

COMBIDISC grinding tools
The product line for many applications



**YOU KNOW HOW.
WE KNOW
WOW!**



**New! Innovation
RS type**

TRUST BLUE

- Versatile product line for coarse machining, surface texturing and polishing
- Optimal solutions even for complicated applications
- High performance, quick and safe

COMBIDISC grinding tools

General information

The COMBIDISC product range contains a wide selection of grinding tools for surface finishing. From coarse machining and surface texturing to face-down mirror polishing – the range provides the best tool, even for complicated applications.

Advantages:

- High profitability thanks to quick tool changes.
- Great convenience thanks to simple handling and low-vibration working.
- No operational disruptions caused by sticking, slipping or disengaging.

Applications:

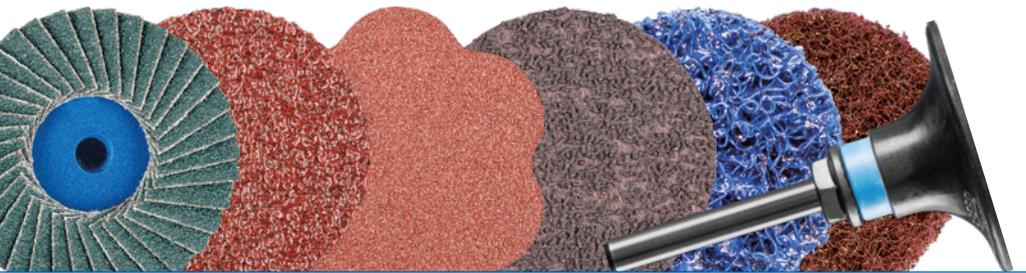
- Roughening
- Levelling
- Deburring
- Surface work
- Work on edges
- Polishing
- Cleaning
- Sharpening
- Work on weld seams
- Structuring surfaces
- Step-by-step fine grinding

Recommendations for use:

- Use COMBIDISC grinding tools with arbors or abrasive disc holders on flexible shaft drives with angle handpieces, compressed-air or electric angle grinders.
- Use grinding oil which is suitable for the material in order to considerably increase the tool life and abrasive performance of the tools. More detailed information and ordering data for grinding oils can be found in our Tool Manual 23, catalogue section 4, page 155 or at www.pferd.com.

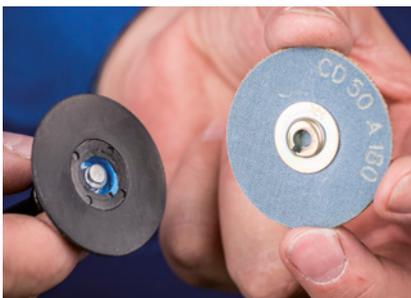
Matching tool drives:

- Flexible shaft drives
- Straight grinders
- Angle grinders
- Cordless angle grinders



PFERD offers two alternative clamping systems:

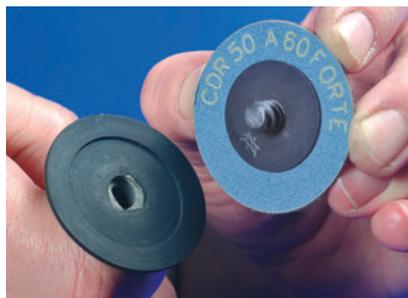
CD system



Tool side: Threaded connection with female thread (metal/plastic)

Also suitable for the following systems used on the market: PSG, Power Lock Type II "turn on", SocAtt, Turn-On

CDR system



Tool side: Threaded connection with male thread (plastic)

Also suitable for the following systems used on the market: Roloc™, Lockit, Speed Lok TR, Power Lock Type III, Fastlock-System B, Roll-On

Ordering notes:

- Please order arbors or COMBIDISC abrasive disc holders separately. More detailed information and ordering data can be found on page 21.
- When ordering, please state the EAN or the full description.
- **Ordering example:**
EAN 4007220266175
CD 38 A 180
- **Ordering example explanation:**
CD = COMBIDISC abrasive discs
38 = Outer diameter D₁ [mm]
A = Abrasive
180 = Grit size

Safety notes:

- The maximum permitted peripheral speed is 50 m/s.
- For safety reasons, the specified maximum permitted rotational speed must never be exceeded.

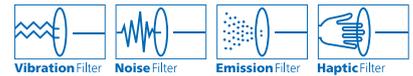


Accessories:

- Arbors for COMBIDISC Mini-POLIFAN
- COMBIDISC abrasive disc holders
- COMBIDISC DUST REMOVER

PFERDVALUE:

PFERDERGONOMICS recommends COMBIDISC tools as a solution to sustainably reduce vibration, noise and dust levels produced by tools and to improve working comfort.



PFERDEFFICIENCY recommends COMBIDISC tools to reduce tool change and setup times.



PFERDVIDEO:

Learn more about the advantages of using COMBIDISC tools.

Overview of COMBIDISC grinding tools

Mini-POLIFAN CD, CDR	4	POLICLEAN discs CD, CDR	16	Sets	22
■ Mini-POLIFAN arbors	4	Non-woven discs CD, CDR	17	DUST REMOVER	23
Abrasive discs CD, CDR	5	TX discs CD	20		
VICTOGRAIN	10	Felt discs CD, CDR	20		
Abrasive discs RS type	14	Abrasive disc holders	21		

COMBIDISC grinding tools

General information



Recommended rotational speed range

Example:

CD 50 A-COOL 60

Application:

Grinding stainless steel (INOX)

Cutting speed: 20–25 m/s

Rotational speed: 7,600–9,500 RPM

D ₁ [mm]	Cutting speed [m/s]								
	5	10	15	20	25	30	35	40	50
	Rotational speeds [RPM]								
20	4,700	9,500	14,300	19,000	23,800	28,600	33,400	38,100	47,700
25	3,800	7,600	11,400	15,200	19,000	22,900	26,700	30,500	38,100
38	2,500	5,000	7,500	10,000	12,500	15,000	17,500	20,100	25,100
50	1,900	3,800	5,700	7,600	9,500	11,400	13,300	15,200	19,000
75	1,200	2,500	3,800	5,000	6,300	7,600	8,900	10,100	12,700

The fast way to the best tool

Material group ▼		Abrasive ►	Aluminium oxide A, A-PLUS, A-FLEX, A-CONTOUR, A-FORTE	Aluminium oxide A Compact grain	Zirconia alumina Z	Silicon carbide SiC	Aluminium oxide A-COOL	Ceramic oxide grain CO-COOL	VICTOGRAIN-COOL 	Diamond abrasive discs	POLICLEAN discs	Non-woven discs PNER, VRH, VRW
Steel, cast steel	Non-hardened, non-heat-treated steels	Construction steels, carbon steels, tool steels, non-alloyed steels, cast steel	●		○			●	●		●	●
	Hardened, heat-treated steels	Tool steels, tempering steels, alloyed steels, cast steel	○	●	●			●	●		○	○
Stainless steel (INOX)	Rust- and acid-resistant steels	Austenitic and ferritic stainless steels		●	○		●	●	●		●	●
Non-ferrous metals	Soft non-ferrous metals, non-ferrous metals	Soft aluminium alloys	○				●	○			●	●
		Brass, copper, zinc	●		○						●	●
	Hard non-ferrous metals	Hard aluminium alloys	●		○	○					●	●
		Bronze, titanium			○	●		●	●	●	○	●
High-temperature-resistant materials	Nickel-based and cobalt-based alloys			○			●	●	●	○	●	
Cast iron	Grey cast iron, white cast iron	Cast iron with flake graphite EN-GJL (GG), with nodular graphite/nodular cast iron EN-GJS (GGG), white annealed cast iron EN-GJMW (GTW), black cast iron EN-GJMB (GTS)	●		○						●	●
Plastics, other materials	Fibre-reinforced plastics, thermoplastics, wood, chipboard, paintwork		●			●				●	●	●

● = Highly suitable

○ = Suitable

COMBIDISC grinding tools

Mini-POLIFAN CD, CDR

Aluminium oxide A type

For universal coarse grinding work with high stock removal rates.

Ideal for dressing weld seams in hard-to-reach places.

Longer tool life and higher stock removal rate when compared to abrasive discs.

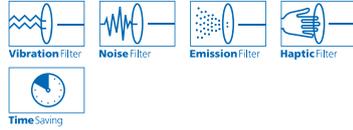
Abrasive:

Aluminium oxide A

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size				Opt. RPM	Suitable arbors		Description
	40	60	80	120				
EAN 4007220								

CD system



50	617359	617366	617373	617380	12,000–14,000	BO PFF 50, SBH 20–50	10	CD PFF 50 A ...
75	617397	617403	617410	617625	8,000–10,000	BO PFF 75, SBH 75	10	CD PFF 75 A ...

CDR system



50	016121	016145	821633	016152	12,000–14,000	SBHR 20–75	10	CDR PFF 50 A ...
75	016169	016176	821640	016336	8,000–10,000	SBHR 20–75	10	CDR PFF 75 A ...

Zirconia alumina Z type

For coarse grinding work with a high stock removal rate and a long tool life.

Abrasive:

Zirconia alumina Z

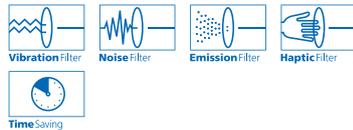
Recommendations for use:

- Use in the case of a higher contact pressure.

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size				Opt. RPM	Suitable arbors		Description
	40	60	80	120				
EAN 4007220								

CD system



50	592717	592724	592731	592748	12,000–14,000	BO PFF 50, SBH 20–50	10	CD PFF 50 Z ...
75	592755	592762	592779	592786	8,000–10,000	BO PFF 75, SBH 75	10	CD PFF 75 Z ...

CDR system

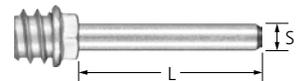


50	902707	902714	016534	016541	12,000–14,000	SBHR 20–75	10	CDR PFF 50 Z ...
75	835111	016558	016565	821688	8,000–10,000	SBHR 20–75	10	CDR PFF 75 Z ...

Mini-POLIFAN arbors

BO PFF

Matching arbors for COMBIDISC Mini-POLIFAN.



S [mm]	L [mm]	Suitable tool	EAN 4007220		Description
6	40	CD PFF 50	593196	1	BO PFF 50
		CD PFF 75	593202	1	BO PFF 75

COMBIDISC grinding tools

Abrasive discs CD, CDR

Aluminium oxide A type

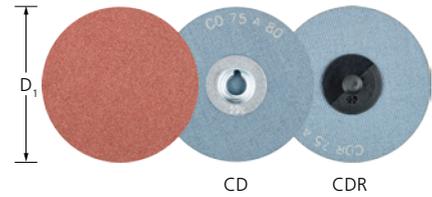
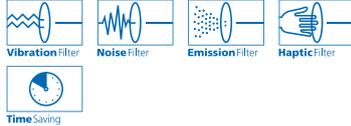
For universal coarse to fine grinding applications in industry and professional trades.

Abrasive:
Aluminium oxide A

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size						Opt. RPM		Description
	36	60	80	120	180	320			
EAN 4007220									

CD system



20	-	265864	266007	266038	266052	266069	20,000–35,000	100	CD 20 A ...
25	-	355718	355725	355732	266083	266151	15,000–26,000	100	CD 25 A ...
38	355749	355756	355763	355770	266175	266199	10,000–16,000	100	CD 38 A ...
50	355787	355794	355800	355817	266212	266281	8,000–13,000	100	CD 50 A ...
75	355824	355831	355848	355855	266328	266359	5,000–9,000	50	CD 75 A ...

CDR system



20	-	778036	778043	778050	778074	778081	20,000–35,000	100	CDR 20 A ...
25	-	778098	778104	778111	778128	778135	15,000–26,000	100	CDR 25 A ...
38	596456	596463	596470	597255	597262	596500	10,000–16,000	100	CDR 38 A ...
50	596517	596524	596531	596548	596555	596562	8,000–13,000	100	CDR 50 A ...
75	596586	596593	596609	596616	596623	596630	5,000–9,000	50	CDR 75 A ...

Aluminium oxide A-PLUS type

For universal applications from coarse to fine grinding.

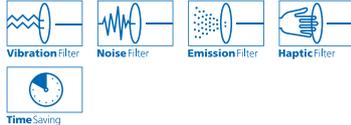
Higher stock removal rate due to sturdy backing material.
Particularly for use in edge grinding due to high tear strength.

Abrasive:
Aluminium oxide A-PLUS

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size				Opt. RPM		Description
	36 PLUS	60 PLUS	80 PLUS	120 PLUS			
EAN 4007220							

CD system

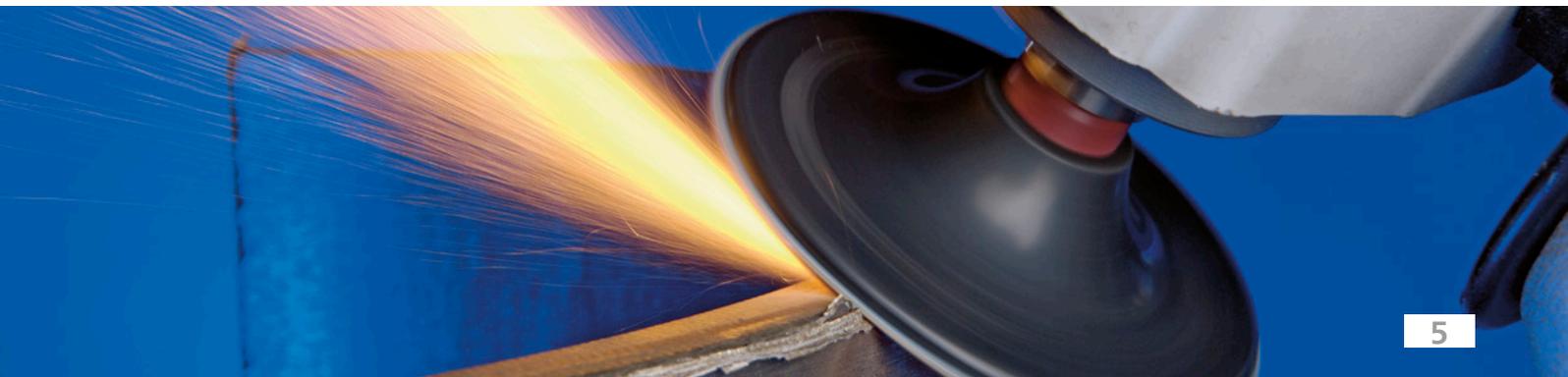


50	593608	593615	593622	593653	8,000–13,000	100	CD 50 A ...
75	593660	593677	593684	593691	5,000–9,000	50	CD 75 A ...

CDR system



50	778302	778319	778326	778333	8,000–13,000	100	CDR 50 A ...
75	778340	778357	778364	778371	5,000–9,000	50	CDR 75 A ...



COMBIDISC grinding tools

Abrasive discs CD, CDR

Aluminium oxide A-FLEX type

Particularly flexible abrasive discs, which are especially suitable for work on contours and concave surfaces, e.g. in tool- and mould-making. For achieving seamless transitions in the surface finish.

Abrasive:

Aluminium oxide A-FLEX

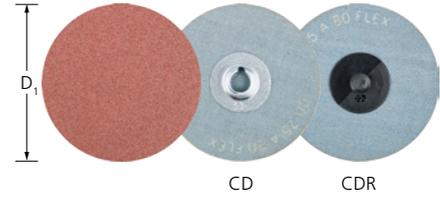
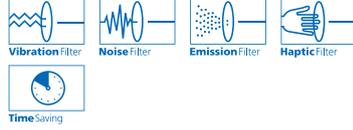
Recommendations for use:

- These discs should be used with a soft holder to support their flexibility.

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size			Opt. RPM		Description
	60 FLEX	80 FLEX	120 FLEX			
EAN 4007220						

CD system



38	638842	638859	638866	10,000–16,000	100	CD 38 A ...
50	638873	638880	638897	8,000–13,000	100	CD 50 A ...
75	638903	638910	638927	5,000–9,000	50	CD 75 A ...

CDR system



38	778166	778159	778173	10,000–16,000	100	CDR 38 A ...
50	778180	778210	778227	8,000–13,000	100	CDR 50 A ...
75	778241	778272	778296	5,000–9,000	50	CDR 75 A ...

Aluminium oxide A-FORTE type

For universal applications from coarse to fine grinding, with a high stock removal rate and long tool life.

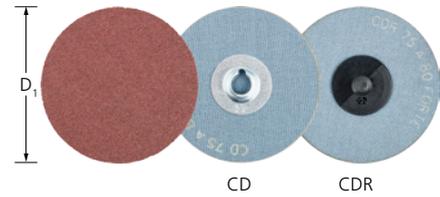
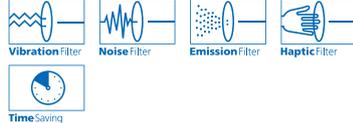
Abrasive:

Aluminium oxide A-FORTE

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size				Opt. RPM		Description
	36 FORTE	60 FORTE	80 FORTE	120 FORTE			
EAN 4007220							

CD system



25	-	265833	266021	266045	15,000–26,000	100	CD 25 A ...
38	266076	266090	266106	266113	10,000–16,000	100	CD 38 A ...
50	266120	266137	266144	266168	8,000–13,000	100	CD 50 A ...
75	266182	266205	266229	266250	5,000–9,000	50	CD 75 A ...

CDR system



25	-	778388	778395	778401	15,000–26,000	100	CDR 25 A ...
38	596647	596661	596678	596685	10,000–16,000	100	CDR 38 A ...
50	596692	596708	596715	596722	8,000–13,000	100	CDR 50 A ...
75	596739	596746	596753	596760	5,000–9,000	50	CDR 75 A ...



COMBIDISC grinding tools

Abrasive discs CD, CDR

Aluminium oxide A-COOL type

For universal applications from coarse to fine grinding on materials with challenging stock removal properties, e.g. stainless steel (INOX).

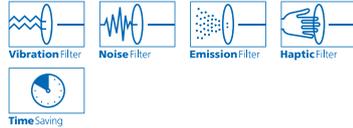
Active grinding additives in the coating substantially improve the stock removal rate, prevent clogging and result in cooler grinding.

Abrasive:
Aluminium oxide A-COOL

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size			Opt. RPM		Description
	36	60	80			
EAN 4007220						
CD system						
50	265840	266427	266434	8,000–13,000	100	CD 50 A-COOL ...
75	266441	266458	266465	5,000–9,000	50	CD 75 A-COOL ...
CDR system						
50	596777	596784	596791	8,000–13,000	100	CDR 50 A-COOL ...
75	596807	596814	596821	5,000–9,000	50	CDR 75 A-COOL ...

Aluminium oxide A compact grain type

Outstandingly suited to fine and very fine grinding, and for step-by-step preparations for polishing.

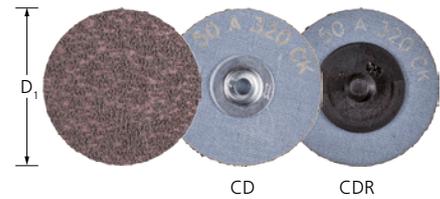
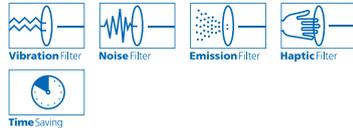
The self-sharpening compact grain facilitates a very long tool life and achieves consistent surface quality levels throughout the entire tool life.

Abrasive:
Aluminium oxide A compact grain

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size									Opt. RPM		Description
	120	180	240	320	400	600	800	1000	1200			
EAN 4007220												
CD system												
50	003169	065594	065600	065860	065921	065976	066539	066546	066553	3,800–13,000	100	CD 50 A ... CK
75	066775	066782	066799	066805	066812	066836	066843	066850	066867	2,500–9,000	50	CD 75 A ... CK
CDR system												
50	066577	066591	066607	066621	066638	066645	066652	066669	066737	3,800–13,000	100	CDR 50 A ... CK
75	066874	066881	066904	067123	067130	067161	067185	067192	067208	2,500–9,000	50	CDR 75 A ... CK



COMBIDISC grinding tools

Abrasive discs CD, CDR

Aluminium oxide A-CONTOUR type

Very flexible and adaptable on account of the outer contour.
Cutting into the workpiece is avoided.

Abrasive:

Aluminium oxide A-CONTOUR

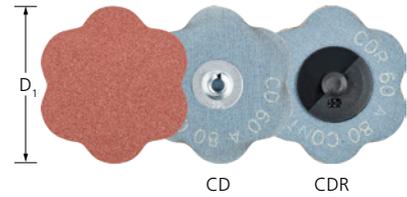
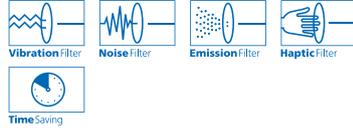
Recommendations for use:

- Use an abrasive disc holder with a diameter of 20–50 mm.

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size				Opt. RPM		Description
	60 CONTOUR	80 CONTOUR	120 CONTOUR	180 CONTOUR			
EAN 4007220							
CD system 							
60	898802	898819	898826	898833	7,500–11,000	50	CD 60 A ...
CDR system 							
60	898840	898857	898864	898871	7,500–11,000	50	CDR 60 A ...

Zirconia alumina Z type

For coarse grinding work with a high stock removal rate and a long tool life.
Particularly high stock removal rate in coarse grinding applications using grit sizes 36 and 60.

Abrasive:

Zirconia alumina Z

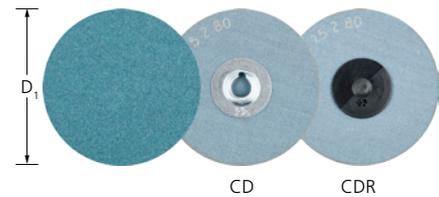
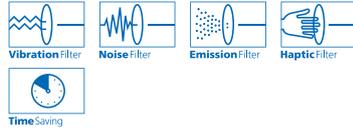
Recommendations for use:

- Use with hard or medium-hard COMBIDISC abrasive disc holders.

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size			Opt. RPM		Description
	36	60	80			
EAN 4007220						
CD system 						
38	778418	778425	778432	5,000–16,000	100	CD 38 Z ...
50	265857	266472	266519	3,800–13,000	100	CD 50 Z ...
75	266526	266533	266540	2,500–9,000	50	CD 75 Z ...
CDR system 						
38	778449	778456	778463	5,000–16,000	100	CDR 38 Z ...
50	596838	596845	596852	3,800–13,000	100	CDR 50 Z ...
75	596869	596876	596883	2,500–9,000	50	CDR 75 Z ...



COMBIDISC grinding tools

Abrasive discs CD, CDR

Ceramic oxide grain CO-COOL type

For aggressive grinding with maximum stock removal rate on hard materials which do not conduct heat well. Consistently high performance due to self-sharpening ceramic oxide grain.

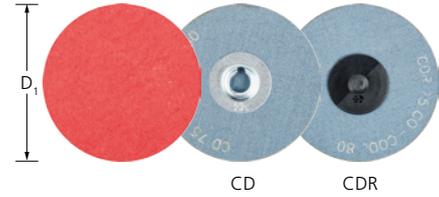
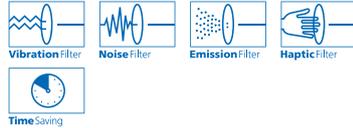
Active grinding additives in the coating substantially improve the stock removal rate, prevent clogging and result in cooler grinding.

Abrasive:
Ceramic oxide grain CO-COOL

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size					Opt. RPM		Description
	24	36	60	80	120			
EAN 4007220								

CD system



38	770672	770689	770696	770702	770719	5,000–16,000	100	CD 38 CO-COOL ...
50	617922	617298	617304	617311	771365	3,800–13,000	100	CD 50 CO-COOL ...
75	617939	617328	617335	617342	771372	2,500–9,000	50	CD 75 CO-COOL ...

CDR system



38	778593	778609	778616	778623	778630	5,000–16,000	100	CDR 38 CO-COOL ...
50	778661	778678	778685	778692	778708	3,800–13,000	100	CDR 50 CO-COOL ...
75	778715	778722	778739	778746	778753	2,500–9,000	50	CDR 75 CO-COOL ...

Midget fibre discs ceramic oxide grain CO-COOL type

Exceptionally well-suited to surface and edge grinding. The fibre backing strengthens the abrasive disc and improves stock removal.

For aggressive grinding with maximum stock removal rate on hard materials which do not conduct heat well. Consistently high performance due to self-sharpening ceramic oxide grain.

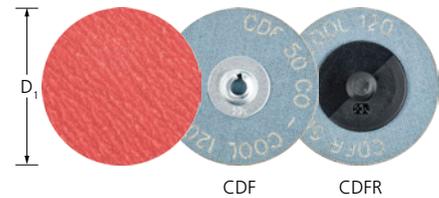
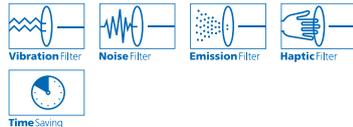
Active grinding additives in the coating substantially improve the stock removal rate, prevent clogging and result in cooler grinding.

Abrasive:
Ceramic oxide grain CO-COOL

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size				Opt. RPM		Description
	36	50	80	120			
EAN 4007220							

CD system



50	778876	778883	778890	779156	3,800–13,000	100	CDF 50 CO-COOL ...
75	779163	779170	779187	779194	2,500–9,000	50	CDF 75 CO-COOL ...

CDR system



50	779200	779217	779224	779231	3,800–13,000	100	CDFR 50 CO-COOL ...
75	779255	779262	779279	779286	2,500–9,000	50	CDFR 75 CO-COOL ...

The complete range of products with the CO-COOL abrasive grain can be found in our brochure "Ceramic oxide grain CO-COOL abrasive – For maximum stock removal" at www.pferd.com.



COMBIDISC grinding tools

VICTOGRAIN

VICTOGRAIN products are some of the most effective grinding tools in the world. PFERD's triangular, precision-formed abrasive grain achieves uniquely high abrasive performance.

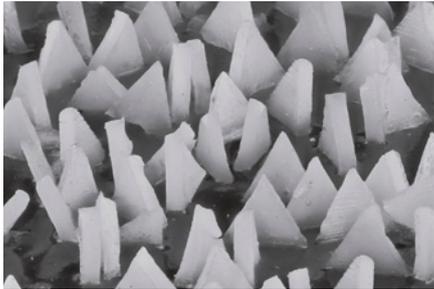
The **VICTOGRAIN** abrasive grain triangles are identical in shape and size and their cutting edges are applied to the workpiece at the optimum angle, meaning the grain needs very little energy to penetrate the workpiece. As such, the user benefits from an efficient machining process with

- fast working,
- a long tool life,
- less heat build-up in the workpiece, and
- a lower power output required for the tool drive.

The **VICTOGRAIN** abrasive grain triangles are fixed to the substrate on one of their sides. This means they are securely fixed in place and, together with their slim design, offer an extremely large chip space in order to further improve machining efficiency.

The structure of the triangular **VICTOGRAIN** has also been specially adapted to maximize results. The very small crystals inside the triangles ensure optimal wear characteristics as sharp cutting edges are always exposed, but only the minimum amount of abrasive grain/the triangle breaks off.

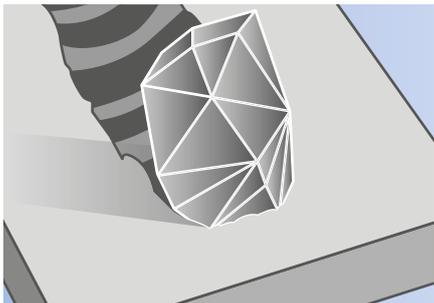
By combining all these properties together, users benefit from optimal, constant performance during cool grinding and an extremely long tool life together with consistent workpiece surface roughness.



The **VICTOGRAIN** abrasive grain is optimally aligned



Coated abrasives **VICTOGRAIN**



Conventional abrasive grain

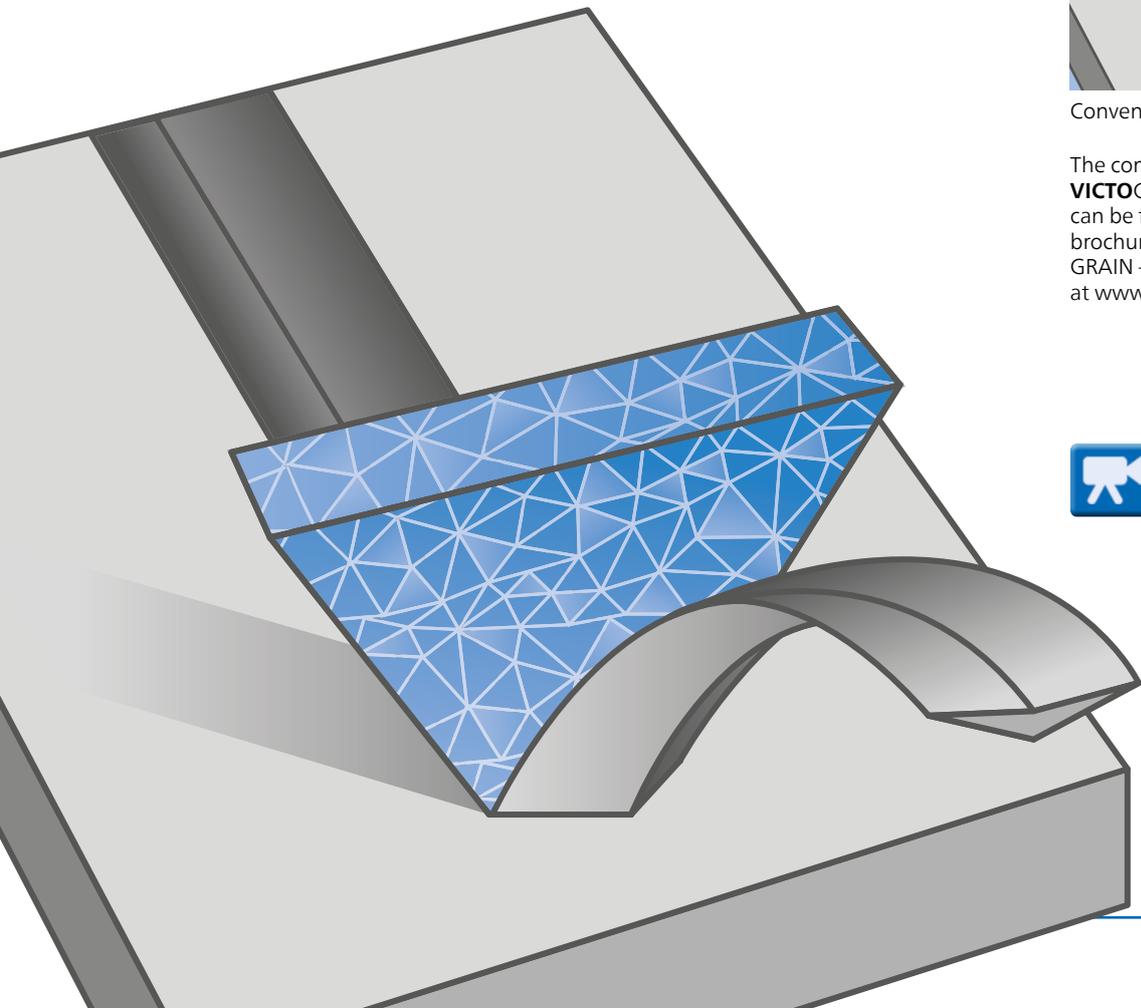
The complete range of **VICTOGRAIN** products can be found in our brochure "**VICTOGRAIN** – Simply better" at www.pferd.com.



PFERDVIDEO:

Learn more about the advantages of using **VICTOGRAIN** products.

VICTOGRAIN abrasive grain



COMBIDISC grinding tools

Abrasive discs CD, CDR

VICTOGRAIN-COOL type

For extremely aggressive grinding with an extremely long tool life and an outstanding stock removal rate on steels and materials which are hard or have poor heat-conducting properties.

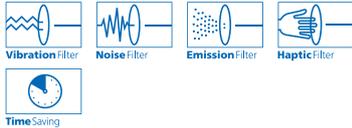
Outstanding, constant high performance thanks to the **VICTOGRAIN-COOL** abrasive grain.

Active grinding additives in the coating substantially improve the stock removal rate, prevent clogging and result in cooler grinding.



Abrasive:
VICTOGRAIN-COOL

PFERDVALUE:



	D ₁ [mm]	EAN 4007220	Opt. RPM		Description
CD system 					
	38	108857	5,000–16,000	100	CD 38 VICTOGRAIN-COOL
	50	109762	3,800–13,000	100	CD 50 VICTOGRAIN-COOL
	75	109779	2,500–9,000	50	CD 75 VICTOGRAIN-COOL
CDR system 					
	38	109786	5,000–16,000	100	CDR 38 VICTOGRAIN-COOL
	50	109793	3,800–13,000	100	CDR 50 VICTOGRAIN-COOL
	75	109809	2,500–9,000	50	CDR 75 VICTOGRAIN-COOL

Midget fibre discs VICTOGRAIN-COOL type

Exceptionally well-suited to surface and edge grinding. The fibre backing considerably strengthens the abrasive disc and improves stock removal.

For extremely aggressive grinding with an extremely long tool life and an outstanding stock removal rate on steels and materials which are hard or have poor heat-conducting properties.

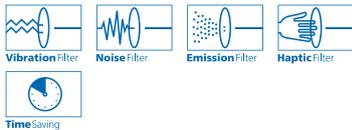
Outstanding, constant high performance thanks to the **VICTOGRAIN-COOL** abrasive grain.

Active grinding additives in the coating substantially improve the stock removal rate, prevent clogging and result in cooler grinding.



Abrasive:
VICTOGRAIN-COOL

PFERDVALUE:



	D ₁ [mm]	EAN 4007220	Opt. RPM		Description
CD system 					
	38	109298	5,000–16,000	100	CDF 38 VICTOGRAIN-COOL 36
	50	109304	3,800–13,000	100	CDF 50 VICTOGRAIN-COOL 36
	75	109311	2,500–9,000	50	CDF 75 VICTOGRAIN-COOL 36
CDR system 					
	38	109328	5,000–16,000	100	CDR 38 VICTOGRAIN-COOL 36
	50	109335	3,800–13,000	100	CDR 50 VICTOGRAIN-COOL 36
	75	109342	2,500–9,000	50	CDR 75 VICTOGRAIN-COOL 36

COMBIDISC grinding tools

Abrasive discs CD, CDR

Diamond type

Exceptionally suitable for work on wear-resistant coatings and for hard facings made of tungsten carbide, chromium carbide, titanium carbide, etc. Particularly recommended for work on materials used for aircraft engine construction, e.g. Hastelloy, Inconel and titanium/titanium alloys. Also highly suitable for work on extremely hard materials such as tungsten carbide, glass, ceramics, enamel, stone and GRP/CRP.

Detailed information on diamond grinding tools can be found in our Tool Manual 23, catalogue section 5.



Abrasive:

Diamond

D 251 = P 60

D 126 = P 120

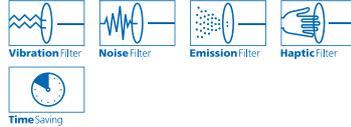
D 76 = P 220

(P = Grit size according to ISO 6344)

Ordering notes:

- Please complete the description with the desired grit size.
- Grit sizes are indicated in μm .

PFERDVALUE:



Recommendations for use:

- For the best results, use at a recommended cutting speed of 10–20 m/s.
- Use with hard or medium-hard COMBIDISC abrasive disc holders.

D ₁ [mm]	Grit size [μm]			Opt. RPM		Description
	251	126	76			
	EAN 4007220					
CD system 						
25	750292	750315	750322	7,500–15,000	10	CD DIA 25 D ...
38	750339	750346	750353	5,000–10,000	10	CD DIA 38 D ...
50	750360	750377	750384	3,800–7,500	10	CD DIA 50 D ...
75	750391	750407	750414	2,500–5,000	10	CD DIA 75 D ...
CDR system 						
25	750421	750438	750445	7,500–15,000	10	CDR DIA 25 D ...
38	750452	750469	750476	5,000–10,000	10	CDR DIA 38 D ...
50	750483	750490	750506	3,800–7,500	10	CDR DIA 50 D ...
75	750513	750520	750537	2,500–5,000	10	CDR DIA 75 D ...



COMBIDISC grinding tools

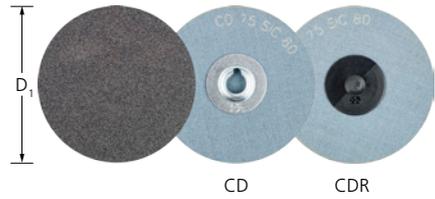
Abrasive discs CD, CDR

Silicon carbide SiC type

For universal grinding work on components made from aluminium, copper, bronze, titanium and fibre-reinforced plastics.

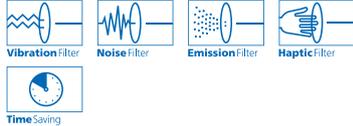
Particularly recommended for use on titanium alloys.

Ideally suited to use in the aeronautical industry, especially where SiC is the only approved abrasive, e.g. for use on engine components.



Abrasive:
Silicon carbide SiC

PFERDVALUE:



Ordering notes:

- Please complete the description with the desired grit size.

D ₁ [mm]	Grit size					Opt. RPM		Description
	36	60	80	120	240			
	EAN 4007220							
CD system 								
50	441176	441183	441190	441206	441213	3,800–13,000	100	CD 50 SiC ...
75	441220	441237	441244	441251	441268	2,500–9,000	50	CD 75 SiC ...
CDR system 								
50	778470	778487	778494	778500	778517	3,800–13,000	100	CDR 50 SiC ...
75	778524	778548	778555	778562	778579	2,500–9,000	50	CDR 75 SiC ...



COMBIDISC grinding tools

Abrasive discs CDR

RS type

RS type COMBIDISC abrasive discs are outstandingly well suited for weld dressing of backwards repair welds, e.g. in cases, slots and grooves on engines and for processing welded-on combustor plates. Unlike on conventional abrasive discs, the abrasive coating is on the underside of the tool, which allows backwards working.



Advantages:

- Ideal for use in extremely difficult to reach locations.
- Convenient and safe backward working.

Recommendations for use:

- Move the tool to the location to be worked. To grind, do not push it onto the surface, pull it towards yourself.
- To ensure optimum utilization of the grinding surface using the SBHR 20 or SBHR 25 abrasive disc holder. More detailed information and ordering data can be found on page 21.
- Always use the RS abrasive discs at the specified optimum rotational speed and do not adhere to the maximum permitted rotational speeds of the SBHR 20 or SBHR 25 holder.

RS aluminium oxide A-PLUS type

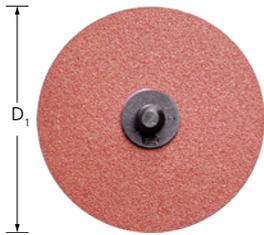
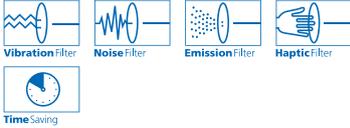
For universal applications from coarse to fine grinding, with a high stock removal rate and long tool life.

Abrasive:
Aluminium oxide A-PLUS

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size			Opt. RPM		Description
	60 PLUS	80 PLUS	120 PLUS			
	EAN 4007220					

CDR system



38	241967	241974	241981	10,000–16,000	100	CDR 38 A ... RS
50	242001	242025	242391	8,000–13,000	100	CDR 50 A ... RS
75	242407	242414	242421	5,000–9,000	50	CDR 75 A ... RS



COMBIDISC grinding tools

Abrasive discs CDR

Midget fibre discs RS ceramic oxide grain CO-COOL type

For aggressive grinding with maximum stock removal rate on hard materials which do not conduct heat well. Consistently high performance due to self-sharpening ceramic oxide grain.

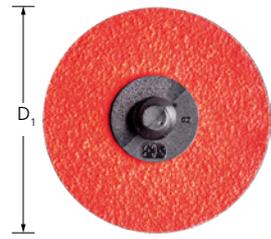
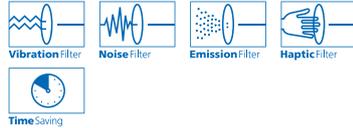
Active grinding additives in the coating substantially improve the stock removal rate, prevent clogging and result in cooler grinding.

Abrasive:
Ceramic oxide grain CO-COOL

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size			Opt. RPM		Description
	50	80	120			
EAN 4007220						

CDR system

38	074671	222829	222843	10,000–16,000	100	CDFR 38 CO-COOL ... RS
50	241783	241790	241806	3,800–13,000	100	CDFR 50 CO-COOL ... RS
75	241813	241820	241844	2,500–9,000	50	CDFR 75 CO-COOL ... RS

Silicon carbide SiC type

For universal grinding work on components made from aluminium, copper, bronze, titanium and fibre-reinforced plastics.

Particularly recommended for use on titanium alloys.

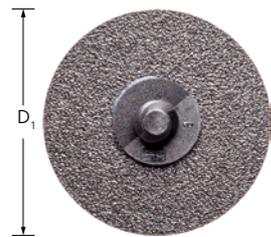
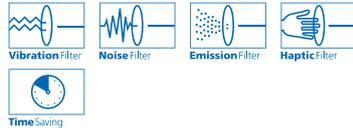
Ideally suited to use in the aeronautical industry, especially where SiC is the only approved abrasive, e.g. for use on engine components.

Abrasive:
Silicon carbide SiC

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size			Opt. RPM		Description
	60	80	120			
EAN 4007220						

CDR system

38	241851	241868	241875	10,000–16,000	100	CDR 38 SiC ... RS
50	241882	241899	241912	3,800–13,000	100	CDR 50 SiC ... RS
75	241929	241936	241943	2,500–9,000	50	CDR 75 SiC ... RS



COMBIDISC grinding tools

POLICLEAN discs CD, CDR

PCLR and PCLR PLUS types

For coarse cleaning work such as removing paint, scale, heat discoloration, rust and adhesive residues in face-down grinding.

POLICLEAN-PLUS discs (blue) exhibit a higher stock removal rate with a very long tool life.

Applications:

roughening, surface work, cleaning

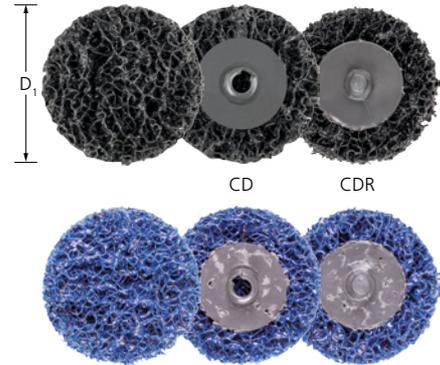
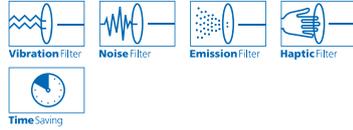
Abrasive:

Aluminium oxide A
Silicon carbide SiC

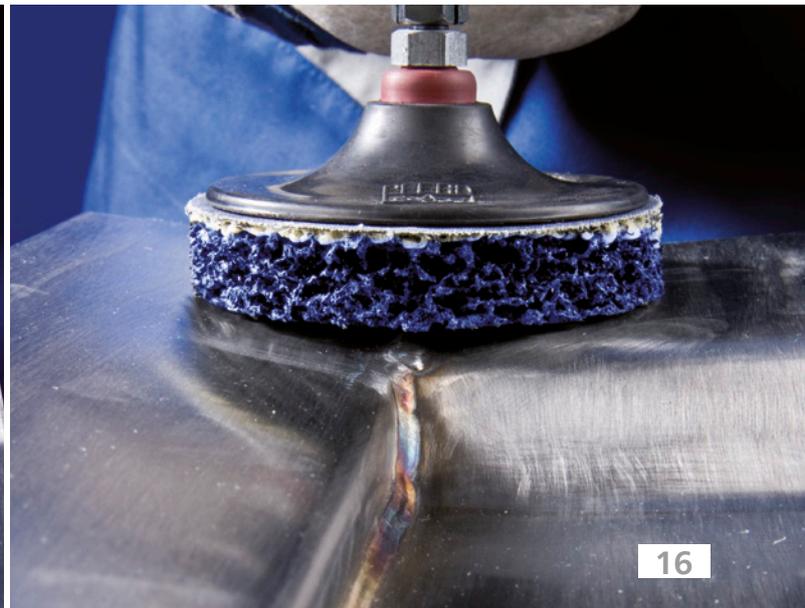
Recommendations for use:

- Use with hard or medium-hard COMBIDISC abrasive disc holders.

PFERDVALUE:



D ₁ [mm]	Type	Abrasives	EAN 4007220	Opt. RPM		Description
CD system 						
50	PCLR	SiC	471500	5,500–8,000	10	CD 50 PCLR
75	PCLR	SiC	471517	3,800–5,000	10	CD 75 PCLR
50	PCLR PLUS	A	069288	5,500–8,000	10	CD 50 PCLR PLUS
75	PCLR PLUS	A	069295	3,800–5,000	10	CD 75 PCLR PLUS
CDR system 						
50	PCLR	SiC	677124	5,500–8,000	10	CDR 50 PCLR
75	PCLR	SiC	677131	3,800–5,000	10	CDR 75 PCLR
50	PCLR PLUS	A	069301	5,500–8,000	10	CDR 50 PCLR PLUS
75	PCLR PLUS	A	069318	3,800–5,000	10	CDR 75 PCLR PLUS



COMBIDISC grinding tools

Non-woven discs CD, CDR

Hard type VRH

Suitable for universal work on small and medium-sized metal surfaces, e.g. removing rough grinding traces, removing oxidation and light deburring work. Achieve matt and satin-finished surfaces.

Applications:

roughening, deburring, surface work, cleaning, weld dressing, structuring, fine grinding in multiple steps

Abrasive:

Aluminium oxide A
Available POLIVLIES grit sizes:
100 G = coarse (yellow-brown)
180 M = medium (red-brown)
240 F = fine (blue)

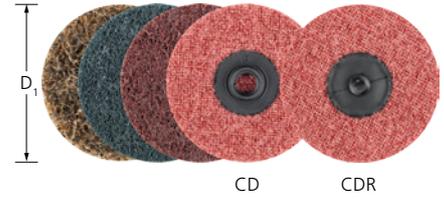
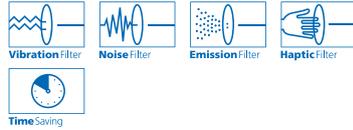
Recommendations for use:

■ The addition of oil or water during grinding results in a finer finish, cooler grinding and longer tool life.

Ordering notes:

■ Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size			Opt. RPM		Description
	100 G	180 M	240 F			
	EAN 4007220					
CD system 						
20	628218	584507	265871	14,000–19,000	50	CD VRH 20 A ...
25	268865	266564	266571	11,000–15,000	50	CD VRH 25 A ...
38	266588	266595	268872	7,000–10,000	50	CD VRH 38 A ...
50	266618	266625	266632	5,500–7,500	50	CD VRH 50 A ...
75	266649	266656	266663	3,800–5,000	25	CD VRH 75 A ...
CDR system 						
38	596906	596913	596920	7,000–10,000	50	CDR VRH 38 A ...
50	596937	596944	596951	5,500–7,500	50	CDR VRH 50 A ...
75	596968	596975	597354	3,800–5,000	25	CDR VRH 75 A ...



COMBIDISC grinding tools

Non-woven discs CD, CDR

Soft type VRW

Suitable for very fine grinding on small and medium-sized surfaces and contours, and for cleaning metal and painted surfaces. Achieve matt and satin-finished surfaces. Highly open structure.

Applications:

roughening, deburring, surface work, cleaning, weld dressing, structuring, fine grinding in multiple steps

Abrasive:

Aluminium oxide A
Available POLINOX grit sizes:

- 100 = medium
- 180 = fine
- 280 = very fine

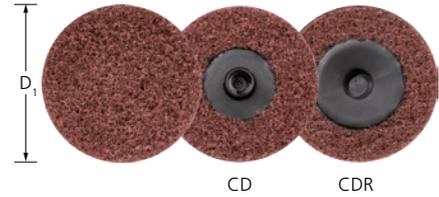
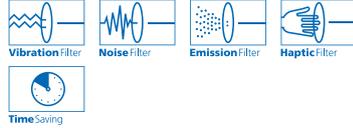
Recommendations for use:

- The addition of oil or water during grinding results in a finer finish, cooler grinding and longer tool life.

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size			Opt. RPM		Description
	100	180	280			
EAN 4007220						
CD system 						
38	537039	450345	450352	7,000–10,000	50	CD VRW 38 A ...
50	266670	266687	266694	5,500–7,500	50	CD VRW 50 A ...
75	266717	266724	266731	3,800–5,000	25	CD VRW 75 A ...
CDR system 						
50	596999	597002	597019	5,500–7,500	50	CDR VRW 50 A ...
75	597026	597033	597040	3,800–5,000	25	CDR VRW 75 A ...



COMBIDISC grinding tools

Non-woven discs CD, CDR

PNER type

For achieving a very fine, uniform surface finish which, depending on requirements, is a sufficient preparation for high-gloss polishing. Particularly suitable for work on small and medium-sized surfaces of stainless steel (INOX) components.

The different thicknesses/hardnesses of the non-woven material are colour-coded:

- W (soft) = grey
- MH (medium-hard) = dark blue
- H (hard) = red

Applications:

roughening, deburring, surface work, cleaning, weld dressing, structuring, fine grinding in multiple steps

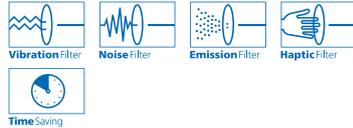
Abrasive:

Aluminium oxide A
Silicon carbide SiC

Ordering notes:

- Please complete the description with the desired grit size.
- The non-woven discs are supplied with a thickness of 6 mm.

PFERDVALUE:



D ₁ [mm]	Abrasives	Type			Grit size	Opt. RPM	Max. RPM		Description
		W (soft)	MH (medium-hard)	H (hard)					
EAN 4007220									

CD system



50	A	832783	-	832851	coarse	9,500	19,100	25	CD PNER-... 5006 A G
	SiC	832776	832790	-	fine	9,500	19,100	25	CD PNER-... 5006 SiC F
	A	-	832806	832813	fine	9,500	19,100	25	CD PNER-... 5006 A F
75	A	832868	-	832905	coarse	6,400	12,500	25	CD PNER-... 7506 A G
	SiC	832837	832875	-	fine	6,400	12,500	25	CD PNER-... 7506 SiC F
	A	-	832882	832899	fine	6,400	12,500	25	CD PNER-... 7506 A F

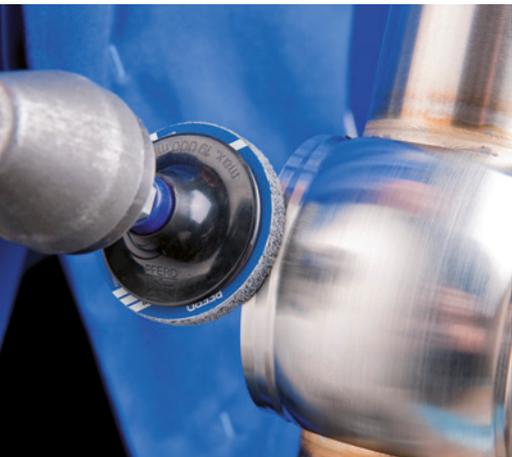
CDR system



50	A	832660	-	832707	coarse	9,500	19,100	25	CDR PNER-... 5006 A G
	SiC	832653	832677	-	fine	9,500	19,100	25	CDR PNER-... 5006 SiC F
	A	-	832684	832691	fine	9,500	19,100	25	CDR PNER-... 5006 A F
75	A	832721	-	832769	coarse	6,400	12,500	25	CDR PNER-... 7506 A G
	SiC	832714	832738	-	fine	6,400	12,500	25	CDR PNER-... 7506 SiC F
	A	-	832745	832752	fine	6,400	12,500	25	CDR PNER-... 7506 A F



For further information on non-woven products in the PNER type please refer to our brochure "Non-woven tools PNER and PNK – The professionals for high-grade surfaces" at www.pferd.com.



COMBIDISC grinding tools

TX discs CD

Aluminium oxide A type

For achieving fine, matt grinding finishes in one process. The very sturdy granular bond facilitates very aggressive abrasive performance. Particularly suitable for work on stainless steel (INOX) and aluminium.

Applications:

deburring, surface work, weld dressing, structuring, fine grinding in multiple steps

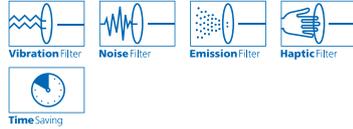
Abrasive:

Aluminium oxide A

Ordering notes:

- Please complete the description with the desired grit size.

PFERDVALUE:



D ₁ [mm]	Grit size				Opt. RPM		Description
	36 TX	80 TX	120 TX	320 TX			
EAN 4007220							

CD system							
50	505724	505731	505748	505755	7,500–9,500	25	CD 50 A ...
75	505786	505793	505809	505816	5,000–6,500	25	CD 75 A ...

Felt discs CD, CDR

FR type

Suitable for polishing with polishing paste bars, grinding pastes or diamond polishing pastes in face-down grinding on small and medium-sized surfaces.

Applications:

polishing

Recommendations for use:

- Use COMBIDISC felt discs with an abrasive disc holder on flexible shaft drives with an angle handpiece or small compressed-air or electric angle grinders.
- For the best results, use at a recommended cutting speed of 5–10 m/s. This provides an ideal compromise between polishing performance, thermal load on the workpiece and tool wear.
- When applying a different polishing paste, use a new unused felt disc.

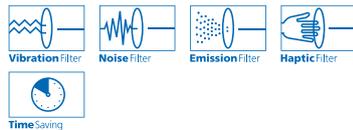
Ordering notes:

- Further information on felt tools can be found in our Tool Manual 23, catalogue section 4, page 144.

Accessories:

Grinding and polishing pastes (Tool Manual 23, catalogue section 4, pages 153–154)

PFERDVALUE:



D ₁ [mm]	EAN 4007220	Opt. RPM		Description
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CD system				
50	440490	2,000–4,000	10	CD FR 50
75	440506	1,200–2,500	10	CD FR 75

CDR system				
50	004784	2,000–4,000	10	CDR FR 50
75	004791	1,200–2,500	10	CDR FR 75



COMBIDISC grinding tools

Abrasive disc holders

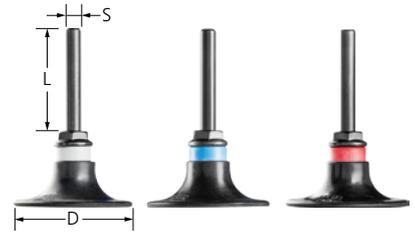
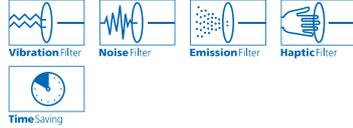
SBH and SBHR types

Matching arbors for COMBIDISC grinding tools. Available in three different hardness grades.

Ordering notes:

- The different hardness grades are colour-coded:
 - W (soft) – grey;
 - M (medium) – blue;
 - H (hard) – red
- Please complete the description with the desired hardness grade.

PFERDVALUE:



D [mm]	S [mm]	L [mm]	Hardness			Max. RPM		Description
			W (soft)	M (medium)	H (hard)			
EAN 4007220								

CD system

20	6	40	-	265901	-	47,500	1	SBH 20 ...
25	6	40	-	266755	-	38,000	1	SBH 25 ...
38	6	40	266762	266779	266786	25,000	1	SBH 38 ...
50	6	40	266793	266809	266816	19,000	1	SBH 50 ...
75	6	40	266823	266830	266847	12,500	1	SBH 75 ...

CDR system

20	6	40	-	776315	-	47,500	1	SBHR 20 ...
25	6	40	-	776322	-	38,000	1	SBHR 25 ...
38	6	40	776346	597057	776339	25,000	1	SBHR 38 ...
50	6	40	776360	597064	776353	19,000	1	SBHR 50 ...
75	6	40	776384	597071	776377	12,500	1	SBHR 75 ...

Adapters:

The shank of the abrasive disc holders can be replaced by suitable adapters. This enables the abrasive disc holder to be mounted directly to the drive spindle of the tool drive.

The following adapters are available:



AF 14-1/4 CD,
(EAN 4007220**302026**)
Female thread M14,
male thread 1/4-20 UNC.
Suitable for drives with
spindle M14.



SPV-20 CD 1/4-20 UNC,
(EAN 4007220**333167**)
Female thread 1/4-20 UNC,
male thread 1/4-20 UNC.
Suitable for drives with
spindle 1/4-20 UNC, e.g. for
PW 3/120 DH.



AF M5 CD 1/4-20 UNC
(EAN 4007220**064702**)
Male thread M5,
male thread 1/4-20 UNC.
Suitable for cordless angle
grinder, dia. 75, with spindle
M5 (female thread).



COMBIDISC grinding tools

Sets

COMBIDISC SET

Set of various COMBIDISC tools.

Contents:

- 3 pcs. each of COMBIDISC abrasive discs:
 - CD A 60 FORTE
 - CD A 120 FORTE
 - CD A-COOL 60
 - CD CO-COOL 36
 - CD Z 60
- 3 pcs. each of COMBIDISC non-woven discs:
 - CD VRH A 180 M
 - CD VRW A 100
- 1 pc. each of:
 - Abrasive disc holder SBH M

Advantages:

- Getting to know and testing the comprehensive system.
- Coordinated selection of the most common versions.

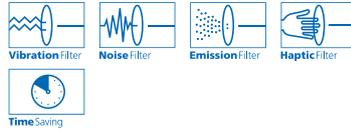
Abrasive:

- Aluminium oxide A
- Zirconia alumina Z
- Aluminium oxide A-FORTE
- Aluminium oxide A-COOL
- Ceramic oxide grain CO-COOL

Recommendations for use:

- Use COMBIDISC grinding tools with an arbor or abrasive disc holder on flexible shaft drives with an angle handpiece or small compressed-air or electric angle grinders.

PFERDVALUE:



D ₁ [mm]	EAN 4007220		Description
50	265918	1	COMBIDISC-SET 50
75	265932	1	COMBIDISC-SET 75

SET CD UWER

Set of different COMBIDISC tools, including single-hand angle grinder, for all coarse and fine grinding, polishing and cleaning work, especially on assembly and construction sites.

Contents:

- Electric angle grinder UWER 5/200 SI with electronic rotational speed control (9,000–20,000 RPM), output 500 watts
- 4 abrasive disc holders and 2 adapters for alternative tool drives
- 135 different abrasive discs, TX discs, Mini-POLIFAN, non-woven and felt discs with a diameter of 50 mm
- Polishing paste bar for using felt discs

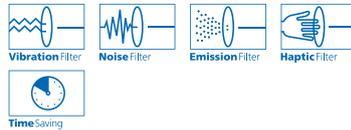
Advantages:

- Entire rotational speed range covered for COMBIDISC tools with a diameter of 50 mm.
- Easy and comfortable to use thanks to the handy angle grinder design.
- Coordinated selection of the most common versions.

Ordering notes:

- Detailed information and ordering data on tool drives can be found in in our Tool Manual 23, catalogue section 9.

PFERDVALUE:



D ₁ [mm]	EAN 4007220		Description
50	607893	1	SET CD 50 UWER 5/200 230 V

COMBIDISC grinding tools

DUST REMOVER

DUST REMOVER

With the COMBIDISC DUST REMOVER, grinding dust can be extracted very effectively from places where something is ground. It can be universally used with all dust extraction systems (portable or stationary). The DUST REMOVER can be used with CD and CDR backing pads.

Advantages:

- Clean work environment with less dust.
- Compatible with all drive systems.
- Flexible tube for easy accessibility.

Recommendations for use:

- To guarantee effective extraction, the volumetric flow rate has to be at least 300 m³/h.
- Reducing the rotational speed increases the effectiveness of extraction.

Matching tool drives:

- Flexible shaft drives
- Straight grinders
- Angle grinders
- Cordless angle grinders

Ordering notes:

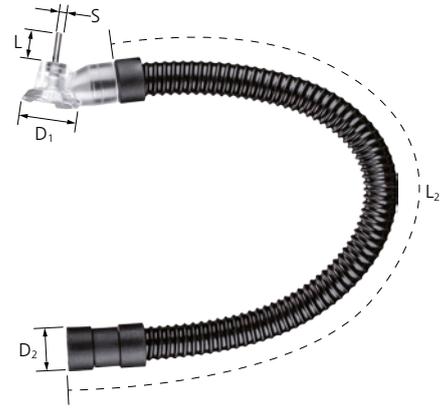
- Please order arbors or COMBIDISC abrasive disc holders separately.
- When ordering, please state the EAN or the full description.

Safety notes:

- The maximum permitted peripheral speed is 50 m/s.
- For safety reasons, the specified maximum permitted rotational speed must never be exceeded.

Accessories:

- CD and CDR abrasive disc holders with a diameter of 50 mm or 75 mm.



D ₁ [mm]	S [mm]	L [mm]	Thread	D ₂ [mm]	L ₂ [mm]	EAN 4007220	Suitable arbors		Description
50	6	27	1/4-20 UNC	37	600	158074	CD/CDR 50	1	CD DUST REMOVER CD-DR 50
75	6	27	1/4-20 UNC	37	600	158081	CD/CDR 75	1	CD DUST REMOVER CD-DR 75

