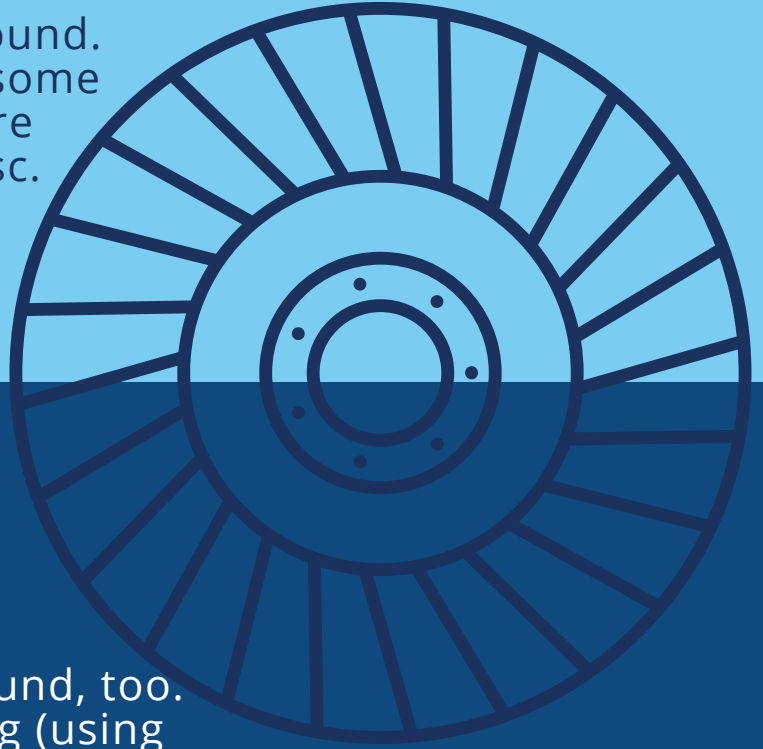


HOW TO CHOOSE ABRASIVES FOR METALWORKING

1. BONDED

Bonded discs are just like they sound. The mineral, binding agent, and some type of reinforcement material are fused together to form a hard disc.



2. COATED

Coated discs are just like they sound, too. They have mineral-coated backing (using some sort of resin, much like glue). They're durable and flexible. They come in many different forms, not just discs.

3. NON-WOVEN

Non-woven are sometimes called by a brand name: Scotch-BriteTM (a 3M proprietary disc). These discs are made up of a fibrous material that the abrasive minerals are adhered to with a resin, similar to a coated disc, but in a more random pattern. They offer great conform-ability, flexibility, cleaning action ease, and add a grain pattern to the work piece.

MINERALS

- **Aluminum Oxide:** Widely used. Cost-effective. Fractures into sharper pieces until it wears down.
- **Silicon Carbide:** Starts out sharp and cuts well. Wears quickly and doesn't always fracture cleanly.
- **Zirconia Alumina:** Combines sharpness and cutting power similar to silicon carbide, but fractures to a sharp edge as it wears.
- **Ceramics:** Combines one or more minerals with ceramic bits for a durable cutting combination that's heat-resistant.
- **Precision Shaped Grain:** Precision Shaped Grain: Ceramic blend that can include 3M's proprietary Cubitron II mineral.

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800.251.7067 | Sales@LaneSupplyCompany.com
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