

NORTON

SAINT-GOBAIN

Transforming
surfaces
...and beyond

SURFACE SOLUTIONS

AUTOMOTIVE BODY-IN-WHITE




SAINT-GOBAIN



AUTOMOTIVE BODY-IN-WHITE MARKET

Body-in-white, which is the stage in the automobile manufacturing process in which a car body's frame has been joined together, before painting or another subassembly, sets the foundation for e-coat, primer, basecoat, and clearcoat. If manufacturers don't identify and remove defects in the body-in-white phase, the paint processes can accentuate imperfections or create paint defects.

Body-in-white consists of two critical machining processes: rough grinding and metal finishing. Rough grinding can include blending mismatch and removing or levelling metal flash, tabs, and excessive tack weld. Metal finishing produces the final finish for the rough grind areas and removes and finishes minor defects (above or below the surface) due to stamping or handling. Defect areas are typically found on bonnets, roofs, doors, wings, quarter panels, and boot lids.

Norton offers products for all steps of the process from fibre discs, flap discs, belts and non-woven products for rough grinding to paper, film and mesh discs for finishing.

ABRASIVE SOLUTIONS FOR AUTOMOTIVE BODY-IN-WHITE



IDENTIFYING, REMOVING, AND FINISHING DEFECTS

The initial step is to identify defects either above or below the surface, followed by initial defect removal and final finishing.



METAL MISMATCH

Removal/levelling of metal flash, tabs, and excessive tack weld.



WELD SPATTER REMOVAL

Remove weld spatter from the surface using mini angle grinder along with coated or non-woven quick-change discs.



ROBOTIC ROOF JOINT GRINDING

Robotic grinding machines are utilised along with Type 1 non-woven abrasive wheels on the brazed weld to take down, finish, and prep for paint.



IDENTIFYING, REMOVING, AND FINISHING DEFECTS

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DIFFERENTIATION IN THE RANGE

We have one of the widest selections of abrasive products to meet every customer requirement. The range is classified into three quality-tiers (good/better/best) to help you choose the right product for your specific application.

GOOD



Our **good** tier products promise great value with great performance you'd expect from Norton, at a competitive price.

BETTER



Our **better** tier products are the right fit when you can't easily measure the value of a best tier product, but still have higher expectations for performance.

BEST



Our **best** tier products are top-of-the-range solutions with an impressive, measurable impact on reduced process cost.



IDENTIFYING, REMOVING, AND FINISHING DEFECTS

The initial step is to identify defects either above or below the surface, it is not a removal process. Use a MeshPower or non-woven hand pad product to identify and highlight surface defects which can be either convex or concave. This will assist the operator for the next defect removal process whether manual or mechanical.

Heavy-weight and coarser grit discs can be used for initial defect removal and lighter weight paper for final finishing.

IDENTIFYING DEFECTS RECOMMENDED PRODUCTS

MESHPOWER™ CERAMIC M920 **+++++**

- The open mesh construction of the backing allows dust particles to flow freely through thousands of tiny holes, creating a virtually dust free sanding environment.
- Ceramic grain provides the highest cutting performance thanks to its microfracturing properties, meaning the abrasive stays sharper and lasts longer than aluminium oxide products
- Self-grip backing for a quick and easy sheet change
- Abrasive can be used wet or dry for the perfect result For best performance, use the corresponding interface pad (see page 16)
- No defined hole pattern saves time and effort aligning holes, just apply and go

DISCS



SIZE (mm)	GRIT	PK QTY	ART NO.
150	60	50	78072712627
	80	50	69957325723
	120	50	69957325730
	180	50	69957325731
	240	50	69957325732
	320	50	69957325733
	400	50	69957325736



ROLLS



DIMENSIONS	GRIT	PK QTY	ART NO.
115 x 10m	60	1	78072712624
	80	1	69957326269
	120	1	69957326270
	180	1	69957326271
	240	1	69957326272
	320	1	69957326273



CUT SHEETS



DIMENSIONS (mm)	GRIT	PK QTY	ART NO.
115x230	80	50	69957326057
	120	50	69957326062
	180	50	69957326063
	240	50	69957326065
	320	50	69957326068



ALTERNATIVE PRODUCTS

GENERAL PURPOSE NON-WOVEN HAND PADS

- Premium aluminium oxide grain for excellent cutting and finishing
- Tough yet conformable to intricate shapes and contours without changing the workpiece dimension
- Non-loading; constant supply of new cutting edges



DIMENSIONS (mm)	GRIT	PK QTY	ART NO.
152.4 x 228.6	VF	60	66261058000

SNAKE DIAMOND HAND PADS

- Durable yet lightweight conformable backing is adaptable to a variety of shapes and conditions with long lasting performance; offers a uniform finish for improved surface quality
- Can be used wet or dry; colour-coded by grit size for easy identification



DIMENSIONS (mm)	GRIT	PK QTY	ART NO.
90 x 55	SNAKE green 60	5	66260376326
	SNAKE black 120	5	66260322698
	SNAKE red 200	5	66260329702
	SNAKE yellow 400	5	66260329704
	SNAKE white 800	5	66260162107
	SNAKE blue 1500	5	66260162113

DEFECT REMOVAL AND FINISHING RECOMMENDED PRODUCTS

BLUE FIRE DISCS NORZON H835 **+++++**

- Latest Norzon grain design with self-sharpening grain for great cut rate & extended product life
- Prevents premature clogging due to open grain distribution
- The best option for coarse sanding and finishing on hard materials
- High strength paper backing with excellent tear resistance and reduced curling & edge chipping



SIZE (mm)

150



GRIT

60

80

120

PK QTY

50

50

100

ART NO.

69957390940

69957391248

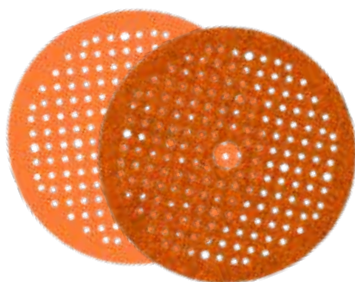
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ALTERNATIVE PRODUCTS

MULTI-AIR® BLAZE PAPER DISCS A995 **+++++**

- P-graded, ceramic aluminium oxide abrasive ensures fast cut rate and unique Norton Multi-Air hole configuration maximises dust extraction for a clean work environment and less contamination; delivers cool, fast, consistent cut rate with a long life
- Unique fiber reinforced, flexible D-weight latex saturated backing provides 50% - 60% improvement in tear strength while retaining flexibility
- Water-based, non-pigmented stearate No-Fil® coating and open coat provide maximum load resistance with no colour transfer to work



SIZE D x H (mm)

150x18



GRIT

40

60

80

120

150

180

220

320

400

PK QTY

50

50

50

50

50

50

50

50

50

ART NO.

78072756399*

78072756400*

78072756402

78072756403

78072756404

78072756405

78072756406

78072756407

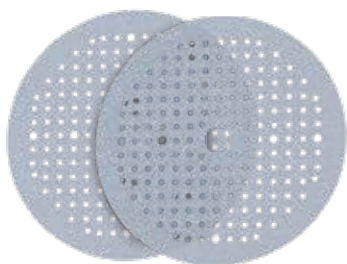
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*Discs P40 and P60 have 33 holes

MULTI-AIR® PLUS PAPER DISCS A975

- P-graded, seeded-gel ceramic alumina abrasive and hole design maximizes dust extraction for clean work environment and less contamination, and delivers a cool, fast, consistent cut rate and longer life than any paper disc
- Unique fiber reinforced, flexible C-weight latex saturated backing delivers 50% - 60% improvement in tear strength while retaining flexibility
- Water-based, non-pigmented stearate No-Fil® coating and open coat provide maximum load resistance with no colour transfer to work



SIZE D x H (mm)	GRIT	PK QTY	ART NO.
125x18	80	50	63642563535
	120	50	63642563536
	150	50	63642563537
	180	50	63642563538
	240	50	63642563540
	320	50	63642563542
	400	50	63642563543
150x18	80	50	63642565916
	120	50	63642523429
	150	50	63642523430
	180	50	63642565920
	220	50	63642523434
	240	50	63642523435
	280	50	63642523436
	320	50	63642523437
	400	50	63642565925



NORaX® DISCS U254

- Engineered micro-structured abrasive exposes sharp abrasive grains to prolong cutting performance, lasting 2-5X longer, with faster cut rate and consistency vs. conventional polishing discs
- High-performance micron-graded aluminium oxide abrasive prevents wild scratches; produces a more repeatable consistent finish from the first to the last part
- Quickly removes grit scratches, part defects, and steps from your polishing process



SIZE (mm)	GRIT	PK QTY	ART NO.
150	80	100	66254493159*
	120	100	66254493172*
	150	100	66254493193*
	180	100	66254452103*
	220	100	66254493195*
	320	100	66254493197*



* Made to order



METAL MISMATCH




Metal mismatch includes removal/levelling of metal flash, tabs and panel mismatch around windows, door and boot openings plus excessive tack weld. Due to the aggressiveness plus high removal rates of the metal mismatch operation, it is imperative that the operator uses a continuous motion when levelling excessive material. This will eliminate the possibility of snagging the product while grinding and over-grinding the area.

RECOMMENDED PRODUCTS

X-TREME FLAP DISCS ^{R860} +++++

- High performance zirconia alumina plus abrasive provide aggressive cut and long life with up to 30% longer life than competitive zirconia alumina products
- Angled, polyester/cotton flaps provide greater surface contact and are the best choice when speed of job completion and stock removal are primary considerations; may be used on contour and edge work






FIBRE GLASS BACKED	SIZE D x H (mm)	GRIT	PK QTY	ART NO.
	115x22 	40	10	78072726071
		60	10	78072726074
		80	10	78072726075
	125x22 	40	10	78072726076
		60	10	78072726077
		80	10	78072726078

NORTON QUANTUM® FLAP DISCS ^{R996} +++++

- Extremely aggressive ceramic grain for noticeably faster cut rate
- Strong polyester backing for demanding work on edges
- Supersize layer for a cooler cut and reduced heat generation during use, providing better part quality and no burn marks
- Especially suitable for high pressure applications on high power angle grinders




FIBRE GLASS BACKED	SIZE D x H (mm)	GRIT	PK QTY	ART NO.
	115x22 	40	10	66254461027
		60	10	66254461029
		80	10	66254461031
	125x22 	40	10	66254445878
		60	10	66254445879
		80	10	66254461033

BLAZE® QUICK CHANGE DISCS R980P

- The best choice for part cut & finish
- Aggressive disc removes all defects quickly
- Provides the coolest cut and significantly faster cut rates
- For the greatest durability, longest life, and edge-fray resistance on tough applications




SIZE (mm)	GRIT	MAX. RPM	PK QTY	TR ATTACHMENT 
50	36	5700 - 13400	50	63642597039
	50	5700 - 13400	50	63642597045
	60	5700 - 13400	50	63642597050
75	36	3800 - 8900	50	63642597053
	50	3800 - 8900	50	63642597057
	60	3800 - 8900	50	63642597060

BLAZE® MINI FLAP DISCS R980P

- Provides longer life compared to any mini flap disc when used on stainless, titanium & super alloys
- Extremely aggressive ceramic grain for noticeably faster cut rate
- Supersize layer applied to the grain for a cooler cut and reduced heat generation during use, providing better part quality and no burn marks

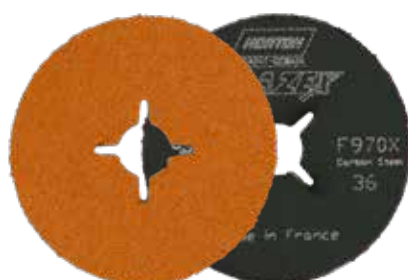


SIZE (mm)	GRIT	MAX. RPM	PK QTY	TR ATTACHMENT 
50	40	5700 - 13400	50	66261120104
	60	5700 - 13400	50	66261120109
75	40	3800 - 8900	50	66261120112
	60	3800 - 8900	50	66261120116

ALTERNATIVE PRODUCTS

BLAZE®X FIBER DISCS F970X

- Ceramic micro-fracturing grain constantly self-sharpen, exposing new sharp edges, for a better cut rate and longer disc life
- Stronger fibre backing provides better face-to-surface grinding, but also resists tearing in heavy-duty applications



SIZE D x H (mm)	GRIT	PK QTY	ART NO.
115x22	36	25	78072718984
	50	25	78072718985
	60	25	78072718986
	80	25	78072718987
125x22	36	25	78072718988
	50	25	78072718989
	60	25	78072718990
	80	25	78072718991

SG FILE BELTS R929

- Made with premium SG abrasive grain
- High content of active filler for cool cut, no burn marks on the metal part
- Excellent performance at low & medium pressure
- X-weight polyester cloth, extremely durable even on aggressive applications



SIZE W x L (mm)	GRIT	PK QTY	ART NO.
10x330	40	50	66623303110
	60	50	66261144369
	80	50	66623303270



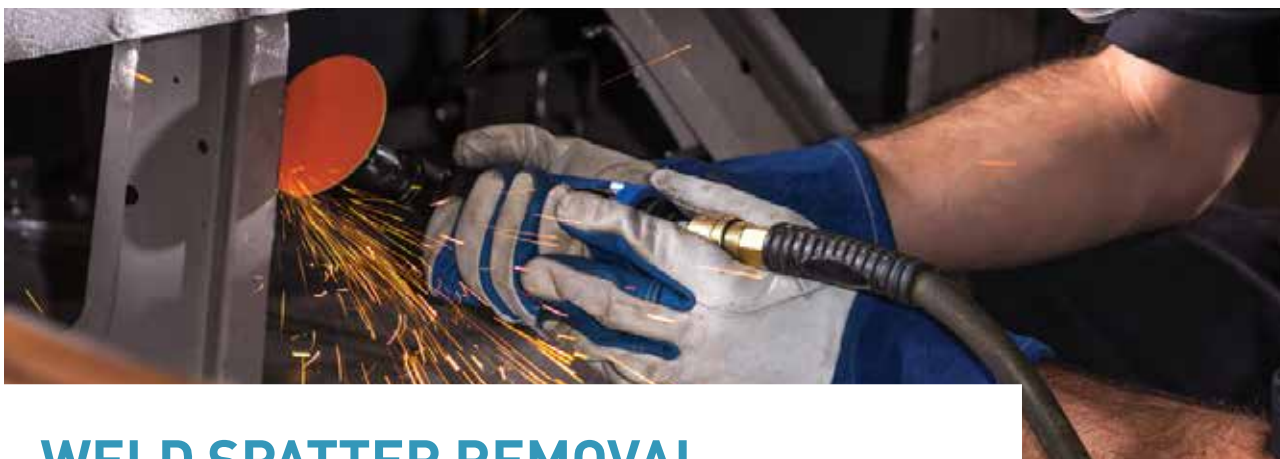
RAPID PREP SURFACE CONDITIONING FILE BELTS

- Premium ceramic blend for superior cut rate and finish on all metal substrates
- Proprietary Clean Bond™ resin system, for increased life and smear-free finishing
- Engineered fibre mesh and backing for improved flexibility and performance



SIZE W x L (mm)	GRIT	PK QTY	ART NO.
10x330	Coarse	10	69957360172
	Medium	10	63642578004
	Very Fine	10	69957360176





WELD SPATTER REMOVAL

Weld spatter can be removed from the surface using a mini angle grinder and coated or non-woven quick-change discs. Designed for blending, breaking edges and removing parting lines and machine marks, the discs are small in diameter, ideal for hard-to-reach areas and mild contours as well as small, flat surfaces.

RECOMMENDED PRODUCTS

BLAZE® RAPID STRIP DEPRESSED CENTRE DISCS TYPE 27 **+++++**

- Blaze lasts up to twice as long as other ceramic discs thanks to the Norton SG grain
- Leaves a thoroughly cleaned surface that ensures excellent adhesion for subsequent processes
- Extremely versatile; stiff enough to withstand aggressive use, soft enough to prevent gouging and rework. Apply pressure to strip or remove coatings; use lighter pressure to finish like a surface finishing disc

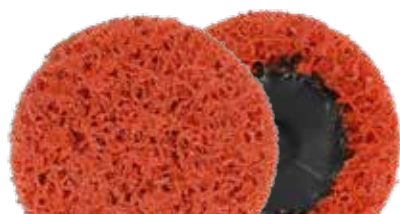


SHAPE	SIZE D x H (mm)	CAP CODE	MAX RPM	PK QTY	ART NO.
	115x22	R9101	12000	10	66623303783
	125x22	R9101	11000	10	66623303916



BLAZE® RAPID STRIP QUICK CHANGE DISCS **+++++**

- Ideal for removing coatings on a variety of surfaces
- With ceramic alumina grain, disc lasts 2x longer than competitor
- Cleans surface thoroughly for excellent adhesion of coatings, painting and soldering
- Withstands aggressive use whilst preventing gouging



DIA (mm)	GRADE	CAP CODE	MAX RPM	PK QTY	TR ATTACHMENT
50	X Coarse SG	R9101	20000	25	66623303912
75	X Coarse SG	R9101	15000	25	66261096557



ALTERNATIVE PRODUCTS

VORTEX® RAPID PREP QUICK CHANGE DISCS

- Gain higher material removal, longer life and consistent, smear-free finishes
- Proprietary engineered Vortex aluminium oxide abrasive grain and coating method combine maximum cutting speed with the consistent finish of finer grades to reduce process times by 50%+ by combining multiple grit sequences into 1 step
- Up to 4x longer life than competitor products, material removal level is maintained throughout disc life, reducing the need for rework & reducing total consumable cost
- The Clean Bond™ resin system ensures surfaces stay smear-free



DIA (mm)	CAP CODE	GRADE	PK QTY	TR ATTACHMENT 
50	S2103	Extra coarse	50	66623378336
	S2203	Coarse	50	66623378340
	S2303	Medium	50	66623378342
	S2403	Fine	50	66623378345
	S2503	Very fine	50	66623378347
75	S2103	Extra coarse	25	66623378337
	S2203	Coarse	25	66623378341
	S2303	Medium	25	66623378343
	S2403	Fine	25	66623378346
	S2503	Very fine	25	66623378348

HIGH STRENGTH BUFFING DISCS

- Tough, yet conformable, resists tearing on burrs and sharp edges
- Follows contours and awkward profiles easily.
- Premium aluminium oxide grain for aggressive blending and cleaning without smearing
- Will not stretch or shed




DIA (mm)	CAP CODE	GRADE	PK QTY	TR ATTACHMENT 
50	F2303	Medium A	50	63642585924
	F2506	Very Fine A	50	08834163987
75	F2303	Medium A	25	08834164065
	F2506	Very Fine A	25	63642585932



Photo courtesy of FerRobotics

ROBOTIC ROOF JOINT GRINDING

During the automotive assembly process, the joints between the car door and roof are brazed together. This process leaves a brazed weld that needs to be taken down, finished, and prepped for paint. To achieve the final finish, robotic grinding machines are utilised along with Type 1 non-woven abrasive wheels. Norton non-woven wheels provide cost savings in this application due to their superior performance and long wheel life.

Rapid Blend unitised wheels can be trued and dressed to the appropriate size and shape needed for each unique application. Contact your Norton representative for availability of truing and dressing products.

RECOMMENDED PRODUCTS

VORTEX® RAPID BLEND UNITISED WHEELS **+++++**

- High-performance, engineered aluminium oxide grain and improved resin bond system provide aggressive, fast, stock removal, reduced cycle times, and excellent part quality
- Thick nylon web delivers 2X longer life and faster finishing – with minimal shedding vs competitive wheels
- Controlled porosity ensures cool cutting and improved cut rate



GRADE	DENSITY	ART NO.
Coarse	soft / medium / hard	upon request
Medium	soft / medium / hard	upon request

RAPID BLEND NEX UNITISED WHEELS **++++**

- Uniform construction provides extra-long life and holds shape well for less wheel dressing
- Smear free resin binder formula provides smear-free finishes
- A great option for light deburring and blending applications



SIZE D x T x H (mm)	GRADE	DENSITY	ART NO.
203 x 4.2 x 25.4	Medium	8	63642581615*

* Made to order



BACK-UP PADS & INTERFACE PADS

Norton offers a variety of back-up pads and interface pads that can be used to optimise products featured in this brochure.

MULTI-AIR® BACK-UP PADS

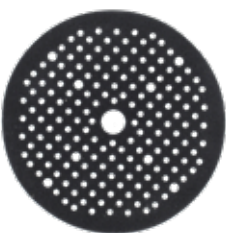


- The Multi-Air back-up pad draws dust into a collection chamber for optimal airflow and powerful dust extraction
- The innovative design delivers high performance and a smoother, unblemished work surface. This is alongside the additional benefit of a clean working environment.



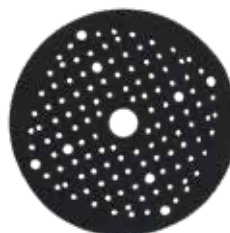
SIZE	DESCRIPTION	PK QTY	ART NO.
125mm	Medium (Suitable for Festool)	1	63642563533
	Medium HT (Compatible with most common brands such as Dynabrade, Rupes, except Festool)	1	66261067436
	Medium HT (Suitable for Festool and Rupes)	1	63642585872
150mm	Medium HT - Fixed screw (Compatible with most common brands such as Dynabrade, Rupes, except Festool. No Adapters & spacers)	1	63642582245
	Hard	1	07660719198

PAD SAVER



SIZE	TYPE	PK QTY	ART NO.
150mm	Multi-Air	16	69957328425

MULTI-AIR® INTERFACE PADS



SIZE	PK QTY	ART NO.
125mm	16	63642585864
150mm	12	07660719359

SELF-GRIP BACK-UP PAD PLAIN



SIZE	TYPE	ART NO.
150mm	5/16" & M8 MEDIUM	66623338436

MULTI-AIR® SANDING BLOCKS

- An in-built air chamber keeps sanding dust-free and the workplace clean
- Robust, impact-resistant plastic body that has been built to last and stand up to the rigours of day-to-day use
- Comfortable rubber grip helps the user maintain control over the process



SIZE (mm)	DESCRIPTION	PK QTY	ART NO.
115 x 230mm	Multi-Air sanding block	1	69957396644
25/30mm x 4m	Attachable hose	1	07660767979

MULTI-AIR® SANDING BLOCK KIT

- Manual sanding block with a set of three self-gripping interchangeable plates: straight, concave and convex
- For use with 150mm Multi-Air discs, in self-grip or SoftTouch
- Kit contains an air valve



SIZE (mm)	DESCRIPTION	PK QTY	ART NO.
150mm	Multi-Air sanding block kit	1	77696024493

QUICK CHANGE DISC HOLDER TR

- TR ATTACHMENT: Roll-on/roll-off system using a nylon threaded male button on a pad (TR) with spindle



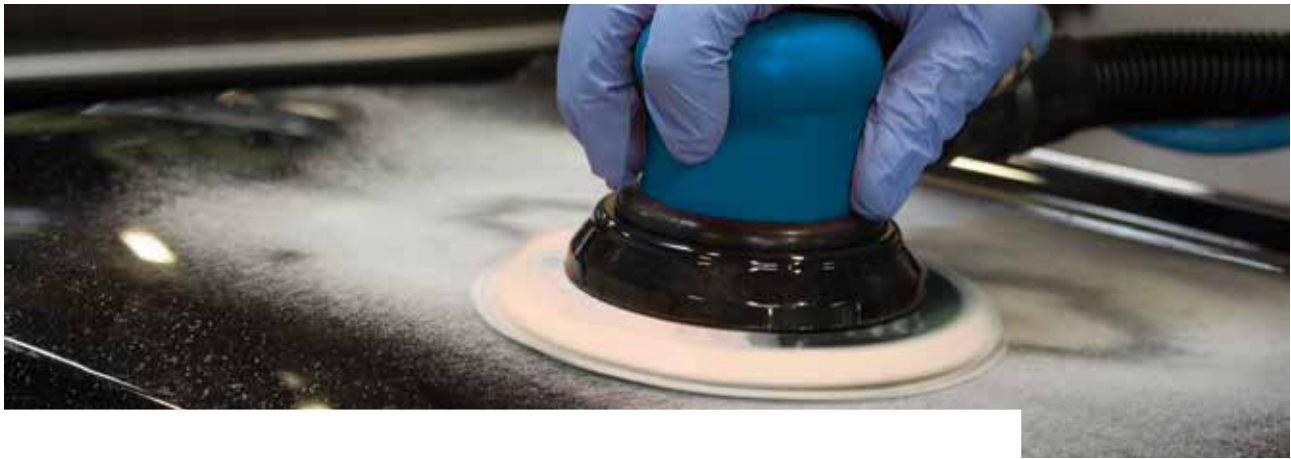
DIA (mm)	MEDIUM	HARD	PK QTY
50mm	07660717817	63642586931	1
75mm	63642556631	66254401460	1

NYLON FIBERGLASS REINFORCED BACK-UP PAD

- The curved ribs keep the pad and abrasive cooler while retaining a level of flexibility across the pad
- For tougher grinding operations
- Conforms ISO 15636
- Grits 36+ and finer



SIZE (mm)	THREAD	DENSITY	MAX RPM	PK QTY	ART NO.
125	M14	Rigid	12200	5	66623376821



MACHINES

Norton offers a range of grinding, sanding and vacuum machines to maximise results when used with Norton abrasives. By offering a full solution, Norton adds true value to many of the applications found in the body-in-white process.

DUAL ACTION SANDER PNEUMATIC (D.A.S.P)

- Compact, lightweight and ergonomic sander designed to reduce vibration and hand/arm fatigue when used over long periods, for better sanding control
- Available in two rotational orbit sizes; 5mm for faster sanding and 2.5mm for an excellent finish
- Includes a 360° adjustable muffler-cap to reduce sharp noise and a metal-muffler inside to reduce oil accumulation designed to ensure smooth running and extend machine life
- 12,000rpm, adjustable speed, best sanding results are achieved when used with the Multi-Air back-up pad, that is included inside the box



MODEL	PAD SIZE	DIA. ORBIT	VACUUM	WEIGHT	ART NO.
150/2.5	152mm	2.5mm	Central vacuum	710g	78072723484
150/5.0	152mm	5mm	Central vacuum	750g	78072723478

VACUUM SYSTEM CV4E

- A reliable, mobile and effective vacuum, that can be used with or without power tools
- Powerful vacuum technology with automatic filter cleaning system
- User friendly control panel and NONSTOPVAC! system ensures constant vacuuming significantly reducing downtime and maintaining high suction performance
- Very practical accessory organisation directly on the vacuum thanks to holder, supports and compartments



DESCRIPTION	VOLUME	FILTER CLASS	DIMENSIONS	WEIGHT	ART NO.
CV4E 40:M	40 L	M (medium hazard)	625 x 385 x 545mm	21kg	78072754268

PNEUMATIC MODULE KIT

- Allows the connection of pneumatic tools to the vacuum
- Easy to install directly under the control panel
- Use a co-axial pneumatic hose to complete the system compartments



DESCRIPTION	QTY IN KIT	ART NO.
Pneumatic module kit	1	78072755387

VACUUM SYSTEM ACCESSORIES

- Accessories for Norton Vacuum System CV4
- Suitable for electric (E) & pneumatic (P) option
- All hoses are suitable for most common vacuums
- Antistatic accessories protect against any electric shocks that may occur during use



DESCRIPTION	APPLICATION	TYPE/DIMENSIONS	PK QTY	ART NO.
Fleece filter bags	For vacuum CV4E/P		10	78072756715
PE bag	For vacuum CV4E/P		1	78072756716
Co-axial pneumatic hose	For vacuum	Length: 5m, Dia: 29mm	1	78072757452
Co-axial pneumatic hose	For vacuum	Length: 7m, Dia: 29mm	1	78072757454
Co-axial hose	For vacuum	Length: 10m, Dia: 29mm	1	78072757455
"Y" Connector	For connecting 2 Tools to a vacuum	Suitable for hoses Dia 29mm	1	78072757457

STRAIGHT CUT OFF TOOL

- Designed for quick cutting in collision repair applications
- Machine is delivered with a fixed safety guard and a soft grip for comfortable use.
- Lightweight, only 0.8kg
- Low noise and low air consumption



DIMENSIONS	TOOL WEIGHT	FREE SPEED	RECOMMENDED OPERATING PRESSURE	ART NO.
180x86x75mm	0,80 kg	25000rpm	6.2 bar	66623391379

PNEUMATIC FILE BELT SANDER

- The Norton pneumatic file belt sander makes life easier when used in hard to reach and awkward applications and areas
- Use with Norton file belts for stock removal, deburring or surface preparation and defect removal on corners, contours and tight areas
- Small but powerful file belt sander with 0,5 hp motor, for a mighty output
- Ergonomic soft grip improves manoeuvrability and reduces operator fatigue



BELT SIZE	HORSEPOWER	FREE SPEED	RECOMMENDED OPERATING PRESSURE	TOOL WEIGHT	ART NO.
10x330mm	0,5	18.000rpm	6,2 bar	0,82 kg	77696091766

MINI ANGLE GRINDER

- Compact, lightweight and ideal for use in small or awkward areas
- The SpeedLok quick change system means discs can be changed quickly, reducing downtime and speeding up the job



EXHAUST DIRECTION	THROTTLE TYPE	AIR CONSUMPTION	COLLECT CHNK	TOOL WEIGHT	ART NO.
Rear	Level	85 l/min	6mm	0,742 kg	66261177765

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