC SURF COND DISC 	06531 3IN FINE ROLOC SURF COND DISC 	06545 4IN ROLOC BACKING PAD 	
06522 2IN MED ROLOC SURF COND DISC 	06532 3IN MED ROLOC SURF COND DISC 	06542 4IN MED ROLOC SURF COND DISC 	
06523 2IN CRS ROLOC SURF COND DISC 	06533 3IN CRS ROLOC SURF COND DISC 	06543 4IN CRS ROLOC SURF COND DISC 	06535 3IN ROLOC BACKING PAD  06525 2IN ROLOC BACKING PAD 

2", 3", 4" Roloc™
Surface Cond Discs
IBS No. 523P • 11 ITEMS • 55 Pcs
 WITHOUT DIE GRINDER
 PACKAGED IN A LOCKING STEEL DRAWER

 Assortment No. 529P			
40423 3IN MED ROLOC X-TOUGH CERAMIC SURF DISC 	40339 3IN 60G ROLOC CERAMIC GRAIN GRIND DISC 	38862 3IN V FINE ROLOC HI STRENGTH SATIN DISC 	06535 3IN ROLOC BACKING PAD 
40422 3IN CRS ROLOC X-TOUGH CERAMIC SURF DISC 	40338 3IN 60G ROLOC CERAMIC GRAIN GRIND DISC 	38861 3IN FINE ROLOC HI STRENGTH SATIN DISC 	
06730 3IN ROLOC SUPER STRIPPER COATING REMOVAL DISC 	40335 3IN 36G ROLOC CERAMIC GRAIN GRIND DISC 	38860 3IN MED ROLOC HI STRENGTH SATIN DISC 	

3" Roloc™ Total
Surf Prep Discs
IBS No. 529P • 10 ITEMS • 57
PIECES • WITHOUT DIE GRINDER
 PACKAGED IN A LOCKING STEEL DRAWER

 Assortment No. 542P			
06521 2 FINE ROLOC SURF COND DISC 	06531 3 FINE ROLOC SURF COND DISC 	40420 2 CRS ROLOC X-TOUGH CERAMIC  40421 2 MED ROLOC X-TOUGH CERAMIC 	06535 3 ROLOC BACKING PAD 
06522 2 MED ROLOC SURF COND DISC 	06532 3 MED ROLOC SURF COND DISC 	40422 3 CRS ROLOC X-TOUGH CERAMIC 	
06523 2 CRS ROLOC SURF COND DISC 	06533 3 CRS ROLOC SURF COND DISC 	40423 3 MED ROLOC X-TOUGH CERAMIC 	
06525 2 ROLOC BACKING PAD 			

Roloc Surface
Conditioning Discs
IBS No. 542P • 12 ITEMS • 52
PIECES WITHOUT DIE GRINDER
 PACKAGED IN A LOCKING STEEL DRAWER

TriFlex Grinding, Blending & Finishing Roloc Quick Change Discs

TriFlex Grinding, Blending & Finishing Roloc Quick Change Discs are IBS' latest initiative in providing premium abrasives that provide maximum performance.

FOR USE ON: Stainless steel, aluminum, mild steel, nickel alloys, kevlar and brass

FEATURES & BENEFITS:

- **Engineered with abrasive grain consistent throughout the wheel** for an even finish which allows the user to work with the entire wheel for ultimate cost and time savings.
- **Innovative blend of materials** that result in a wheel that is tough enough to grind and blend, yet soft enough to finish in one step for fewer disc changes, saving time and money.
- **Made with a blend of cotton fibers and abrasive materials** that are naturally non-loading on all metals, which make these discs ideal for use on a variety of materials, for less inventory and overall savings.
- **Has no backing material that could gouge the work surface** therefore providing a better, more consistent finish for the entire use of the wheel for maximum life resulting in cost savings.
- **Manufactured with laminates of non-woven abrasive impregnated into cotton fabric** providing a cushion action while in use, enabling the grit to push slightly back into the fiber which means more flexibility and a better surface finish versus coated abrasives.
- **The combination of cotton fiber and abrasive grain** result in a disc that will outlast other discs such as surface conditioning discs 4 to 5 times, and coated discs 8 to 10 times, saving time and money.
- **NOTE: For optimum flexibility and life, use 2" pad with 3" discs, and 1-1/2" pad with 2" discs.**



Size	Specifications					MAX RPM	Qty
	24 Grit	36 Grit	54 Grit	80 Grit	120 Grit		
2	40351	40352	40353	40354	40355	30,000	10
Use IBS Back Up Pad No. 06525 with 2" or 1-1/2" 06515							
3	40356	40357	40358	40359	40360	20,000	10
Use IBS Back Up Pad No. 06535 with 3" or 2" 06525							

TriFlex Roloc Quick Change Disc Assortment (Z02)

IBS No. 795R • 12 ITEMS • 34 PIECES

PACKAGED IN A LOCKING STEEL DRAWER FOR EASY STORAGE & ORGANIZATION

 IBS, Inc. SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR INDUSTRIALBOLTY.COM • 800-678-1906			TriFlex Quick Change Discs		
Assortment No. 795R					
40351 2" 24G TRIFLEX QUICK CHANGE DISC	40352 2" 36G TRIFLEX QUICK CHANGE DISC	40353 2" 54G TRIFLEX QUICK CHANGE DISC			
 	 	 			
40354 2" 80G TRIFLEX QUICK CHANGE DISC	40355 2" 120G TRIFLEX QUICK CHANGE DISC	06525 2 ROLOC BACKING PAD*			
 	 	 			
40356 3" 24G TRIFLEX QUICK CHANGE DISC	40357 3" 36G TRIFLEX QUICK CHANGE DISC	40358 3" 54G TRIFLEX QUICK CHANGE DISC			
 	 	 			
40359 3" 80G TRIFLEX QUICK CHANGE DISC	40360 3" 120G TRIFLEX QUICK CHANGE DISC	06535 3 ROLOC BACKING PAD*			
 	 	 			



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Abrasives P30

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Mounted Satin Wheels ALUMINUM OXIDE MEDIUM GRIT

Mounted satin wheels are most practical for removal of scale and oxidation. They will produce a uniform high luster finish without altering part geometry, and can be used for a wide variety of cleaning, finishing and polishing applications. Mounted satin wheels can be used with portable power tools, drill presses, and lathes.

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IBS No.	Dia.	Width	Max RPM	Shank	Qty
05762	2-3/8	2	8,000	1/4	2
05765	3	2	6,000	1/4	2

Use IBS Back Up Pad No. 06525 with 2"

Recommended RPM is 10 - 20% less than max.



High Strength Satin Discs

A flexible and durable disc with high strength fibers combined with a high grain content that delivers a tough, long lasting product for light deburring and final finishing.

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for BLENDING &
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Size	Specifications			MAX RPM	Qty
	V Fine Maroon	Fine Brown	Medium Dk Maroon		
2	38859	38858	38857	12,000	10
3	38862	38861	38860	8,000	10

Use IBS Back Up Pad No. 06525 with 2"

Use IBS Back Up Pad No. 06535 with 3"

Use IBS Back Up Pad No. 06530 3" 5/8-11 for Angle Grinders

2" & 3" Roloc Satin Discs (Z02)

IBS No. 546P • 8 ITEMS • 62 PIECES WITHOUT DIE GRINDER

PACKAGED IN A LOCKING STEEL DRAWER



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2" & 3" Roloc Satin Discs
Assortment No. 546P

38859 2" V FINE ROLOC HI STRENGTH  38858 2" FINE ROLOC HI STRENGTH  38857 2" MED ROLOC HI STRENGTH 	38861 3" FINE ROLOC HI STRENGTH  38860 3" MED ROLOC HI STRENGTH 	06535 3" ROLOC STYLE BACKING PAD  06525 2" ROLOC STYLE BACKING PAD  38862 3" V FINE ROLOC HI STRENGTH 
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Felt Polishing Discs

With Fiberglass Backing

- Flap discs made of 70% wool felt affixed to a fiberglass backing plate to create a thick polishing pad.
- The individual flaps are flexible, allowing for a cool air flow.
- Felt discs are used with polishing compounds or pastes to provide up to a mirror finish
- Ideal for work on irregular or contoured surfaces.

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TIP: Felt Products should always be run at lower speeds than coated abrasives.



NOTE: Felt polishing products are designed to be used with polishing compounds.

FELT FLAP DISCS

IBS No.	Diameter x Arbor	OPT RPM	MAX RPM	Qty
37750	4-1/2 x 7/8	1.650	10.000	5
37752	4-1/2 x 5/8-11	1.650	10.000	5
37753	5 x 5/8-11	1.520	10.000	5

Roloc Mini Felt Flap Discs



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ROLOC MINI FELT FLAP DISCS

IBS No.	Diameter	OPT RPM	MAX RPM	Qty
37755	2	1.650	10.000	5
37757	3	1.650	10.000	5

Compound Polishes

For Use with Felt Polishing Discs

IBS No.	Name	Color	Description	Qty
74207	White Rouge	White	Creates a high gloss finish on non-ferrous materials like aluminum and stainless steel.	1
74206	Stainless	Gray	Provides fast cutting action and good coloring. Creates gloss finish on a wide range of materials including steel, stainless, chrome, nickel & Plastic.	1





IBS, INCORPORATED

Assortments Z02

2" & 3" Felt Flap Disc Assortments

IBS No. 759R • 12 ITEMS • 52 PIECES

PACKAGED IN A LOCKING STEEL DRAWER FOR EASY STORAGE & ORGANIZATION



2" & 3" Roloc Satin & Felt Discs

Assortment No. 759R

38857 2IN MED ROLOC HI STRENGTH SATIN DISC  	38860 3IN MED ROLOC HI STRENGTH SATIN DISC  	37755 2IN ROLOC MINI FELT FLAP DISC  	
38858 2IN FINE ROLOC HI STRENGTH SATIN DISC  	38861 3IN FINE ROLOC HI STRENGTH SATIN DISC  	37757 3IN ROLOC MINI FELT FLAP DISC  	
38859 2IN V FINE ROLOC HI STRENGTH SATIN DISC  	38862 3IN V FINE ROLOC HI STRENGTH SATIN DISC  	06525 2IN ROLOC BACKING PAD   06535 3IN ROLOC BACKING PAD  	
			 74206 GRAY POLISHING COMPOUND FOR FELT DISCS 

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Bristle Discs

Faster, safer, more cost-effective coatings removal, weld preparation, general maintenance cleaning and cleaning in hard-to-reach areas.

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BRISTLE DISCS

Standard			
Dia.	120 Grit (White)	80 Grit (Yellow)	50 Grit (Green)
1		68010	

Single discs can be mounted with the Roloc™ attachment system
1" uses back-up pad 06512
Color Coded

Applications: Cleaning, finishing, blending and deburring. Use for general surface conditioning applications.

Tapered			
Dia.	120 Grit (White)	80 Grit (Yellow)	50 Grit (Green)
2	68016	68017	68018
3	68023	68024	68025

Single discs can be mounted with the Roloc™ attachment system

2" uses back up pad 06525
3" uses back up pad 06535
3"-5/8-11 uses back up pad 06530
Color Coded

Applications: Corners, welds and other areas where extreme conformity is required.

4-1/2" Bristle Disc			
Dia.	120 Grit (White)	80 Grit (Yellow)	50 Grit (Green)
4-1/2	68452	68451	68450

Threaded core spins quickly onto 5/8-11 threaded shafts on electric or pneumatic right angle grinders.

Color coded.

Applications: Ideal for removing adhesive, paint & other coatings, heavy oxides and surface contaminants.

Roloc Bristle Discs (Z08)

IBS No. 534P • 6 ITEMS • 12 PIECES WITHOUT DIE GRINDER

PACKAGED IN A LOCKING STEEL DRAWER

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Roloc Bristle Discs

Assortment No. 534P

68018 2IN 50G TAPERED BRISTLE DISC ROLOC DISC GREEN 25000RPM	68025 3IN 50G TAPERED BRISTLE DISC ROLOC DISC GREEN 15000RPM	06535 3IN ROLOC BACKING PAD
68017 2IN 80G TAPERED BRISTLE DISC ROLOC DISC YELLOW 25000RPM	68024 3IN 80G TAPERED BRISTLE DISC ROLOC DISC YELLOW 15000RPM	06525 2IN ROLOC BACKING PAD



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Super Stripper Roloc™ Coating Removal Discs

Red Super Stripper discs feature a tough web of non-flexible synthetic filaments coated with extra-coarse high-performance grain in an open construction that is very aggressive and non-loading.

- Quick-Change Roloc fastening system for fast and easy changeovers.
- Versatile sizes for small work areas.
- Covers a wide range of maintenance projects, including stripping and cleaning of coatings, rust, paint, adhesives and contaminants on a wide range of materials.

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IBS No.	Dia.	RPM	Qty	Use with Back Up Pad	
				IBS No.	Shank
06720	2"	15,500	10	06525	2 x 1/4
06730	3"	12,000	10	06535	3 x 1/4
				06530	3 5/8-11 Thrd
06740	4"	11,000	10	06545	4 x 1/4
				06458	4 5/8-11 Thrd

Roloc™ Coating Removal Discs Assortment (Z08)

IBS No. 519P • 6 ITEMS • 15 PIECES



Super Stripper Roloc™ Coating Removal Discs

Assortment No. 519P

06525
2 ROLOC BACKING PAD"



06535
3 ROLOC BACKING PAD"



06545
4 ROLOC BACKING PAD"



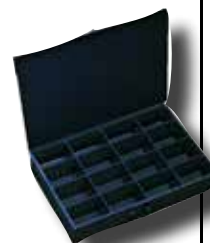
06720
2 ROLOC COATING REMOVAL DISC"



06730
3 ROLOC COATING REMOVAL DISC"



06740
4 ROLOC COATING REMOVAL DISC"



Grinder NOT for use with cut-off wheels over 3" in diameter. Refer to ASTM B7.1-2001



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Super Stripper 4-1/2" Coating Removal Discs

Orange Super Stripper discs feature a tough web of non-flexible synthetic filaments coated with extra-coarse high-performance ceramic grain in an open construction that is very aggressive and non-loading.

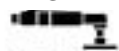
- Unique web and bonded ceramic grit provide faster material removal action on paint, rust and mill scale with virtually no heat build-up.
- The open coat design cleans surfaces without damage.
- Type 27 plastic backing with 7/8 arbor or built-in 5/8-11 thread for strong and secure mounting.

IBS No.	Description	RPM	Qty
06745	4-1/2" x 7/8	11,000	5
06746	4-1/2 x 5/8-11	11,000	5



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Use on
**1/4" 90°Angle
AIR DIE GRINDERS**



for **DEBURRING,
BLENDING &
FINISHING**

Roloc™ Unitized Wheels

Roloc™ unitized wheels are strong, efficient products for edge deburring and finishing. They perform well in a variety of metal working applications and on intricate machined parts where close tolerances are important.

IBS No.	Dia.	Grit	Color	RPM	Qty
06821	2"	Coarse	Tan	22,100	10
06822	2"	Medium	Tan	22,100	10
06823	2"	Fine	Gray	22,100	10

Use IBS Back Up Pad No. 06525 with 2"

06833	3"	Coarse	Coarse	15,100	10
06834	3"	Medium	Medium	15,100	10
06835	3"	Fine	Fine	15,100	10

Use IBS Back Up Pad No. 06535 with 3"

Use IBS Back Up Pad No. 06530 3" 5/8-11 for Angle Grinders



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Hub & Stud Cleaning Disc

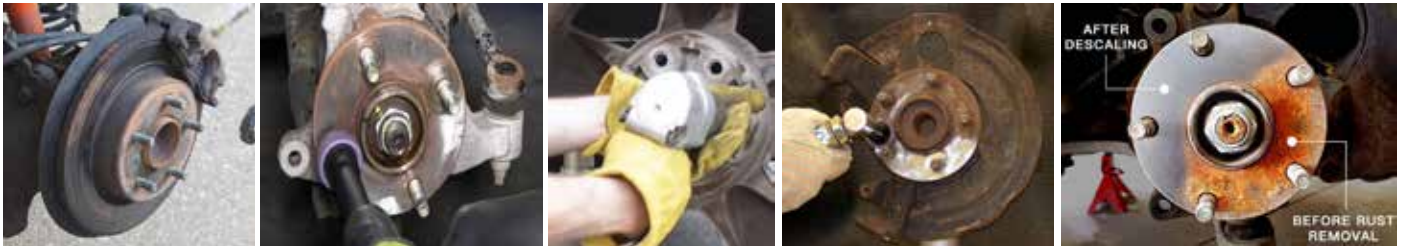


Hub and Stud Cleaning discs and holder combine an aggressive 3-D disc construction with a unique, center hole Roloc™ attachment system for improved productivity. The system removes rust and corrosion quickly, even in hard to reach places. The attachment provides quick disc changes with the convenience of running on high-speed tools. All this adds up to saving time, increasing speed and effectiveness on the brake job.

- **Extremely tough three-dimensional web** removes rust and corrosion without excessive metal removal or gouging of the metal - Saves time and helps to maintain AOEM surface milling marks.
- **Non-metallic attachment system and disc pad holder** are made of tough polymers that will not damage the wheel stud threads - Cleans the area fast while protecting the threads.

- **Unique Roloc™ Attachment System** locks securely with 1/2 turn on and 1/2 turn off and fits over the wheel stud - Saves time, easy to use, works fast.
- Disc Holder is **designed to fit on a variety of tools** with collets or chucks makes it very versatile.
- **Ideal for use on right angle air tools.**
- **Contains no wire filaments** that eliminates the potential for injury from flying wires for safer operation.

IBS No.	Description	Qty
37150	1-1/2 x 5/8 Hub & Stud Cleaning Disc	10
37200	2 x 5/8 Hub & Stud Cleaning Disc	10
37000	Hub & Stud Cleaning Disc Holder	1



Eraser Wheel



- **Quick and easy removal** of decals, pinstripes, bumper stickers, and reflective tapes, etc. from glass, urethane, acrylic paints and OEM painted surfaces.
- **Effectively removes adhesive** tapes and glue from the back of mouldings.
- **Longer lasting and wider than a solid disc** for faster job completion.
- **Toothed wheel works cooler**, causing less smearing.
- **Includes universal arbor** for use with electric or pneumatic tools.
- **Best results at 1,500 - 3,000 RPM. MAX: 4,000 RPM.**

APPLICATION:

Clean the surface thoroughly. Apply light pressure only. Start at the top of the decal and move side to side. For faster results, use the entire width of the wheel, do not tilt on an angle.



IBS No.	Description	Qty
37700	Eraser Wheel	1