

**NORTON**

SAINT-GOBAIN

**CATALOG #8923**

ABRASIVE PRODUCTS FOR  
**RIGHT ANGLE  
GRINDERS**



## Our Mission

We offer powerful, precise, user-friendly solutions, which enable our customers to cut, shape and finish all materials even in the most complex and challenging applications. By working closely with end-users and our grinding expert partners, we design and provide customized solutions to secure the best option for performance, cost and safety.

## Our Expertise

Norton is the leading brand of Saint-Gobain Abrasives, with more than 135 years of experience in manufacturing abrasives.

We are committed to providing access to our expert's knowledge whenever you need it. Whether it is through our [Process Solutions Program \(PSP\)](#), ongoing training programs, or through on-line expert articles and white papers you can stay up-to-date with Norton where and when you need it.

Bring us your grinding challenges, we have solutions!

## Our Commitment

You be the final judge in performance! We are so confident of the superior performance of our abrasive products, as recommended for specific applications, that we invite in-plant tests against any other brand of abrasive product on the market. Contact your Norton Representative to find out more about our No Risk test policy or visit [www.nortonabrasives.com](http://www.nortonabrasives.com)



**NO-RISK TEST**

## Why Tiers Matter

At Norton we believe in delivering right choices that matter. Our abrasives are classified in BEST, BETTER, and GOOD performance/price tiers to help you choose the right product for your specific application every time.

### BEST

Our BEST tier products are designed for the customer who is seeking the highest productivity at the lowest total cost.

### BETTER

Our BETTER tier products provide an excellent blend of performance and price.

### GOOD

And, our GOOD tier products promise the highest quality you expect from the Norton name with a low initial price.

If you need help determining the right tier for your specific needs, don't hesitate to contact us directly or reach out to your Norton sales representative.

## Go Further

Visit our website at [www.nortonabrasives.com](http://www.nortonabrasives.com) for a more comprehensive outline of products, safety and application information. We continually update it with our most current information.

Connect with us:





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## Color-Coded Application Steps

The color-coded chart of metal fabrication operations represents the eight key application processes found in metal fabrication today, where right angle grinders are most commonly used.

It is referenced on each page, providing a 'best product' solution for each application to help you understand which one you need.



### CUTTING

Cutting wheel for correct dimensioning.

### HEAVY-DUTY GRINDING

Grinding wheel for heavy stock removal of welds, burrs or beveling.

### STOCK REMOVAL

FLAP DISCS: Remove heavy weld seams and excess material. Long product life.

FIBER DISCS: Remove excess material from flat and contoured surfaces.

### BLENDING & REFINING

Impart a uniform finish.

### DEBURRING

Remove burrs, radiusing and break sharp edges.

### SURFACE PREP & CLEANING

Remove dirt, rust or corrosion and prepare surface prior to coating or welding.

### FINISHING

Reduce surface roughness, apply a cosmetic finish, prepare for polishing.

### POLISHING

Final step to provide a high gloss finish.

## Grit Application Table

The table below shows the grit overlap for each product type and every stage of the application process.

Coarse (Grinding)						Fine (Finishing)				
GRIT OR GRADE	EXTRA COARSE					COARSE	MEDIUM	FINE	VERY FINE	NON-ABRASIVE
	20	36	40	50	60	80	120	150-180	180-240	0
Cutting and Grinding Wheels	Cutting									
	Heavy-Duty Grinding									
Coated and Non-Woven	Stock Removal									
						Blending & Refining				
						Deburring				
							Surface Prep & Cleaning			
								Finishing		
								Polishing		

## Understanding the Application Matrix

For each of the eight key application processes, the Application Matrix provides a product selection guide. Divided by material and cost requirement (performance or economy), the guide provides a recommendation for selecting the perfect product solution at every stage.

Application:

Identify your application from each of the eight color-coded stages of the process.

Material:

Select from stainless steel, carbon steel and aluminium, depending on your work material.

Product Requirement:

Choose between innovative products providing exceptionally high performance and alternative economy solutions.

Product Solution:

Our recommendation to direct you to the best product for your application needs.



## Process-to-Product Recommendation – Carbon Steel

RIGHT ANGLE GRINDER PROCESS		CARBON STEEL	
		PERFORMANCE	ECONOMY
	CUTTING	<b>Norton Quantum3 Wheels</b> <ul style="list-style-type: none"> <li>Reduced vibration for enhanced comfort and less fatigue</li> <li>Sharper grain for a quicker cut</li> <li>Longer disc life reduces downtime and waste</li> </ul>	<b>Norton Gemini Wheels</b> <ul style="list-style-type: none"> <li>Good cutting performance</li> <li>Straight and quick cuts</li> </ul>
	HEAVY-DUTY GRINDING	<b>Norton Quantum3 Wheels</b> <ul style="list-style-type: none"> <li>Ceramic grain for the highest material removal rate</li> <li>Significant savings in time and productivity</li> <li>High performance in rough applications</li> </ul>	<b>Norton Gemini Wheels</b> <ul style="list-style-type: none"> <li>Ideal for general-purpose grinding</li> <li>Good product life and metal removal rate</li> <li>Consistent performance</li> </ul>
	STOCK REMOVAL	<b>Norton BlueFire R860 Flap Discs</b> <ul style="list-style-type: none"> <li>Self-sharpening zirconia grain removes burrs and material quickly through life of the disc</li> </ul> <b>Norton BlazeX F970 Fiber Discs</b> <ul style="list-style-type: none"> <li>Good, regular cut rate</li> <li>Ceramic alumina grain is self-sharpening for a consistent cut</li> </ul>	<b>Norton Metal R828 Flap Discs</b> <ul style="list-style-type: none"> <li>Self-sharpening zirconia alumina grain removes burrs and material quickly through life of the disc</li> </ul> <b>Norton Metal F240 Fiber Discs</b> <ul style="list-style-type: none"> <li>Tough and versatile aluminum oxide abrasive fiber discs for processing steel and metal alloys</li> </ul>
	BLENDING & REFINING	<b>Norton Vortex Rapid Blend Discs</b> <ul style="list-style-type: none"> <li>Cut and finish with one disc</li> <li>Engineered grain removes light weld beads and spatter, deburrs and can also impart a smooth finish</li> <li>Long disc life and comfortable to use thanks to the non-woven structure</li> </ul>	<b>Norton Rapid Prep (SCM) Discs</b> <ul style="list-style-type: none"> <li>Good performance and life</li> <li>Open structure resists loading</li> <li>Can be used for applications from deburring to finishing</li> </ul>
	DEBURRING	<b>Norton Vortex Rapid Blend Discs</b> <ul style="list-style-type: none"> <li>Vortex grain cuts in coarse grades and finishes in fine grades</li> <li>Clean bond technology prevents smearing and loading</li> <li>Creates a burr-free surface faster</li> </ul>	<b>Norton Rapid Prep (SCM) Discs</b> <ul style="list-style-type: none"> <li>Good performance</li> <li>Open structure resists loading</li> <li>Coarse grades available for deburring</li> </ul>
	SURFACE PREP & CLEANING	<b>Norton Blaze Rapid Strip Discs</b> <ul style="list-style-type: none"> <li>High performance ceramic grain for 2x faster cut and longer life</li> <li>Surface condition, strip and clean with one disc, without gouging the surface</li> </ul>	<b>Norton Rapid Strip Discs</b> <ul style="list-style-type: none"> <li>Aggressive, controlled cut</li> <li>Easy cleaning without loading</li> <li>Ideal for general-purpose use on a variety of metals</li> </ul>
	FINISHING	<b>Norton Rapid Blend NEX-SF Discs</b> <ul style="list-style-type: none"> <li>Imparts a high quality, shiny surface finish</li> <li>Ideal choice for finishing prior to polishing and paint preparation</li> <li>Open structure resists loading</li> </ul>	<b>Norton Rapid Prep (SCM) Discs</b> <ul style="list-style-type: none"> <li>Medium to fine grades for finishing and pre-polishing</li> </ul>
	POLISHING	<b>Norton Rapid Polish Discs</b> <ul style="list-style-type: none"> <li>Felt wool polishing pad for a high shine finish</li> <li>Use with or without polishing compound or paste</li> </ul>	



## Process-to-Product Recommendation – Stainless Steel

RIGHT ANGLE GRINDER PROCESS		STAINLESS STEEL	
		PERFORMANCE	ECONOMY
	CUTTING	<b>Norton Quantum3 Wheels</b> <ul style="list-style-type: none"> <li>Reduced vibration for enhanced comfort</li> <li>Sharper grain for a quicker cut</li> <li>Longer disc life reduces downtime and waste</li> </ul>	<b>Norton Gemini Stainless Steel Wheels</b> <ul style="list-style-type: none"> <li>Good cutting performance</li> <li>Straight and quick cuts</li> </ul>
	HEAVY-DUTY GRINDING	<b>Norton Quantum3 Wheels</b> <ul style="list-style-type: none"> <li>Ceramic grain for the highest material removal rate</li> <li>Reduced vibration for enhanced comfort</li> <li>Easy to steer and control</li> </ul>	<b>Norton Gemini Wheels</b> <ul style="list-style-type: none"> <li>Ideal for general-purpose grinding</li> <li>Good product life and metal removal rate</li> <li>Consistent performance</li> </ul>
	STOCK REMOVAL	<b>Norton Blaze R980P Flap Discs</b> <ul style="list-style-type: none"> <li>Ceramic abrasive for maximum performance</li> <li>Aggressive, consistent and cooler cut</li> <li>Long product life compared to standard discs</li> </ul> <b>Norton BlazeX F980 Fiber Discs</b> <ul style="list-style-type: none"> <li>Premium ceramic abrasive delivering a smooth, fast cut</li> <li>Cooler cuts, dissipates heat with Cool Friction Technology</li> <li>Long product life compared to standard discs</li> </ul>	<b>Norton Metal R828 Flap Discs</b> <ul style="list-style-type: none"> <li>Ideal for mid- to heavy-duty applications on stainless steel</li> <li>High and regular cut rate</li> </ul> <b>Norton Metal F240 Fiber Discs</b> <ul style="list-style-type: none"> <li>Aluminum oxide abrasive with self-sharpening effect</li> <li>Good cut rate</li> </ul>
	BLENDING & REFINING	<b>Norton Vortex Rapid Blend Discs</b> <ul style="list-style-type: none"> <li>Cut and finish with one disc</li> <li>Engineered grain removes light weld beads and spatter, deburrs and imparts a smooth finish</li> <li>Long disc life and comfortable to use</li> </ul>	<b>Norton Rapid Prep (SCM) Discs</b> <ul style="list-style-type: none"> <li>Good performance</li> <li>Open structure resists loading</li> <li>Coarse grades available for deburring</li> </ul>
	DEBURRING	<b>Norton Vortex Rapid Blend Discs</b> <ul style="list-style-type: none"> <li>Vortex grain cuts in coarse grades and finishes in fine grades</li> <li>Clean bond technology prevents smearing and loading</li> <li>Creates a burr-free surface faster</li> </ul>	<b>Norton Rapid Prep (SCM) Discs</b> <ul style="list-style-type: none"> <li>Good performance</li> <li>Open structure resists loading</li> <li>Coarse grades available for deburring</li> </ul>
	SURFACE PREP & CLEANING	<b>Norton Blaze Rapid Strip Discs</b> <ul style="list-style-type: none"> <li>High performance Ceramic grain for 2x faster cut and longer life</li> <li>Surface condition, strip and clean with one disc, without gouging the surface</li> </ul>	<b>Norton Rapid Strip Discs</b> <ul style="list-style-type: none"> <li>Aggressive, controlled cut</li> <li>Easy cleaning without loading</li> <li>Ideal for general-purpose use on a variety of metals</li> </ul>
	FINISHING	<b>Norton Rapid Blend NEX-SF Discs</b> <ul style="list-style-type: none"> <li>Imparts a high quality, shiny surface finish</li> <li>Ideal choice for finishing prior to polishing and paint preparation</li> <li>Open structure resists loading</li> </ul>	<b>Norton Rapid Prep (SCM) Discs</b> <ul style="list-style-type: none"> <li>Medium to fine grades for finishing and pre-polishing</li> </ul>
	POLISHING	<b>Norton Rapid Polish Discs</b> <ul style="list-style-type: none"> <li>Felt wool polishing pad for a high shine finish</li> <li>Use with or without polishing compound or paste</li> </ul>	

## Process-to-Product Recommendation – Aluminum

RIGHT ANGLE GRINDER PROCESS		ALUMINUM	
		PERFORMANCE	ECONOMY
	CUTTING	<a href="#">Norton Gemini Aluminum Wheels</a> <ul style="list-style-type: none"> <li>No clogging, even on soft metal</li> <li>Sharp aluminum oxide grain for fast and clean cuts</li> </ul>	
	HEAVY-DUTY GRINDING	<a href="#">Norton Gemini Aluminum Wheels</a> <ul style="list-style-type: none"> <li>Sharp aluminum oxide grain enables fast material removal</li> <li>Reduces clogging during grinding</li> <li>Achieves a smooth finish</li> </ul>	
	STOCK REMOVAL	<a href="#">Norton BlueFire R860 Flap Discs</a> <ul style="list-style-type: none"> <li>Self-sharpening zirconia grain removes burrs and material quickly through life of the disc</li> </ul> <a href="#">Norton BlueFire F826P Fiber Discs</a> <ul style="list-style-type: none"> <li>Zirconia alumina grain offers fast cut and long life</li> </ul>	<a href="#">Norton Metal R828 Flap Discs</a> <ul style="list-style-type: none"> <li>Durable aluminum oxide abrasive grain</li> <li>Good material removal on low- or medium-power angle grinders</li> </ul> <a href="#">Norton Metal F240 Fiber Discs</a> <ul style="list-style-type: none"> <li>Aluminum oxide grain for good cut rate on soft aluminum alloys</li> </ul>
	BLENDING & REFINING	<a href="#">Norton Vortex Rapid Blend Discs</a> <ul style="list-style-type: none"> <li>Cut and finish with one disc</li> <li>Engineered grain removes light weld beads and spatter, deburrs and can also impart a smooth finish</li> <li>Long disc life and comfortable to use</li> </ul>	<a href="#">Norton Rapid Prep (SCM) Discs</a> <ul style="list-style-type: none"> <li>Good performance and life</li> <li>Open structure resists loading</li> <li>Various grades available for different blending styles</li> </ul>
	DEBURRING	<a href="#">Norton Bear-Tex High-Strength Discs</a> <ul style="list-style-type: none"> <li>Open structure prevents loading when deburring</li> <li>High-strength nylon material conforms to contours throughout the life of the disc</li> </ul>	<a href="#">Norton Rapid Prep (SCM) Discs</a> <ul style="list-style-type: none"> <li>Good performance</li> <li>Open structure resists loading</li> <li>Coarse grades available for deburring</li> </ul>
	SURFACE PREP & CLEANING	<a href="#">Norton Bear-Tex High-Strength Discs</a> <ul style="list-style-type: none"> <li>Durable construction for fast surface preparation and cleaning</li> <li>Imparts a good surface for final finishing operations</li> </ul>	<a href="#">Norton Rapid Strip Discs</a> <ul style="list-style-type: none"> <li>Aggressive, controlled cut</li> <li>Easy cleaning without loading</li> <li>Ideal for general-purpose use on a variety of metals</li> </ul>
	FINISHING	<a href="#">Norton Rapid Blend NEX Discs</a> <ul style="list-style-type: none"> <li>Imparts a high quality, shiny surface finish</li> <li>Ideal choice for finishing prior to polishing and paint preparation</li> </ul>	<a href="#">Norton Vortex Rapid Prep (SCM) Discs</a> <ul style="list-style-type: none"> <li>Medium to fine grades for finishing and pre-polishing</li> </ul>
	POLISHING	<a href="#">Norton Rapid Polish Discs</a> <ul style="list-style-type: none"> <li>Felt wool polishing pad for a high shine finish</li> <li>Use with or without polishing compound or paste</li> </ul>	

# FINISHING MADE EASY



## Everything You Need To Achieve a Better Finish

Pick up everything you need to improve a finish on carbon, aluminum, titanium and stainless steel. Take the guess work out of the finishing process. Follow these simple steps to obtain a single digit Ra or #4 finish.

- Two different versions. One for 7/8" hole and the other 5/8"-11 spin-on hub, each tray can hold up to eight discs depending on the type
- Easy assembly and compact for that last minute impact purchase
- Engaging graphics showing the discs needed, each step and expected Ra finish all in one display
- Durable metal base with rubber feet for long counter life

PART #	DESCRIPTION	STD. PKG.
<b>7/8" Hole Coated &amp; Non-woven Discs #4 Finish Counter Display</b>		
00410138206	4-1/2" x 7/8" Non-Woven Disc #4 Finish Counter Display	1
<b>Order the following to fit the 7/8" Hole Coated &amp; Non-Woven Discs #4 Finish Counter Display</b>		
66261183487	Blaze R980P 40 Grit Flap Disc	10
66263303783	Blaze Rapid Strip Disc	10
66254429268	Vortex Rapid Blend Disc	10
66261020546	Rapid Blend NEX Disc	10
<b>5/8"-11 Hole Coated &amp; Non-Woven Discs #4 Finish Counter Display</b>		
00410138325	4-1/2" x 5/8"-11 Non-Woven Disc #4 Finish Counter Display	1
<b>Order the following to fit the 5/8"-11 Hole Coated &amp; Non-Woven Discs #4 Finish Counter Display</b>		
66261183491	Blaze R980P 40 Grit Flap Disc	10
66254498101	Blaze Rapid Strip Disc	10
66254429243	Vortex Rapid Blend Disc	10
66261023947	Rapid Blend NEX Disc	10



19-1/2"W x 8-1/4"D x 13-1/2"H



## Weld Preparation and Finishing In 4 Steps – Carbon Steel

### STEP 1 – CUTTING

Norton Quantum3 cutting wheels are easy to use, easy to steer and deliver consistent results. Thanks to the sharp ceramic grain which cuts with ease through the metal, Quantum3 reduces vibration on the surface, making cutting more comfortable.



#### Quantum3 Ceramic Alumina Cut-off Wheels

- 100% next-generation, uniquely-shaped, ceramic alumina abrasive grain and tough new bond system result in 5-6 times the life of aluminum oxide wheels and up to 100% increase in performance and life over competitive ceramic wheels
- Significantly increase production, for the lowest total grinding cost of any wheel in the market today
- Better operator control, improved comfort, and exceptional finished part quality with a more robust, sharper, yet smoother cutting action; wheels don't grab or dig

TIER: **BEST** **BEST**  
TRADENAME: **QUANTUM3** **QUANTUM3**  
ABRASIVE: Ceramic Alumina Ceramic Alumina  
SHAPE: Type 01/41 Type 27/42

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #
<b>Quantum3 RightCut Cut-Off – Type 01/41 and 27/42</b>				
4-1/2 x .045 x 7/8	13,580	25	662528 <b>38454</b>	
4-1/2 x 1/16 x 5/8-11	13,580	10		662528 <b>38457</b>
4-1/2 x 1/16 x 7/8	13,580	25	662528 <b>38455</b>	662528 <b>38456</b>
5 x .045 x 7/8	12,225	25	662528 <b>38460</b>	
5 x 1/16 x 7/8	12,225	25	662528 <b>38462</b>	662528 <b>38464</b>
6 x 1/16 x 5/8-11	10,185	10		662528 <b>46246</b>
6 x 1/16 x 7/8	10,185	25	662528 <b>38465</b>	662528 <b>38466</b>



TIER: **GOOD** **GOOD**  
TRADENAME: **GEMINI** **GEMINI**  
ABRASIVE: Aluminum Oxide Aluminum Oxide  
SHAPE: Type 01/41 Type 27/42

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #
<b>Gemini RightCut Cut-Off – Type 01/41 and 27/42</b>				
4-1/2 x .045 x 5/8-11	13,590	10		662528 <b>42025</b>
4-1/2 x .045 x 7/8	13,580	25	662528 <b>23602</b>	662528 <b>42026</b>
4-1/2 x 3/32 x 7/8	13,580	25	662528 <b>23599</b>	
5 x .045 x 5/8-11	12,225	10		662528 <b>41939</b>
5 x .045 x 7/8	12,225	25	662528 <b>23603</b>	662528 <b>42036</b>
5 x 3/32 x 7/8	12,225	25	662528 <b>23600</b>	
6 x .045 x 5/8-11	10,185	10		662528 <b>30587</b>
6 x .045 x 7/8	10,185	25	662528 <b>23604</b>	662528 <b>42202</b>
6 x 3/32 x 7/8	10,185	25	662528 <b>23601</b>	
7 x .045 x 7/8	8,600	20	662528 <b>32323</b>	662529 <b>12626</b>
9 x .045 x 5/8-11	6,600	10		662530 <b>19115</b>
9 x .045 x 7/8	6,600	10		662530 <b>17734</b>

#### Gemini Aluminum Oxide Cut-off Wheels

- Quality aluminum oxide for consistent performance at an economical price
- Designed for portable cut-off tool applications where a fast cut and minimum material loss are desired
- Durable bond designed for fast cut while retaining excellent wheel life

See Norton Catalog #7364 – Abrasive Products for the Welding and Metal Fabrication Market for a complete offering of our products.

## Weld Preparation and Finishing In 4 Steps – Carbon Steel

### STEP 2 – CLEANING

Norton Blaze Rapid Strip non-woven discs are best used at a 10-15° angle to quickly eliminate unwanted coatings and corrosion, with minimal stock removal. It's a truly versatile product, as you can achieve a more aggressive action as you increase the pressure. It's comfortable to use without damaging or gouging components.



#### Blaze Rapid Strip Ceramic Alumina Non-Woven Depressed Center Discs

- Blaze ceramic grain provides 2X plus faster, consistent rate and life than silicon carbide discs, leaves a thoroughly cleaned surface, ensuring excellent adhesion in subsequent processes such as painting and soldering
- Open web construction for minimal loading; does not shed or snag on rusty pieces; prevents gouging and rework
- Rapid Strip material provides a unique combination of aggressive performance, long life, and improved finish

TIER: **BEST**  
TRADENAME: **BLAZE RAPID STRIP**  
ABRASIVE: Ceramic Alumina  
GRADE: X-Coarse 36-50 grit  
TYPE/BACKING: Type 27/Fiberglass

SIZE (D x H)	MAX. RPM	STD. PKG.	PART #
<b>Blaze Rapid Strip Non-Woven Depressed Center Discs</b>			
4-1/2 x 5/8-11	12,000	10	662544 <b>98101</b>
4-1/2 x 7/8	12,000	10	666233 <b>03783</b>
5 x 5/8-11	11,000	10	666233 <b>03915</b>
5 x 7/8	11,000	10	666233 <b>03916</b>
7 x 5/8-11	8,000	10	666233 <b>03919</b>
7 x 7/8	8,000	10	666233 <b>03920</b>

### STEP 3 – BEVELING

Norton BlazeX F970 fiber discs in 36 grit combined with a hard serrated back-up pad is the best option for beveling edges. It'll remove material quickly, and the flat contact area makes it easy to control and help generate the required angle.

For bevel preparation requiring heavy stock removal or dimensioning, Norton Quantum3 or Gemini grinding wheels offer great results.



#### BlazeX F970 Ceramic Alumina Fiber Discs

- Improved ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to significantly increase cut rate and life over competitive blended/low-ratio ceramic alumina discs
- Heavier fiber backing for additional strength and tear resistance
- Non-supersized design for cool cutting and long life on carbon steel and other soft-to-grind materials

TIER: **BEST** **BEST**  
TRADENAME: **BLAZEX F970** **BLAZEX F970**  
ABRASIVE: Ceramic Alumina Ceramic Alumina

SIZE (D x H)	GRIT	STD. PKG.	PART #	PART #
<b>BlazeX F970 Fiber Discs – Standard Hole</b>				
4-1/2 x 7/8	36	25	699573 <b>70193</b>	
5 x 7/8	36	25	699573 <b>70197</b>	
7 x 7/8	36	25	699573 <b>70201</b>	
<b>BlazeX F970 Fiber Discs – Speed-Change</b>				
4-1/2 x 5/8-11	36	25		699573 <b>70205</b>
5 x 5/8-11	36	25		699573 <b>70209</b>
7 x 5/8-11	36	25		699573 <b>70213</b>

See Norton Catalog #7364 – Abrasive Products for the Welding and Metal Fabrication Market for a complete offering of our products.



## Weld Preparation and Finishing In 4 Steps – Carbon Steel

### STEP 4 – WELD SEAM REMOVAL

For thick carbon steel weld seams Norton Quantum3 or Gemini grinding wheels are an ideal starting choice to make light work of heavy weld removal.

After welding use a Norton BlueFire R860 flap disc in 60 grit to quickly remove the weld seam and generate a finish ready for paint or other surface coatings.



#### Quantum3 Ceramic Alumina Depressed Center Wheels

- 100% next-generation, uniquely-shaped, ceramic alumina abrasive grain and tough new bond system result in 5-6 times the life of aluminum oxide wheels and up to 100% increase in performance and life over competitive ceramic wheels
- Significantly increase production, for the lowest total grinding cost of any wheel in the market today
- Better operator control, improved comfort, and exceptional finished part quality with a more robust, sharper, yet smoother cutting action; wheels don't grab or dig

TIER:	<b>BEST</b>	<b>GOOD</b>
TRADENAME:	<b>QUANTUM3</b>	<b>GEMINI</b>
ABRASIVE:	Ceramic Alumina	Aluminum Oxide
SHAPE:	Type 27	Type 27

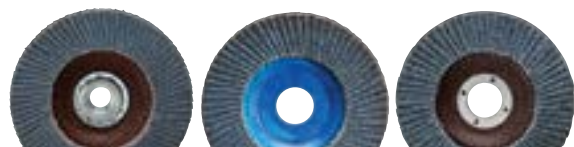
SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #
<b>Depressed Center Grinding Wheels – Type 27 Grinding</b>				
4-1/2 x 1/4 x 5/8-11	13,580	10	662533 <b>70793</b>	662528 <b>43593</b>
4-1/2 x 1/4 x 7/8	13,580	25	662533 <b>70794</b>	662528 <b>43594</b>
5 x 1/4 x 5/8-11	12,225	10	662533 <b>70795</b>	662528 <b>43597</b>
5 x 1/4 x 7/8	12,225	25	662533 <b>70796</b>	662528 <b>43598</b>
6 x 1/4 x 5/8-11	10,185	10	662533 <b>70797</b>	662528 <b>32390</b>
6 x 1/4 x 7/8	10,185	25	662533 <b>70798</b>	662528 <b>01865</b>
7 x 1/4 x 5/8-11	8,600	10	662533 <b>70799</b>	662529 <b>40147</b>
7 x 1/4 x 7/8	8,600	25	662533 <b>70800</b>	662529 <b>40098</b>
9 x 1/4 x 5/8-11	6,600	10	662533 <b>70801</b>	662529 <b>49105</b>
9 x 1/4 x 7/8	6,600	25	662533 <b>70802</b>	662530 <b>49077</b>

#### Gemini Aluminum Oxide Depressed Center Wheels

- Quality aluminum oxide for consistent performance at an economical price
- High-performance bond and wheel hardness are designed for fast cut while retaining excellent wheel life
- Versatile, general purpose specification for use on variety of materials including 400 series stainless, hard carbon steels, soft carbon steels

#### BlueFire R860 Zirconia Alumina Flap Discs

- High performance zirconia alumina abrasive for aggressive cut and long life, with up to 30% longer life than competitive zirconia alumina products
- Polyester/cotton flaps with semi-open coat provide improved durability and reduces loading on aluminum
- High-strength fiberglass back is durable, lightweight, and absorbs vibration; blue, Quick Trim back plate allows for trimmability of the plate



TIER:	<b>BETTER</b>	<b>BETTER</b>	<b>BETTER</b>
TRADENAME:	<b>BLUEFIRE R860</b>	<b>BLUEFIRE R860</b>	<b>BLUEFIRE R860</b>
SHAPE:	Type 29 Conical	Type 27 Flat	Type 27 Flat
FLAP DENSITY:	Standard	Standard	High
ABRASIVE:	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina
BACKING PLATE:	Fiberglass	Quick-Trim Plastic	Fiberglass

SIZE (D x H)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #
<b>BlueFire R860 Flap Discs</b>						
4-1/2 x 5/8-11	60	13,300	10	662544 <b>61170</b>	666233 <b>99138</b>	776960 <b>90087</b>
4-1/2 x 7/8	60	13,300	10	662544 <b>61163</b>	666233 <b>99142</b>	776960 <b>90083</b>
5 x 5/8-11	60	12,000	10	666233 <b>99191</b>	666233 <b>99146</b>	
5 x 7/8	60	12,000	10	662544 <b>61177</b>	666233 <b>99150</b>	
6 x 7/8	60	10,200	10	666233 <b>99194</b>	666233 <b>99153</b>	
7 x 5/8-11	60	8,600	10	662544 <b>61192</b>	666233 <b>99157</b>	776960 <b>90093</b>
7 x 7/8	60	8,600	10	662544 <b>61185</b>	666233 <b>99161</b>	776960 <b>90090</b>

## Weld Removal to a Commercial Finish In 3 Steps – Stainless Steel

### STEP 1 – HEAVY-DUTY GRINDING

Remove the excess weld with a Norton Quantum3 grinding wheel for INOX, at a 30-45° angle. The grinding discs create a coarse surface finish so it's a good idea to leave a small amount of weld on the surface to avoid scratching the base metal.



TIER: **BEST**  
TRADENAME: **QUANTUM3**  
ABRASIVE: Ceramic Alumina  
SHAPE: Type 27

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #
<b>Quantum3 Cutting / Notching / Light Grinding – Type 27</b>			
4-1/2 x 1/8 x 5/8-11	13,580	10	662528 <b>39423</b>
4-1/2 x 1/8 x 7/8	12,225	25	662528 <b>39424</b>
5 x 1/8 x 5/8-11	13,580	10	662528 <b>39425</b>
5 x 1/8 x 7/8	12,225	25	662528 <b>39426</b>
6 x 1/8 x 5/8-11	10,185	10	662528 <b>39427</b>
6 x 1/8 x 7/8	10,185	25	662528 <b>39428</b>
7 x 1/8 x 5/8-11	8,600	10	662528 <b>39429</b>
7 x 1/8 x 7/8	8,600	25	662528 <b>39430</b>
9 x 1/8 x 5/8-11	6,600	10	662528 <b>39431</b>
9 x 1/8 x 7/8	6,600	25	662528 <b>39432</b>

### Quantum3 Ceramic Alumina Depressed Center Wheels

- 100% next-generation, uniquely-shaped, ceramic alumina abrasive grain and tough new bond system result in 5-6 times the life of aluminum oxide wheels and up to 100% increase in performance and life over competitive ceramic wheels
- Significantly increase production, for the lowest total grinding cost of any wheel in the market today
- Better operator control, improved comfort, and exceptional finished part quality with a more robust, sharper, yet smoother cutting action; wheels don't grab or dig



TIER: **BEST** **GOOD**  
TRADENAME: **QUANTUM3** **GEMINI**  
ABRASIVE: Ceramic Alumina Aluminum Oxide  
SHAPE: Type 27 Type 27

### Gemini Aluminum Oxide Depressed Center Wheels

- Quality aluminum oxide for consistent performance at an economical price
- High-performance bond and wheel hardness are designed for fast cut while retaining excellent wheel life
- Versatile, general purpose specification for use on variety of materials including 400 series stainless, hard carbon steels, soft carbon steels

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #
<b>Depressed Center Grinding Wheels – Type 27 Grinding</b>				
4-1/2 x 1/4 x 5/8-11	13,580	10	662533 <b>70793</b>	662528 <b>43593</b>
4-1/2 x 1/4 x 7/8	13,580	25	662533 <b>70794</b>	662528 <b>43594</b>
5 x 1/4 x 5/8-11	12,225	10	662533 <b>70795</b>	662528 <b>43597</b>
5 x 1/4 x 7/8	12,225	25	662533 <b>70796</b>	662528 <b>43598</b>
6 x 1/4 x 5/8-11	10,185	10	662533 <b>70797</b>	662528 <b>32390</b>
6 x 1/4 x 7/8	10,185	25	662533 <b>70798</b>	662528 <b>01865</b>
7 x 1/4 x 5/8-11	8,600	10	662533 <b>70799</b>	662529 <b>40147</b>
7 x 1/4 x 7/8	8,600	25	662533 <b>70800</b>	662529 <b>40098</b>
9 x 1/4 x 5/8-11	6,600	10	662533 <b>70801</b>	662529 <b>49105</b>
9 x 1/4 x 7/8	6,600	25	662533 <b>70802</b>	662530 <b>49077</b>

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## Weld Removal to a Commercial Finish In 3 Steps – Stainless Steel

### STEP 2 – STOCK REMOVAL

Norton BlazeX F980 fiber discs are used at a 10-15° angle to remove the remaining weld quickly. For optimum results, use with an air-cooled back-up pad.

Back-up pads are available see page 23 for details.



#### BlazeX F980 Ceramic Alumina Fiber Discs

- Premium ceramic alumina grain for increased cut rate and life over competitive blended/low ratio ceramic alumina discs
- Self-lubricating grinding aid treatment delivers cool cuts on stainless steel and other harder-to-grind materials
- Our new technology, called COOL FRICTION, dissipates heat as you grind, reducing rework and further extending the life of the discs

TIER: **BEST** **BEST**  
TRADENAME: **BLAZEX F980** **BLAZEX F980**  
ABRASIVE: Ceramic Alumina Ceramic Alumina

SIZE (D x H)	GRIT	STD. PKG.	PART #	PART #
<b>BlazeX F980 Fiber Discs – Standard Hole</b>				
4-1/2 x 7/8	36	25	780727	<b>43400</b>
5 x 7/8	36	25	780727	<b>43401</b>
7 x 7/8	36	25	780727	<b>43402</b>
<b>BlazeX F980 Fiber Discs – Speed-Change</b>				
4-1/2 x 5/8-11	36	25		780727 <b>43403</b>
5 x 5/8-11	36	25		780727 <b>43404</b>
7 x 5/8-11	36	25		780727 <b>43405</b>

### STEP 3 – BLENDING & REFINING

Norton Vortex Rapid Blend 5AM non-woven discs are ideal for blending applications and will remove grind lines left by the fiber disc during the stock removal stage. The bright finish left by the Vortex Rapid Blend can be used either as the final finish or as an intermediate step to a polished finish.



#### Vortex Rapid Blend Aluminum Oxide Non-Woven Depressed Center Discs

- Proprietary engineered Vortex aluminum oxide agglomerated grain performs the medium to fine grit steps of traditional aluminum oxide discs
- Thick nylon web for 2X longer life and faster finishing vs. traditional aluminum oxide discs, with minimal shedding
- Special resin chemistry resists shedding when used on sharp edges, making it ideal for deburring; no smearing

TIER: **BEST**  
TRADENAME: **VORTEX  
RAPID BLEND**  
ABRASIVE: Engineered A/O  
GRIT SIZE: 100-120  
SPECIFICATION: Vortex 5AM  
TYPE/BACKING: Type 27/Fiberglass

SIZE (D x H)	MAX. RPM	STD. PKG.	PART #
<b>Vortex Rapid Blend Non-Woven Discs</b>			
4-1/2 x 5/8-11	12,000	10	662544 <b>29243</b>
4-1/2 x 7/8	12,000	10	662544 <b>29268</b>

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## Cutting-off to a Commercial Finish In 3 Steps – Stainless Steel

### STEP 1 – CUTTING

Norton Quantum3 wheels cut with ease through stainless steel. Thanks to the ceramic grain, the wheels 'bite' the metal and don't bounce or vibrate during use, meaning a more comfortable cutting experience for the life of the wheel.

**TECH TIP:** At 1/16" thickness, use the Norton Quantum3 Combo wheel for rough cutting, grinding in corners and beveling, thanks to the ceramic grain it makes light work of these applications.



#### Quantum3 Ceramic Alumina RightCut Cut-off Wheels

- 100% advanced ceramic alumina grain with a special shape for comfort and performance guaranteeing 7X the life of aluminum oxide wheels and 3X the life of zirconia alumina wheels
- Unique bond system prevents premature grain release maximizing wheel life
- Available in type 01 straight and type 27 depressed center cut-off wheels from 4-1/2 inch to 6 inch diameters

TIER:	<b>BEST</b>	<b>BEST</b>
TRADENAME:	<b>QUANTUM3</b>	<b>QUANTUM3</b>
ABRASIVE:	Ceramic Alumina	Ceramic Alumina
SHAPE:	Type 01/41	Type 27/42

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #
<b>Quantum3 RightCut Cut-Off – Type 01/41 and 27/42</b>				
4-1/2 x 1/16 x 5/8-11	13,580	10		662528 <b>38457</b>
4-1/2 x 1/16 x 7/8	13,580	25	662528 <b>38455</b>	662528 <b>38456</b>
5 x 1/16 x 7/8	12,225	25	662528 <b>38462</b>	662528 <b>38464</b>
6 x 1/16 x 5/8-11	10,185	10		662528 <b>46246</b>
6 x 1/16 x 7/8	10,185	25	662528 <b>38465</b>	662528 <b>38466</b>

#### Gemini Aluminum Oxide Cut-off Wheels

- Quality aluminum oxide for consistent performance at an economical price
- Designed for portable cut-off tool applications where a fast cut and minimum material loss are desired
- Durable bond designed for fast cut while retaining excellent wheel life

TIER:	<b>GOOD</b>	<b>GOOD</b>
TRADENAME:	<b>GEMINI RIGHT CUT INOX/SS</b>	<b>GEMINI RIGHT CUT INOX/SS</b>
ABRASIVE:	Aluminum Oxide	Aluminum Oxide
SHAPE:	Type 01/41	Type 27/42

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART #	PART #
<b>Gemini INOX/SS Grinding – Type 01/41 and 27/42</b>				
4-1/2 x .045 x 5/8-11	13,580	25		662528 <b>41913</b>
4-1/2 x .045 x 7/8	13,580	25	662528 <b>41997</b>	662528 <b>41912</b>
5 x .045 x 7/8	12,225	25		662528 <b>41914</b>
6 x .045 x 7/8	10,185	25	662528 <b>41999</b>	
7 x .045 x 5/8-11	8,600	25		662528 <b>41919</b>
7 x .045 x 7/8	8,600	25	662528 <b>42000</b>	662528 <b>41918</b>

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## Cutting-off to a Commercial Finish In 3 Steps – Stainless Steel

### STEP 2 – DEBURRING/ SHAPING

The ceramic grain in Norton Blaze R980P flap discs has an aggressive, consistent cutting action for maximum stock removal. Flap discs deliver longer life and more conformability compared to fiber discs, adapting to the workpiece edge for better results.

A 60 grit flap disc produces light finish lines, which can be easily removed using a Norton Vortex Rapid Blend disc; use a powerful angle grinder rated for the disc's RPM for optimum performance.



#### Blaze R980P Ceramic Alumina Flap Discs

- Premium ceramic alumina abrasive grain lasts 50% – 200% longer than many flap discs on hard-to-grind materials
- Y-weight polyester flaps with a supersize grinding aid significantly improve life, grain retention, and fray resistance while providing a cool, noticeably fast cut rate
- High-strength fiberglass back is durable, lightweight, and absorbs vibration; quick-trim plastic allows for trimmability of the plate



TIER:	BEST	BEST	BEST
TRADENAME:	<b>BLAZE R980P</b>	<b>BLAZE R980P</b>	<b>BLAZE R980P</b>
SHAPE:	Type 29 Conical	Type 27 Flat	Type 27 Flat
FLAP DENSITY:	Standard	Standard	High
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina
BACKING PLATE:	Fiberglass	Quick-Trim Plastic	Fiberglass
OTHER:	Supersize	Supersize	Supersize

SIZE (D x H)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #
<b>Blaze R980P Flap Discs</b>						
4-1/2 x 5/8-11	60	13,300	10	662611 <b>83492</b>	662544 <b>00258</b>	662610 <b>96435</b>
4-1/2 x 7/8	60	13,300	10	662611 <b>83488</b>	662544 <b>00254</b>	662610 <b>20633</b>
5 x 5/8-11	60	12,000	10		776960 <b>90142</b>	
5 x 7/8	60	12,000	10	662611 <b>90003</b>	662544 <b>00264</b>	
6 x 5/8-11	60	8,600	10		662611 <b>32129</b>	662611 <b>32146</b>
6 x 7/8	60	8,600	10		662611 <b>32124</b>	662611 <b>32136</b>
7 x 5/8-11	60	8,600	10	662611 <b>83500</b>	662611 <b>161067</b>	662611 <b>32168</b>
7 x 7/8	60	8,600	10	662611 <b>83496</b>	662544 <b>61060</b>	662611 <b>32139</b>

### STEP 3 – BLENDING & REFINING

Norton Vortex Rapid Blend non-woven discs are ideal for blending applications and will remove grind lines left during the stock removal stage. The bright finish left by the Vortex Rapid Blend can be used either as the final finish or as an intermediate step to a polished finish.



#### Vortex Rapid Blend Aluminum Oxide Non-Woven Discs

- Proprietary engineered Vortex aluminum oxide agglomerated grain performs the medium to fine grit steps of traditional aluminum oxide discs
- Thick nylon web for 2X longer life and faster finishing vs. traditional aluminum oxide discs, with minimal shedding
- Special resin chemistry resists shedding when used on sharp edges, making it ideal for deburring; no smearing

TIER:	BEST
TRADENAME:	<b>VORTEX RAPID BLEND</b>
ABRASIVE:	Engineered A/O
GRIT SIZE:	100-120
SPECIFICATION:	Vortex 5AM
TYPE/BACKING:	Type 27/Fiberglass

SIZE (D x H)	MAX. RPM	STD. PKG.	PART #
<b>Vortex Rapid Blend Non-Woven Discs</b>			
4-1/2 x 5/8-11	12,000	10	662544 <b>29243</b>
4-1/2 x 7/8	12,000	10	662544 <b>29268</b>

See Norton Catalog #7364 – Abrasive Products for the Welding and Metal Fabrication Market for a complete offering of our products.

## Weld Removal to a Bright Finish In 3 Steps – Stainless Steel

### STEP 1 – STOCK REMOVAL

Norton Blaze R980P flap discs in 60 grit are ideal for weld and stock removal. Flap discs are particularly suited to this application as the constant erosion of the backing allows new, sharper grain to be exposed during use, offering longer product life. As the backing is softer than that of a fiber disc, the surface finish will be better, reducing the number of further steps.



#### Blaze R980P Ceramic Alumina Flap Discs

- Premium ceramic alumina abrasive grain lasts 50% – 200% longer than many flap discs on hard-to-grind materials
- Y-weight polyester flaps with a supersize grinding aid significantly improve life, grain retention, and fray resistance while providing a cool, noticeably fast cut rate
- High-strength fiberglass back is durable, lightweight, and absorbs vibration; quick-trim plastic back allows for timmability of the plate



TIER:	BEST	BEST	BEST
TRADENAME:	<b>BLAZE R980P</b>	<b>BLAZE R980P</b>	<b>BLAZE R980P</b>
SHAPE:	Type 29 Conical	Type 27 Flat	Type 27 Flat
FLAP DENSITY:	Standard	Standard	High
ABRASIVE:	Ceramic Alumina	Ceramic Alumina	Ceramic Alumina
BACKING PLATE:	Fiberglass	Quick-Trim Plastic	Fiberglass
OTHER:	Supersize	Supersize	Supersize

SIZE (D x H)	GRIT	MAX. RPM	STD. PKG.	PART #	PART #	PART #
<b>Blaze R980P Flap Discs</b>						
4-1/2 x 5/8-11	60	13,300	10	662611 <b>83492</b>	662544 <b>00258</b>	662610 <b>96435</b>
4-1/2 x 7/8	60	13,300	10	662611 <b>83488</b>	662544 <b>00254</b>	662610 <b>20633</b>
5 x 5/8-11	60	12,000	10		776960 <b>90142</b>	
5 x 7/8	60	12,000	10	662611 <b>90003</b>	662544 <b>00264</b>	
6 x 5/8-11	60	8,600	10		662611 <b>32129</b>	662611 <b>32146</b>
6 x 7/8	60	8,600	10		662611 <b>32124</b>	662611 <b>32136</b>
7 x 5/8-11	60	8,600	10	662611 <b>83500</b>	662611 <b>61067</b>	662611 <b>32168</b>
7 x 7/8	60	8,600	10	662611 <b>83496</b>	662544 <b>61060</b>	662611 <b>32139</b>

### STEP 2 – BLENDING & REFINING

Norton Vortex Rapid Blend non-woven discs are ideal for blending applications and will remove grind lines left by the flap disc during the stock removal stage. A medium grade disc is used to enable us to refine the finish from step 1.



#### Vortex Rapid Prep Aluminum Oxide Non-Woven Discs

- High-performing, patented Vortex agglomerated aluminum oxide grain provides the cutting power of a coarser grit with the finish of finer grits
- Premium high-loft nylon fiber bonded to a strong nylon scrim backing allows a thick layer of resin bond and grain for extended life and provides added durability and stiffness
- Proprietary Clean Bond resin technology guarantees smear-free finishes even on high nickel content alloys and reduces loading on aluminum and other soft metals

TIER:	BEST
TRADENAME:	<b>VORTEX RAPID BLEND</b>
ABRASIVE:	Engineered A/O
GRIT SIZE:	100-120
SPECIFICATION:	Vortex 5AM
TYPE/BACKING:	Type 27/Fiberglass

SIZE (D x H)	MAX. RPM	STD. PKG.	PART #
<b>Vortex Rapid Blend Non-Woven Discs</b>			
4-1/2 x 5/8-11	12,000	10	662544 <b>29243</b>
4-1/2 x 7/8	12,000	10	662544 <b>29268</b>

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## Weld Removal to a Bright Finish In 3 Steps – Stainless Steel

### STEP 3 – FINISHING

Norton Rapid Blend NEX-2SF has excellent final finishing capabilities and imparts an extremely fine, bright and shiny surface. It's best used at a 10-15° angle and needs to be moved slowly across the workpiece, using just the weight of the angle grinder for pressure. Also try NEX-3SF spec for more durability when flexibility and conformability is less of a concern. For best results and to avoid burn use at 6,000 to 7,000 rpm.



#### Rapid Blend NEX Silicon Carbide Depressed Center Discs

- Premium silicon carbide grain for consistent performance
- Uniform construction extends life and maintains part tolerance; prevents cutting and gouging
- Resin formula produces consistent, smear-free finishes

TIER: **BETTER**  
 TRADENAME: **RAPID BLEND NEX**  
 ABRASIVE: Silicon Carbide  
 GRIT SIZE: 320-400  
 SPECIFICATION: NEX-2SF  
 TYPE/BACKING: Type 27/Fiberglass

SIZE (D x H)	MAX. RPM	STD. PKG.	PART #
<b>Rapid Blend NEX-2SF Non-Woven Depressed Center Discs</b>			
4-1/2 x 5/8-11	12,000	10	662610 <b>23943</b>
4-1/2 x 7/8	12,000	10	662610 <b>20546</b>





## Metal Preparation for Paint and Coatings In 2 Steps – Aluminum and Non-Ferrous

### STEP 1 – STOCK REMOVAL

Norton BlueFire F826P in 36 grit are good option for non-ferrous soft materials. Due to the soft nature of the material they need to be used with light and even pressure to avoid gouging and excess material removal.

For best results choose the medium density back-up pad, see page 23 for details.



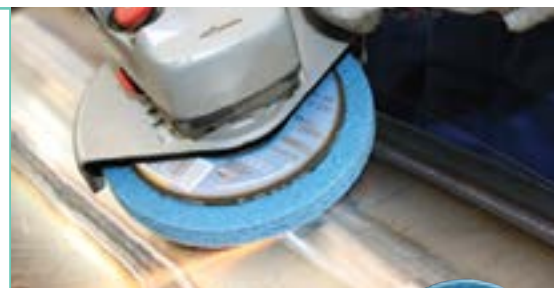
#### BlueFire F826P Zirconia Alumina Fiber Discs

- High-performance zirconia alumina abrasive blend provides 15% faster cut and longer life with less power draw than conventional zirconia discs
- Advanced resin bond technology with enhanced grain adhesion for extended life
- Heavier fiber backing for additional strength and tear resistance

		TIER:	BETTER	BETTER
		TRADENAME:	BLUEFIRE F826P	BLUEFIRE F826P
		ABRASIVE:	Zirconia Alumina	Zirconia Alumina
SIZE (D x H)	GRIT	STD. PKG.	PART #	PART #
BlueFire F826P Fiber Discs – 7/8" Center Hole				
4-1/2 x 7/8	36	25	662611	138456
5 x 7/8	36	25	662611	138562
7 x 7/8	36	25	662611	138593
BlueFire F826P Fiber Discs – Speed-Change				
5 x 5/8-11	36	25		662611138796
7 x 5/8-11	36	25		662611138818

### STEP 2 – BLENDING & REFINING

A medium Norton Vortex Rapid Blend non-woven disc should be used after the fiber disc to impart a finish ready to be coated as it removes scratch patterns and provides a key for any surface coating or paint to adhere to minimizing the risk of peeling.



#### Vortex Rapid Blend Aluminum Oxide Non-Woven Depressed Center Discs

- Proprietary engineered Vortex aluminum oxide agglomerated grain performs the medium to fine grit steps of traditional aluminum oxide discs
- Thick nylon web for 2X longer life and faster finishing vs. traditional aluminum oxide discs, with minimal shedding
- Special resin chemistry resists shedding when used on sharp edges, making it ideal for deburring; no smearing

			TIER: <b>BEST</b>
			TRADENAME: <b>VORTEX RAPID BLEND</b>
			ABRASIVE: Engineered A/O
			GRIT SIZE: 100-120
			SPECIFICATION: Vortex 5AM
			TYPE/BACKING: Type 27/Fiberglass
SIZE (D x H)	MAX. RPM	STD. PKG.	PART #
<b>Vortex Rapid Blend Non-Woven Discs</b>			
4-1/2 x 5/8-11	12,000	10	662544 <b>29243</b>
4-1/2 x 7/8	12,000	10	662544 <b>29268</b>

See Norton Catalog #7364 – Abrasive Products for the Welding and Metal Fabrication Market for a complete offering of our products.

## Paint Coating and Corrosion Removal 2 Options – All Materials

### OPTION 1 – SURFACE PREP & CLEANING

Norton Blaze Rapid Strip non-woven depressed center discs are best used at a 10-15° angle to quickly eliminate unwanted coatings and corrosion, with minimal stock removal. It's a truly versatile product, as you can achieve a more aggressive action as you increase the pressure. It's comfortable to use without damaging or gouging components.



#### Blaze Rapid Strip Ceramic Alumina Non-Woven Depressed Center Discs

- Blaze ceramic grain provides 2X plus faster, consistent rate and life than silicon carbide discs, leaves a thoroughly cleaned surface, ensuring excellent adhesion in subsequent processes such as painting and soldering
- Open web construction for minimal loading; does not shed or snag on rusty pieces; prevents gouging and rework
- Rapid Strip material provides a unique combination of aggressive performance, long life, and improved finish

TIER: **BEST**  
 TRADENAME: **BLAZE RAPID STRIP**  
 ABRASIVE: Ceramic Alumina  
 GRADE: X-Coarse 36-50 grit  
 TYPE/BACKING: Type 27/Fiberglass

SIZE (D x H)	MAX. RPM	STD. PKG.	PART #
<b>Blaze Rapid Strip Non-Woven Depressed Center Discs</b>			
4-1/2 x 5/8-11	12,000	10	662544 <b>98101</b>
4-1/2 x 7/8	12,000	10	666233 <b>03783</b>
5 x 5/8-11	11,000	10	666233 <b>03915</b>
5 x 7/8	11,000	10	666233 <b>03916</b>
7 x 5/8-11	8,000	10	666233 <b>03919</b>
7 x 7/8	8,000	10	666233 <b>03920</b>

### OPTION 2 – SURFACE PREP & CLEANING

Norton BlueFire wire cup brushes can be used as an alternative to Blaze Rapid Strip. A range of cup brushes are available for hard to reach areas or flat surfaces. The conformability of the wire structure enables the brush to remove unwanted coatings from uneven or pitted surfaces.



#### BlueFire Twist Knot Wire Cup Brushes

- Deburring; roughing; cleaning rust, scale, paint and oxidation; cleaning corners, recesses, and other hard-to-reach areas and removing concrete and large surfaces
- Twist Knot style for heavy-duty applications
- Used on right angle cup grinders

TIER: **BETTER**  
 TRADENAME: **BLUEFIRE**

SIZE	TRIM LENGTH	GRIT	STD. PKG.	PART #
<b>BlueFire Twist Knot Wire Cup Brushes – Single Row with Protective Guard</b>				
4 x 0.020 x 5/8-11	1-1/8	10,200	5	662528 <b>33496</b>
5 x 0.020 x 5/8-11	1-1/8	6,500	5	662528 <b>33497</b>
<b>BlueFire Crimped Wire Cup Brushes – with Protective Guard</b>				
4 x (12 x 0.009) x 5/8-11	1-3/16	9,000	5	662528 <b>33494</b>
5 x (12 x 0.009) x 5/8-11	1-1/8	6,600	5	662528 <b>33495</b>

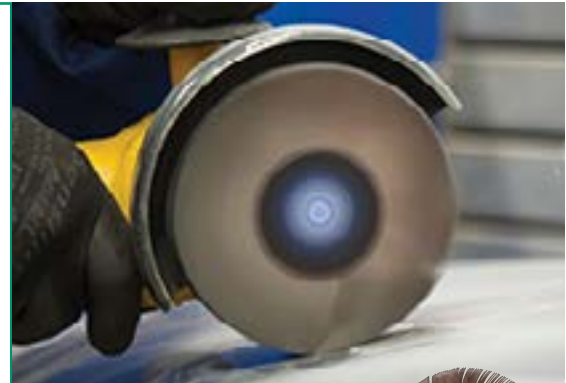
See Norton Catalog #7364 – Abrasive Products for the Welding and Metal Fabrication Market for a complete offering of our products.

## Scale Removal and Cleaning In 1 Step – All Materials

### STEP 1 – SCALE REMOVAL & CLEANING

Norton Merit R369 flap wheels will quickly remove the scale, rust or paint from the workpiece. They are ideal for sanding contours and uneven surfaces, while delivering a consistent cut rate. Ideal for linear finishing in metal fabrication and welding industries.

Norton flap wheels are more forgiving than other abrasives, reducing the risk of flattening, gouging or surface deformation, meaning fewer rejected parts, and better long term productivity.



#### Merit R369 High Performance A/O Blend Flap Wheels

- Long-lasting premium aluminum oxide blend with 2 to 3 times longer life
- Delivers an excellent cut rate on finishing operations
- Heavy cotton blended flaps provide extended durability, conformability, and superior wear resistance

TIER: **GOOD**  
TRADENAME: **MERIT R369**  
ABRASIVE: Aluminum Oxide Blend

SIZE (D x W x H)	GRIT	MAX. RPM	STD. PKG.	PART #
<b>Merit R369 Flap Wheels</b>				
4 x 1 x 5/8	40	12,000	10	088341 <b>22032</b>
	60	12,000	10	088341 <b>22034</b>
	80	12,000	10	088341 <b>22035</b>
	120	12,000	10	088341 <b>22037</b>

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## Sharp Edge Removal After Laser Cutting 2 Options – All Materials

### OPTION 1 – REMOVAL OF SMALL BURRS

The Norton Rapid Blend medium non-woven depressed center disc is able to quickly and efficiently remove burrs whilst simultaneously rounding sharp edges. The open structure and soft nature of the product reduces the risk of creating flat spots and changing the geometry of the component.



#### Rapid Blend Non-Woven Aluminum Oxide Depressed Center Discs

- Premium aluminum oxide grain; engineered for more demanding applications
- Uniform construction maintains part tolerance; prevents cutting and gouging
- Smear-free bond excels at producing light satin finishes

TIER: **BETTER**  
TRADENAME: **RAPID BLEND**  
ABRASIVE: Aluminum Oxide  
GRADE: High Strength Medium  
TYPE/BACKING: Type 27/Fiberglass

SIZE (D x H)	MAX. RPM	STD. PKG.	PART #
<b>Rapid Blend Non-Woven Depressed Center Discs</b>			
4-1/2 x 5/8-11	12,000	10	662610 <b>23949</b>
4-1/2 x 7/8	12,000	10	662610 <b>20549</b>

### OPTION 2 – REMOVAL OF LARGE BURRS

The Norton Rapid Blend NEX-2AM non-woven depressed center disc is more compact and heavy-duty enabling removal of larger burrs, that are created by laser cutting and also sharp edges. The solid 3D structure of the product gives longer life and better productivity.



#### Rapid Blend NEX Aluminum Oxide Non-Woven Depressed Center Discs

- Premium aluminum oxide grain for consistent performance
- Uniform construction extends life and maintains part tolerance; prevents cutting and gouging
- Resin formula produces consistent, smear-free finishes

TIER: **BETTER**  
TRADENAME: **RAPID BLEND NEX**  
ABRASIVE: Aluminum Oxide  
GRADE: NEX-2AM  
TYPE/BACKING: Type 27/Fiberglass

SIZE (D x H)	MAX. RPM	STD. PKG.	PART #
<b>Rapid Blend Non-Woven Depressed Center Discs – NEX-2AM</b>			
4-1/2 x 5/8-11	12,000	10	662610 <b>23947</b>
4-1/2 x 7/8	12,000	10	662610 <b>20548</b>

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## Final Finish Polishing – All Materials

### STEP 1 – APPLYING THE POLISHING COMPOUND

Apply compound directly to the face of the Norton Rapid Polish disc while spinning in a safe manner. The polishing compound coats the disc face, providing longer polishing times and extending disc life for an amazing mirror-like shine.

### STEP 2 - POLISHING THE SURFACE

Use regular motions at a low speed 2,000 - 3,000 rpm to gently buff and polish the material to a bright mirror shine.



#### Rapid Polish Non-Abrasive Depressed Center Discs

- Type 27 disc with premium quality pressed hardened felt for polishing to a mirror-like finish
- Use with or without polishing compound
- Soft padding is ideal for final finishing with no vibration

TIER:	<b>BETTER</b>	<b>BETTER</b>
TRADENAME:	<b>RAPID POLISH</b>	<b>RAPID POLISH</b>
ABRASIVE:	No Abrasive	Polishing Compound
TYPE/BACKING:	Type 27/Plastic	—

SIZE (D x H)	MAX. RPM	STD. PKG.	PART #	PART #
<b>Rapid Polish Depressed Center Discs</b>				
4-1/2 x 5/8-11	12,000	10	780727 <b>47430</b>	
4-1/2 x 7/8	12,000	10	780727 <b>47429</b>	
<b>Rapid Polish Polishing Compound</b>				
4 x 1-1/8 x 1-1/8	—	10		780727 <b>47942</b>

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## Back-up Pads



### Fiber Disc Baling Unit

- Places 100 discs on a spindle between two plates
- Locks down with a pinch screw
- Maintains the shape of the discs by maintaining pressure to minimize curl
- User-friendly and reusable



### Air-Cooled Standard Back-up Pad

Slotted hub design and curved ribs draw heat away from the grinding zone, reducing disc loading and increasing life. All pads have a 5/8"-11 threaded female hub for mounting. We also offer a no-nose pad for shorter-shafted right angle grinders.



### Smooth Face Speed-Change Back-up Pad

Molded rubber back-up pads with a smooth face.

- Hard density pads are for aggressive cutting action
- Medium density pads are for all-purpose applications

DESCRIPTION	MAX. RPM	STD. PKG.	PART #
<b>Fiber Disc Baling Unit</b>			
5"	—	1	7769600 <b>1065</b>
7"	—	1	7769600 <b>1066</b>
<b>Rubber Back-up Pads</b>			
<b>Air-Cooled Standard for 7/8 Hole Fiber and Non-Woven Discs</b>			
4" Medium	12,000	5	636425 <b>04918</b>
4-1/2" Medium	11,000	5	636425 <b>02122</b>
5" Medium	10,000	5	636425 <b>43421</b>
7" Hard	8,600	5	636425 <b>43425</b>
7" Medium	8,600	5	636425 <b>43422</b>
9" Hard	6,600	5	636425 <b>43426</b>
9" Medium	6,600	5	636425 <b>43423</b>
<i>Note: Retainer nuts are not included with back-up pads. These must be ordered separately.</i>			
<b>Air-Cooled No-Nose</b>			
4-1/2" Medium	11,000	5	636425 <b>04872</b>
5" Medium	10,000	5	636425 <b>03000</b>
<b>Smooth Face for Fiber and Non-Woven Speed-Change Discs</b>			
4-1/2" Medium	20,000	5	662544 <b>92277</b>
5" Medium	12,000	5	636425 <b>43235</b>
7" Hard	8,600	5	636425 <b>43240</b>
7" Medium	8,600	5	636425 <b>43245</b>
7" Soft	8,600	5	636425 <b>43250</b>
9" Medium	7,000	5	636425 <b>43270</b>
<b>Tools</b>			
#103 Retainer Nut	—	10	636425 <b>43463</b>
Spanner Wrench	—	5	636425 <b>43005</b>
66NS Short Retainer Nut	—	10	636425 <b>43461</b>

All fiber disc back-up pads are packed in individual boxes within the shipping carton. Each box can be used in a vending machine.

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# RIGHT ANGLE GRINDER SOLUTIONS



**BlazeX F970 Fiber Discs**  
Improved ceramic alumina micro-fracturing grain constantly exposes sharper grain edges to significantly increase cut rate and life over competitive blended/low-ratio ceramic alumina discs



**Quantum3 Cut-off and Depressed Center Wheels**  
100% advanced ceramic alumina grain with a special shape for comfort and performance



**Blaze R980P Flap Discs**  
Premium ceramic alumina abrasive grain lasts 50% – 200% longer than many flap discs on stainless steel, cobalt, chrome, inconel, titanium and other hard-to-grind materials



**Rapid Polish Depressed Center Discs**  
Felt wool polishing pad for a high shine finish



**Non-Woven Depressed Center Discs**  
Leave a thoroughly cleaned surface, ensuring excellent adhesion in subsequent processes such as painting and soldering

**BEST** Highest Productivity;  
Lowest Total Cost

**BETTER** Excellent Blend of  
Performance and Price

**GOOD** Consistent Performance –  
Low Initial Price

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