

CUMI

ABRASIVES FOR

AUTO OEM

PRODUCT
CATALOGUE

CARBORUNDUM UNIVERSAL LIMITED

CUMI

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BEARING INDUSTRY

BONDED ABRASIVES



BONDED ABRASIVES

About Bonded Abrasives

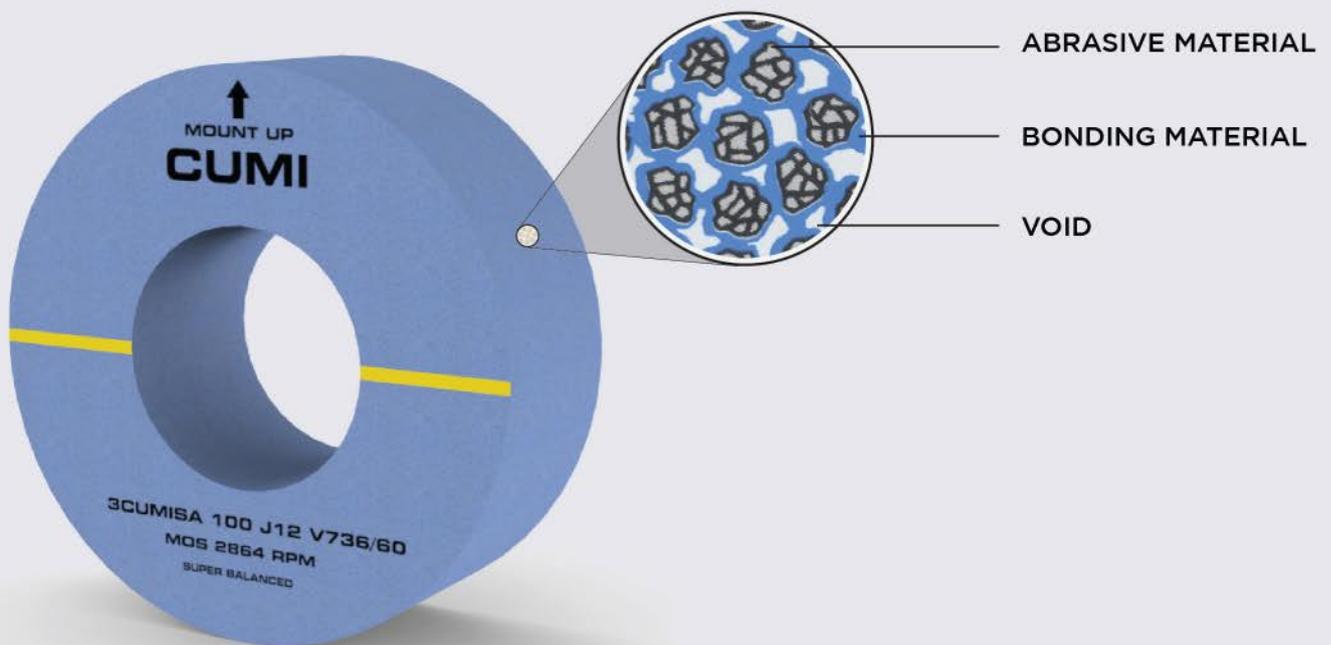
Bonded abrasives is a terminology collectively used for a range of abrasive products where abrasive grains are held together by bonding materials moulded into various shapes like grinding wheels, segments, dressing sticks, mounted points etc.,

Grinding wheel is a multi point cutting tool composed of abrasive grains held together by bonding material (bond) and separated by voids. The abrasive grains provide the cutting points, which in turn helps in cutting the material to the required dimensional accuracy or help impart a fine surface finish. The arrangement of the abrasive grains and the bond in the grinding wheels gives a specific volume of pores known as 'structure'. These pores are designed based on application needs and provide chip clearance.

The major types of grinding are

a) Precision grinding b) Non-Precision grinding or Offhand grinding

With latest developments in technology, we at CUMI pride ourselves in being one of the top manufacturers in the world for both precision and non-precision grinding applications. Our range of grinding wheels are used for various grinding applications that include Ball Grinding & Lapping, Crankshaft & Camshaft grinding, Gear grinding, Centerless grinding, Cylindrical grinding, Creep feed grinding, Thread grinding, Flute grinding, Roll grinding, Bore grinding, Track grinding, Face grinding and Surface grinding



UNDERSTANDING THE NOMENCLATURE

CUMI BONDED ABRASIVES MARKING

A	46	3	L	5	V2016	/45
↓	↓	↓	↓	↓	↓	↓
ABRASIVE TYPE	GRIT SIZE	GRIT COMBINATION	HARDNESS	STRUCTURE	BOND SYSTEM	WHEEL SPEED
Alumium Oxide A, AA, RA, RAA, SA, DA, HA, MCA, CUMISA	8, 10, 12, 14 16, 20, 24, 30 36, 46, 54, 60		DEFGH IJKL			
Silicon Carbide C, GC, CGC	80, 100, 120 150, 180, 220 240, 280, 320	1 3 5 7	MNOPQ RST	1 2 3 4 5 6 7 8.. ...UPTO 35	V - Vitrified B - Resinoid R - Rubber	
Zircon Alumina ZA	400,600,800, 1200, 1500		UVWX YZ			

ABRASIVE GRAINS

A	46	3	L	5	V2016	/45
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An Abrasive is a mineral crystal with hardness much higher than that of work piece. An Abrasive grain cuts into the work until it becomes dull. Then it breaks down (fractures) and exposes new cutting edges.

The principle properties to be considered when choosing an abrasive are as follows:

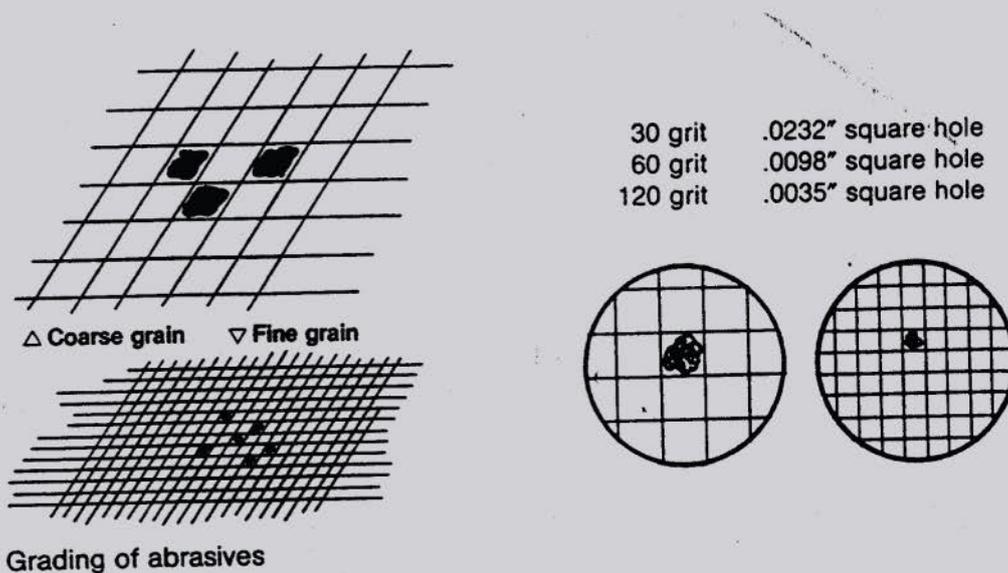
- **HARDNESS** - Resistance to Penetration
- **TOUGHNESS** - Ability to Withstand Load
- **FRIABILITY** - Ability to Fracture Under Load
- **THERMAL CONDUCTIVITY** - Ability to Conduct Heat

GRAIN TYPE	CODE	PROPERTIES & APPLICATIONS
Brown Aluminium Oxide	A	Tough grain for high tensile strength materials
Semi Friable Aluminium Oxide	SA	Free cutting grain with good form holding for complete range of steels
White Aluminium Oxide	AA	Pure Aluminium Oxide for hardened or high speed steels
Pink Aluminium Oxide	RA	Friable grain for Alloyed and Chromium Based Materials
Pink Aluminium Oxide blend	RAA	Combination of Pink and White Aluminium Oxide grains for added advantage
Ruby Pink Aluminium Oxide	24R	Tough pink grain for improved form retention
Brown and White Aluminium Oxide blend	DA	Combination of White and Brown Aluminium Oxide grains for dual advantage
Friable Aluminium Oxide	SBA	Friable grain for improved dressing
Pure Aluminium Oxide	12A	Premium grain for high performance
Premium Aluminium Oxide blend	65A	For best all round performance in cylindrical applications
Sharp Premium Aluminium Oxide blend	55A, 53A	Sharp and pure Aluminium Oxide grains for grinding hard materials
Sharp Crystal Aluminium Oxide	HA	Sharp crystalline grain combination of premium performance on all materials
Ceramic Aluminium Oxide	CUMISA	Sharp Ceramic grain for high MRR & GR requirements
Ceramic Aluminium Blend	MCA	Sharp Ceramic grain for high MRR & GR requirements
Black Silicon Carbide	C	Hard and friable grain for non ferrous material, cast iron and stainless steel
Green Silicon Carbide	GC	Hard and friable grain for grinding cemented carbide tools, hard & high chilled cast iron rolls etc
Silicon Carbide blend	CGC	Combination of C & GC
Silicon Carbide and Aluminium Oxide blend	CA	Combination of Aluminium Oxide & Silicon Carbide for Alloy steel and Stainless steel
Zirconia Alumina	AZA	Alumina Zirconia Alloy - Hard & tough grain for very high performance

GRIT SIZE

A	46	3	L	5	V2016	/45
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The size of the abrasive grain is expressed by the size of the screen opening through which the grains are shifted or sorted. For instance. A grain or grit which goes through a screen 8 mesh or openings per linear inch is called 8 grain or grit size, while a 24 grit size is roughly twenty fourth of an inch across. The higher the grit size, the finer its type.



GRIT COMBINATION

A	46	3	L	5	V2016	/45
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- Combination of different grit sizes in predetermined percentages
- Ex. A463 L5 V10 - combination of 46,54& 60 grits. Primary grit 46 will be at higher percentage.

GRADE HARDNESS

A	46	3	L	5	V2016	/45
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Grade hardness is the volume of the bond present in the wheel.

For a wheel of a particular bond type, the amount of bond used in the wheel mainly determines its hardness. When the amount of bond is increased, the size of the bond posts connecting each abrasive grain to its neighbours is also increased. The larger bond post is naturally stronger, thereby increasing the wheel's hardness.

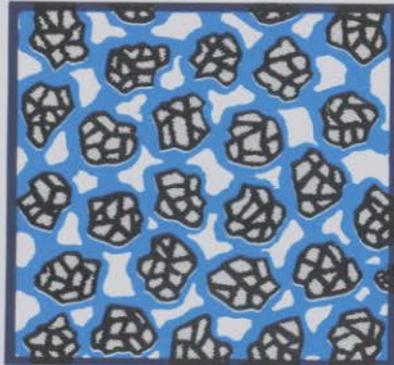
Grade hardness is therefore not a measure of the hardness of the abrasive, but of the durability of the wheel. A hard abrasive can be bonded into a soft, free cutting wheel by using less bond, while an increase in the amount of bond can make the wheel act harder. Wheel grading range from D for the softest, to Z+ for the hardest.

STRUCTURE

Structure is an indication of the abrasive grains in a wheel. This is defined by the voids or spaces between the abrasive grain and the bonding material and is called wheel porosity. A close structured wheel is one, where the volume of closely packed grains are more. These are given structured numbers of 1 and 2. Conversely. Open structure wheels are those with wider grain spacing.



Dense Spacing



Medium Spacing



Open Spacing

Spacing of abrasive grains measured in volume of abrasive particles- higher the number, more porous the wheel structure.

5= normal porosity; 3= dense; 7=porous

DESCRIPTION	OPEN STRUCTURE	CLOSED STRUCTURE
Material Removal Rate	High	Low
Grinding Ration	Low	High
Area / Arc of Contact	High	Low
Severity of Operation	High	Low
Form Holding	Poor	Good
Wheel Speed	Low	High
Type of Operation	High stock removal, Creep Feed	Normal stock removal
Thermal conductivity of work material	Low	High

BOND

A	46	3	L	5	V2016	/45
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- The bonding material which holds the Abrasive Grains together in a wheel.
- Selection of suitable Grain, Grit size, Grade Hardness & Structure can make the wheel to work but selection of a suitable Bond plays a major role in enhancing the performance of a wheel.
- CUMI has tailor made bonds depending upon the Application, Grinding Efficiency (derived from Grinding Ratio and Specific Material Removal Rate), wheel speeds etc.

Vitrified Bond (V)	Resinoid Bond (B)	Rubber Bond (R)
Glossy Bond Made of Ingredients available Naturally	Made of Phenolic Thermo Setting Resins	Made of Natural / Synthetic Rubber
Very Brittle	Very Resilient - Can withstand shock loads	Better Resiliency - Can withstand shock loads
Water, Chemical Resistance	Low Water, Chemical Resistance	Water, Chemical Resistance
Very good Form Retention	Good Form Retention	Good Form Retention
No Shelf Life	Shelf life 1-2 Years	No Shelf Life
Severity of Operation - Low	Severity of Operation - High	Severity of Operation - High
For Wheel Speeds upto 100 metres per sec	For Wheel Speeds upto 100 metres per sec	For Wheel Speeds upto 45 metres per sec
Applicable for almost any kind of application	Gives cool cutting and is more suitable for application with high area of contact, High Material Removal Rate.	For applications where very fine surface finish is required

WHEEL SPEED

A	46	3	L	5	V2016	/45
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Effect of wheel and work speed on grinding action

SPEED	INCREASED	DECREASED
Wheel speed	Harder	Softer
Work Speed	Softer	Harder
Traverse Speed	Softer	Harder
Infeed rate	Softer	Harder

WHEEL SPEED	COLOR BAND
33/35 mps	No Band
45/50 mps	Blue Band
60/63 mps	Yellow Band
80 mps	Red Band
100 mps	Green Band

WHEEL SELECTION

CUMI has one of the widest range of grinding wheels in the world. Available in standard sizes or customized to specific grinding requirements, these premier quality wheels are manufactured to suit the varied grinding needs of all user. Since there are as many types of wheels as there are grinding applications, correct wheel usage assumes very critical importance.

FACTORS AFFECTING THE SELECTION OF A GRINDING WHEEL

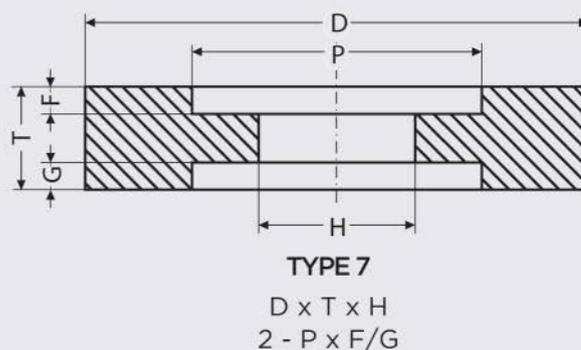
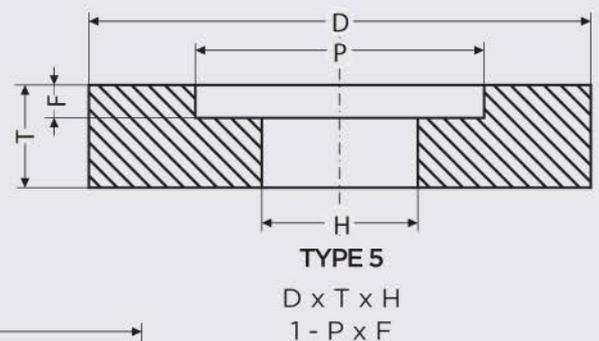
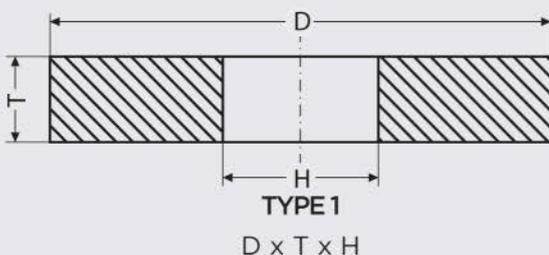
Wheel selection is dependent type of material to be ground and the type of grinding operation. The eight important factors that need to be considered in the selection of a grinding wheel

1. Material to be ground and its hardness
2. Stock removal and surface finish
3. The grinding process-whether wet or dry
4. Peripheral speed of the wheel
5. The area of grinding contact-large or small
6. The severity of grinding operation
7. Condition of grinding machine
8. Type of grinding machine

STANDARD GRINDING WHEEL SHAPES

STRAIGHT WHEELS

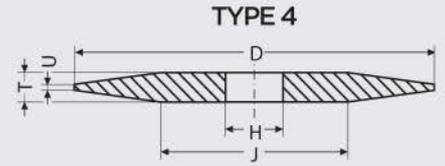
Type 1, 5 & 7 wheels are standard for internal grinding, cylindrical grinding, tool grinding, offhand grinding and snagging. The recess in Type Nos. 5 and 7 gives clearance for the mounting flanges.



STANDARD GRINDING WHEEL SHAPES

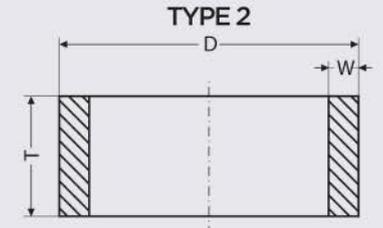
TAPERED WHEELS

Type 4 wheel, is a modification on Type 1 wheel having a taper on both sides and is used principally in snagging operations. Tapered wheels with tapered mounting flanges are a safety device to prevent pieces of the wheel from flying out should the wheel break in operation.



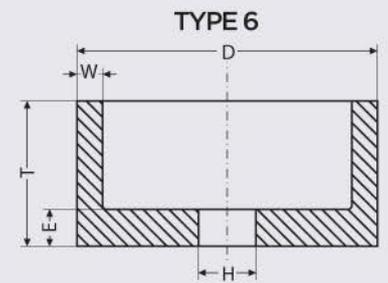
CYLINDER WHEELS

Type 2 wheel is used for surface grinding on both horizontal and vertical spindle machines with the grinding performed on the face of the wheel



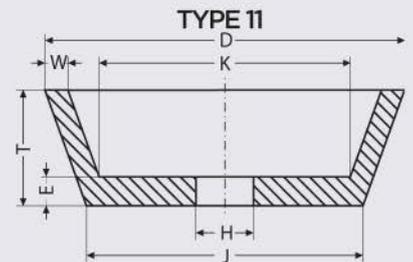
STRAIGHT CUP WHEELS

Type 6 wheel is a straight cup wheel and is used primarily for surface grinding on horizontal or vertical spindle machines. It is also useful for off-hand grinding in order to generate a flat surface. Available in either plain or bevel face.



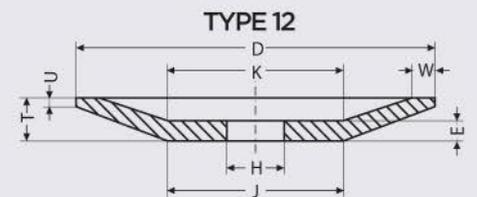
FLARING CUP WHEELS

Type 11 wheel is a flaring cup wheel used for grinding various surfaces requiring flatness. It is supplied with either a plain or bevelled face.



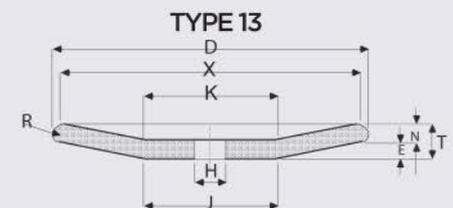
DISH WHEELS

Type 12 wheel is a dish wheel for grinding in the tool room. Its thinness permits the insertion of the grinding edge of the wheel into narrow places.



SAUCER WHEELS

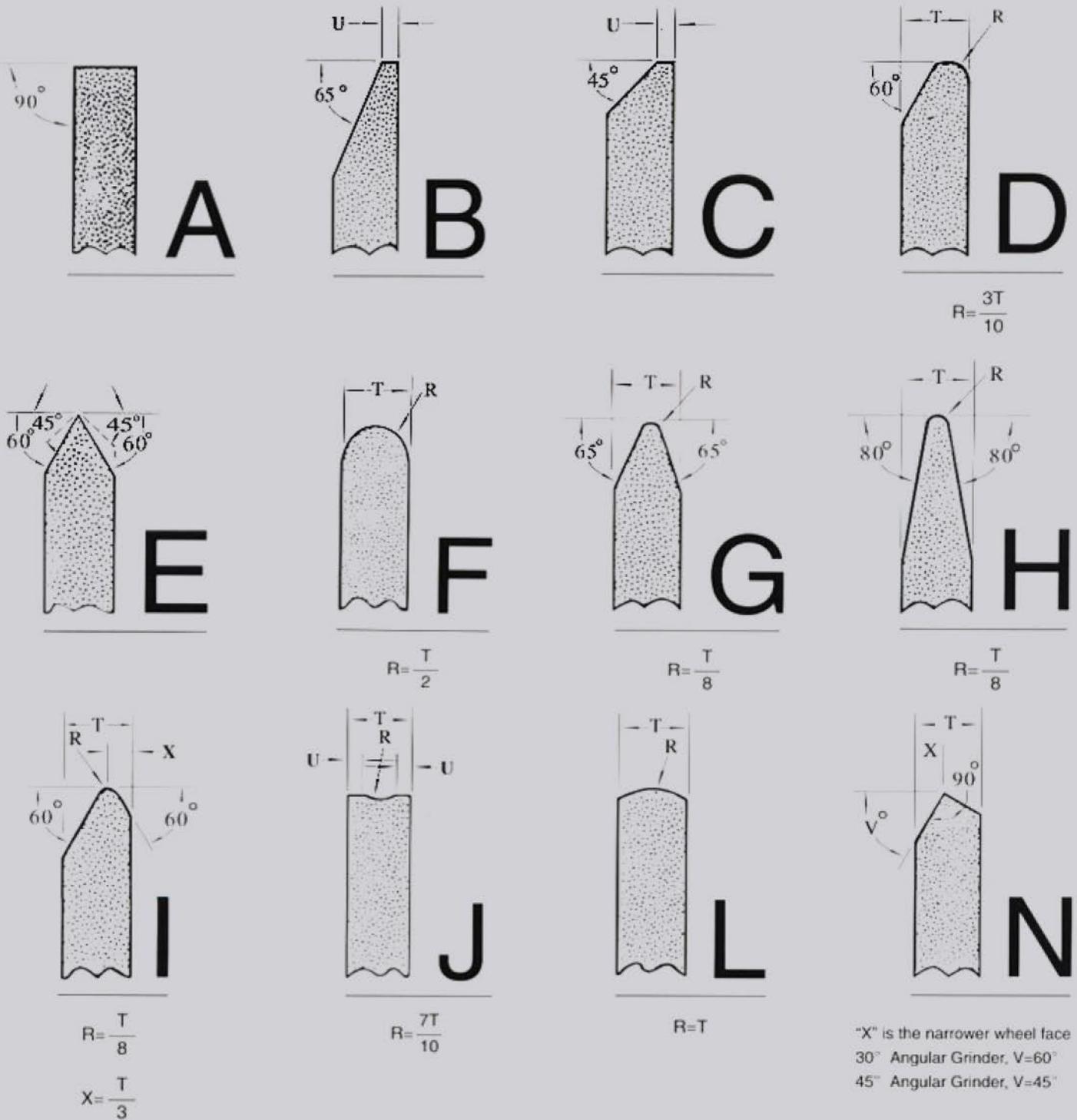
Type 13 wheel is a saucer wheel or saw gummer. Its name is derived from its use for re-sharpening saws (saw gumming).



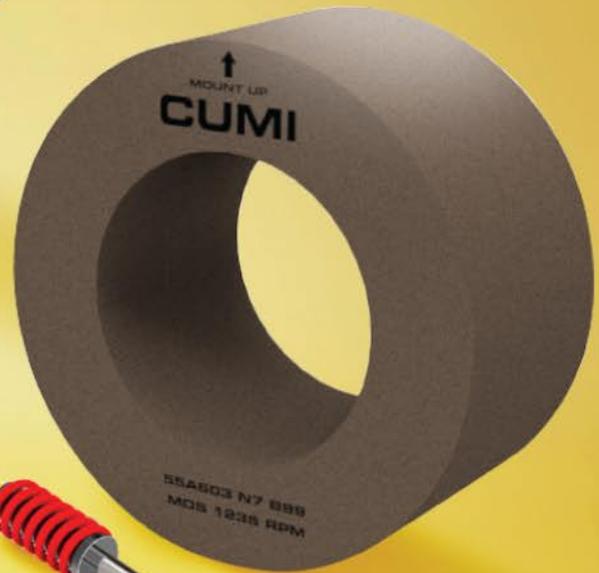
- D: Diameter (overall)
- E: Thickness at hole or back thickness
- F: Depth of recess (see type 5 & 7)
- G: Depth of recess (see type 7)
- H: Hole
- J: Diameter of outside flat
- K: Diameter of inside flat

- M: Large Diameter of bevel
- P: Diameter of recess
- R: Radius of corner
- T: Thickness (overall)
- U: Width of edge
- W: Wall thickness of grinding face

STANDARD GRINDING WHEEL SHAPES



CENTERLESS



CYLINDRICAL GRINDING WHEELS

GENERAL PURPOSE

Hardness	Speed	Best	Better	Good
< 40 HRc	35	AA463 M5 V2016	SBA463 M5 V10	A463 M5 V10
	50	1CUMISA541 L6 VC500/45	5SA463 L5 V500/45	DA463 M5 V45
	63	1CUMISA541 L6 VC500/60	AA463 L5 V60	5SA463 L5 V500/60
50 HRc to 60 HRc	35	AA463 K5 V2016	SBA463 K5 V10	A463 K5 V10
	50	1CUMISA541 J6 VC500/45	5SA463 J5 V500/45	DA463 K5 V45
	63	1CUMISA541 J6 VC500/60	AA463 J5 V60	5SA463 J5 V500/60

CAST IRON

Hardness	Speed	Best	Better	Good
< 40 HRc	35	GC463 N5 VG	CGC463 M5 VG	C463 M5 VG
	50	GC463 N5 VS2001/45	CGC463 M5 VS2001/45	C463 M5 VS2001/45
	63	-	-	-
50 HRc to 60 HRc	35	GC463 L5 VG	CGC463 K5 VG	C463 K5 VG
	50	GC463 L5 VS2001/45	CGC463 K5 VS2001/45	C463 K5 VS2001/45
	63	-	-	-

STEEL

Hardness	Speed	Best	Better	Good
< 40 HRc	35	AA463 M5 V2016	SBA463 M5 V10	A463 M5 V10
	50	1CUMISA541 L6 VC500/45	5SA463 L5 V500/45	DA463 M5 V45
	63	1CUMISA541 L6 VC500/60	AA463 L5 V60	5SA463 L5 V500/60
50 HRc to 60 HRc	35	1CUMISA541 K6 VC500	5SAA463 K5 V500	AA46/54 K5 V8
	50	1CUMISA541 K6 VC500/45	5SAA463 K5 V500/45	AA46/54 K5 V45
	63	1CUMISA541 J6 VC500/60	5SAA463 J5 V500/60	AA54 J5 V60

STAINLESS STEEL 300 SERIES

Operation	Speed	Best	Better	Good
Rough Finish	35	GC463 K5 VG	CGC463 K5 VG	C463 K5 VG
		GC80 J5 VG	CGC80 J5 VG	C80 J5 VG
Rough Finish	50	GC463 K5 VS2001/45	CGC463 K5 VS2001/45	C463 K5 VS2001/45
		GC80 J5 VS2001/45	CGC80 J5 VS2001/45	C80 J5 VS2001/45
For higher stock removal rate	Upto 35 MPS		GC60 J11 VR	

CENTERLESS GRINDING WHEELS

ADVANTAGES OF CUMI WHEELS



1. High stock removal
2. Lower dressing frequency
3. Burn free component
4. Better productivity
5. Excellent surface finish

WIDTH OF PRODUCT RANGE

Abrasive Used	CUMI Code	Grit Range	Diameter		Thickness		Hardness	Structure	Speed mps
			mm	inch	mm	inch			
Ceramic Aluminium Oxide	CUMISA	46 - 120	350 - 610	14 - 24	100 - 250	4 - 10	I - N	6 & 8	35. 50 & 63
Sharp Aluminium Oxide blend	53A / 55A	46 - 120					I - N	7	35 & 50
Premium Aluminium Oxide	65A	80 - 220					L	-	40
Semi friable Aluminium Oxide	SA	46 - 120					I - N	5 - 7	35 & 50
White Aluminium Oxide	AA	46 - 120			I - N	5 - 7	35 & 50		
Aluminium Oxide blend	DA	46 - 120			I - P	5 - 7	35 & 50		
Brown Aluminium Oxide	A	46 - 120			I - P	5 - 7	35 & 50		
Black Silicon Carbide	C	46 - 120			I - P	5 - 7	35 & 50		

SHAPES



COMMONLY USED MACHINES

•Cincinnati •WMW •Marcus •Lid Kopping

VALVE STEM

Type	Operation	Speed	Best	Better	Good
Mono Valve	Rough	35	DA463 M5 V500	A463 M3 V2016	A463 M3 V10
		50	DA463 M5 V500/45	A463 M3 V2016/45	A463 M3 V45
	Semi Finish	35	DA60 L5 V500	A60 L5 V2016C	A60 L5 V10C
		50	DA60 L5 V500/45	A60 L5 V2016C/45	A60 L5 V45C
	Finish	35	DA100 J5 V500	A100 J5 V2016C	A100 J5 V10C
		50	DA100 I5 V500/45	A100 I5 V2016C/45	A100 I5 V45C
Bi - Metal	Rough	35	DA543 N5 V500	A463 M3 V2016	A463 M3 V10
		50	DA543 N5 V500/45	A463 M3 V2016/45	A463 M3 V45
	Semi Finish	35	DA60 L5 V500	A60 L5 V2016C	A60 L5 V10C
		50	DA60 L5 V500/45	A60 L5 V2016C/45	A60 L5 V45C
	Finish*	35	5SA100 I5 V390	5A100 I5 V390*	A100 J5 V10C
		50	5SA100 I5 V390/45	5A100 I5 V390/45	A100 I5 V45C

* Finishing Operation :

For Roughness 0.3 Ra --> Use Grit 100

For Roughness < 0.3 Ra --> Use Grit 1001



PINS

Type	Operation	Speed	Best	Better	Good
Gudgeon Pin	Rough	35	1CUMISA461 K6 VCAE	AA463 L5 V2020	A463 L5 V10C
		50	1CUMISA461 K6 VC500/45	AA463 K5 V2020/45	A463 K5 V45C
	Semi Finish	35	1CUMISA601 K6 VCAE	AA60 L5 V2020	A60 L5 V10C
		50	1CUMISA601 K6 VC500/45	AA60 K5 V2020/45	A60 K5 V45C
	Finish	35	1CUMISA100 J6 VC500	AA100 J5 V2020	A100 J5 V10C
		50	1CUMISA100 I6 VC500/45	AA100 I5 V2020/45	A100 I5 V45C
	Fine Finish	35	-	A220 N5 VK12	-
	Super Finish	35	A400 F5 RBX	C320 P5 BYZ	-

* V- Vitrified; R- Rubber; RBX- Cork Rubber



SHOCK ABSORBER

Type	Operation	Speed	Best	Better	Good
Inner Tube / Fork Pipe	Rough - 1	35	55A603 N7 B99	DA603 N7 B99	A80 N7 B310
		50	55A603 N7 B99/45	DA603 N7 B99/45	A80 N7 B310/45
	Rough - 2	35	-	A120 L RT1	A1203 N8 B310
		50	-	A120 LRT1/45	A1203 N8 B310/45
	Semi Finish	35	65A220 L RT1	A220 L RT1	-
		50	65A220 L RT1/45	A220 L RT1/45	-
	Finish	35	AA400/A500 G5 RCBX	-	-
		50		-	-
Piston Rod	Rough - 1	35	55A603 N7 B99	A801 N7 B99	A60 K5 V10C
		50	55A603 N7 B99/45	DA603 N7 B99/45	-
	Semi Finish	35	65A220 L RT1	A220 L RT1	-
		50	65A220 L RT1/45	A220 L RT1/45	-
	Finish	35	AA400/A500 G5 RCBX	-	-
		50		-	-

* V- Vitrified; R- Rubber; RBX- Cork Rubber



PISTONS & LINERS

PISTON

Type	Operation	Speed	Good
Piston Ring	Rough	35	C463 L5 VG
		50	-
	Finish	35	C60 L5 VG
		50	-

LINERS

Type	Operation	Speed	Best	Better	Good
Grey Cast Iron	Rough	35	C543 J7 B190K	-	C543 K5 B190
		50	C543 J7 B190K/45	-	C543 K5 B190/45
SG Iron	Rough	35	-	C543 K5 B903	-
		50	-	C543 K5 B903/45	-



FEED/REGULATING WHEELS

ABOUT FEED/REGULATING WHEELS

CUMI's regulating wheels are the best in class in the world. These wheels are made using a distinct calendaring process, leading to superlative & consistent performance making it as the most preferred product in the industry. The controlled wear not only leads to highly precise components but also gives longer life.

FEATURES:

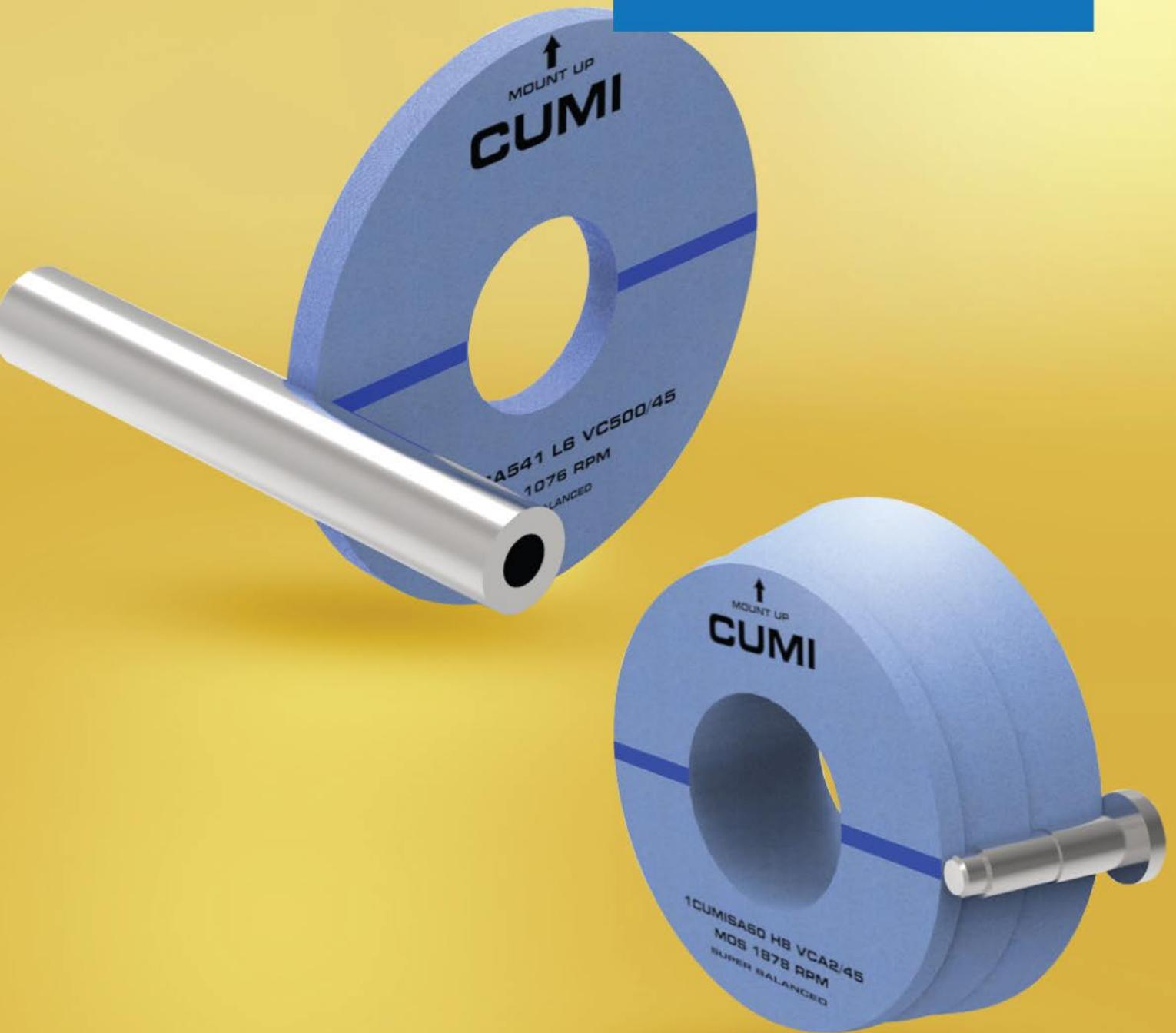
- Tough grains for long life
- Resilient rubber for better finish

PRODUCT RECOMMENDATION

Operation	Grade
For finish	A80 RR
For size control	A120 RR
	A150 RR
For size control & better finish	A180 RR



CYLINDRICAL



CYLINDRICAL GRINDING WHEELS

ABOUT CYLINDRICAL GRINDING WHEELS

CUMI's versatile range of cylindrical wheels are used for a variety of grinding operations that require size generation, fine surface finish and fast stock removal. Special wheels are also available for multiple diameters and shoulder grinding with pre-formed wheel faces.

CUMI's cylindrical grinding wheels find wide application in the grinding of valves, plunger pins, eye bolts, transmission shafts, cam shafts, crank shafts etc.,

FEATURES:

- Best choice of abrasive grain wheels for higher stock removal, higher productivity and form retention
- Customizes sketches for every customer requirement
- Wide range of bond system to customize individual grinding needs



CYLINDRICAL GRINDING WHEELS

ADVANTAGES OF CUMI WHEELS



1. High stock removal
2. Better productivity
3. Excellent surface finish
4. Lower dressing frequency
5. Burn free component

WIDTH OF PRODUCT RANGE

Abrasive Used	CUMI Code	Grit	Diameter		Thickness		Hardness	Structure	Speed mps
			mm	inch	mm	inch			
Ceramic Aluminium Oxide	CUMISA				25 - 150	1 - 6	H - M	6 - 13	35, 50 & 63
Friable Aluminium Oxide	SBA				25 - 250	1 - 10	H - M	5 - 8	35 & 50
Sharp Aluminium Oxide blend	53A				25 - 150	1 - 6	H - M	6 - 13	35 & 50
Pink Aluminium Oxide	RAA				25 - 150	1 - 6	H - M	5 - 8	35 & 50
Semi friable Aluminium Oxide	5SA				25 - 150	1 - 6	H - M	5 - 8	35, 50 & 63
White Aluminium Oxide	AA	46 - 120	300 - 610	12 - 24	25 - 250	1 - 10	H - M	5 - 8	35, 50 & 63
Aluminium Oxide blend	DA				25 - 150	1 - 6	H - M	5 - 8	35 & 50
Brown Aluminium Oxide	A				25 - 150	1 - 6	H - M	5 - 8	35 & 50
Silicon Carbide blend	CGC				25 - 150	1 - 6	H - M	5 - 8	35 & 50
Green Silicon Carbide	GC				25 - 150	1 - 6	H - M	5 - 8	35 & 50
Black Silicon Carbide	C				25 - 150	1 - 6	H - M	5 - 8	35 & 50

SHAPES



COMMONLY USED MACHINES

•Landis •Schaudt •Paragon •Palmary •Norton

CYLINDRICAL GRINDING WHEELS

HIGH SPEED STEEL (HSS)

Hardness	Speed	Best	Better	Good
Low content Vanadium & Molybdenum	35	1CUMISA60 J6 VC500	RAA60 J5 VF8	AA60 K5 V8
	50	1CUMISA60 J6 VC500/45	RAA60 J5 VF8/45	AA60 K5 V45
High content Vanadium & Molybdenum	35	1CUMISA601 H12 VCA2	RAA601 H10 V736	AA601 H10 V736
	50	1CUMISA601 G12 VCA2/45	RAA601 G10 V736/45	AA601 G10 V736/45

TUNGSTEN CARBIDE

Hardness	Speed	Best	Better	Good
For all HRc	35	CGC60 K5 VG	GC60 K5 VG	C60 K5 VG
	50	CGC60 J5 VS2001/45	GC60 J5 VS2001/45	C60 J5 VS2001/45



CYLINDRICAL GRINDING WHEELS

GENERAL PURPOSE

Hardness	Speed	Best	Better	Good
< 40 HRc	35	AA463 M5 V2016	SBA463 M5 V10	A463 M5 V10
	50	1CUMISA541 L6 VC500/45	5SA463 L5 V500/45	DA463 M5 V45
	63	1CUMISA541 L6 VC500/60	AA463 L5 V60	5SA463 L5 V500/60
50 HRc to 60 HRc	35	AA463 K5 V2016	SBA463 K5 V10	A463 K5 V10
	50	1CUMISA541 J6 VC500/45	5SA463 J5 V500/45	DA463 K5 V45
	63	1CUMISA541 J6 VC500/60	AA463 J5 V60	5SA463 J5 V500/60

CAST IRON

Hardness	Speed	Best	Better	Good
< 40 HRc	35	GC463 N5 VG	CGC463 M5 VG	C463 M5 VG
	50	GC463 N5 VS2001/45	CGC463 M5 VS2001/45	C463 M5 VS2001/45
	63	-	-	-
50 HRc to 60 HRc	35	GC463 L5 VG	CGC463 K5 VG	C463 K5 VG
	50	GC463 L5 VS2001/45	CGC463 K5 VS2001/45	C463 K5 VS2001/45
	63	-	-	-

STEEL

Hardness	Speed	Best	Better	Good
< 40 HRc	35	AA463 M5 V2016	SBA463 M5 V10	A463 M5 V10
	50	1CUMISA541 L6 VC500/45	5SA463 L5 V500/45	DA463 M5 V45
	63	1CUMISA541 L6 VC500/60	AA463 L5 V60	5SA463 L5 V500/60
50 HRc to 60 HRc	35	1CUMISA541 K6 VC500	5SAA463 K5 V500	AA46/54 K5 V8
	50	1CUMISA541 K6 VC500/45	5SAA463 K5 V500/45	AA46/54 K5 V45
	63	1CUMISA541 J6 VC500/60	5SAA463 J5 V500/60	AA54 J5 V60

STAINLESS STEEL 300 SERIES

Operation	Speed	Best	Better	Good
Rough Finish	35	GC463 K5 VG	CGC463 K5 VG	C463 K5 VG
		GC80 J5 VG	CGC80 J5 VG	C80 J5 VG
Rough Finish	50	GC463 K5 VS2001/45	CGC463 K5 VS2001/45	C463 K5 VS2001/45
		GC80 J5 VS2001/45	CGC80 J5 VS2001/45	C80 J5 VS2001/45
For higher stock removal rate	Upto 35 MPS		GC60 J11 VR	

CYLINDRICAL GRINDING WHEELS

SOFT STEEL (< 40 HRc)

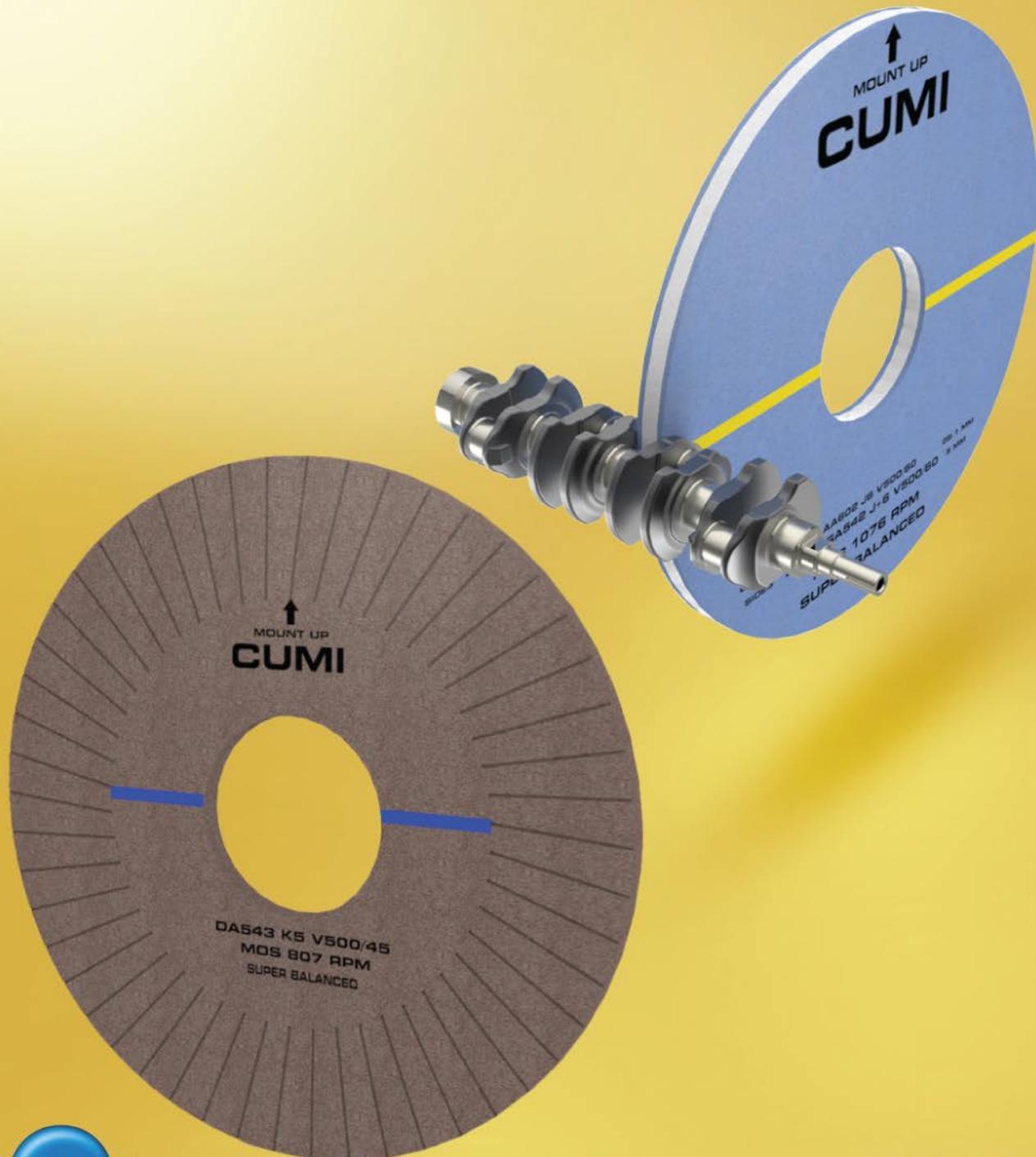
Operation	Hardness	Area of Contact	Best	Better	Good
Rough	35	<= 10 mm	AA46/54 L5 V8	DA 463 K5 V10	A463 K5 V10
	50		AA46/54 L5 V45	DA 463 K5 V45	A463 K5 V45
	35	> 10 mm	AA46/54 J7 V8	DA463 J7 V10	A463 J7 V10
	50		AA46/54 J7 V45	DA463 J7 V45	A463 J7 V45
Finish	35	<= 10 mm	AA60 K5 V8	DA60 K5 V10	A60 K5 V10
	50		AA60 K5 V45	DA60 K5 V45	A60 K5 V45
	35	> 10 mm	AA60 I7 V8	DA60 I7 V10	A60 I7 V10
	50		AA60 I7 V45	DA60 I7 V45	A60 I7 V45

HARD STEEL (> 40 HRc)

Operation	Hardness	Area of Contact	Best	Better	Good
Rough	35	<= 10 mm	1CUMISA60 H8 VCA2	53A60 H8 VCA2	AA60 H8 V736
	50		1CUMISA60 H8 VCA2/45	53A60 H8 VCA2/45	AA60 H8 V736/45
	35	> 10 mm	1CUMISA60 H10 VCA2	53A60 H10 VCA2	AA60 H10 V736
	50		1CUMISA60 H12 VCA2/45	53A60 H12 VCA2/45	AA60 H12 V736/45
Finish	35	<= 10 mm	1CUMISA80 H8 VCA2	53A80 H8 VCA2	AA80 H8 V736
	50		1CUMISA80 H10 VCA2/45	53A80 H10 VCA2/45	AA80 H10 V736/45
	35	> 10 mm	1CUMISA80 H12 VCA2	53A80 H12 VCA2	AA80 H12 V736
	50		1CUMISA80 H13 VCA2/45	53A80 H13 VCA2/45	AA80 H13 V736/45



CRANKSHAFT



CRANKSHAFT GRINDING WHEELS

ABOUT CRANKSHAFT GRINDING WHEELS

What sets Crankshaft grinding apart from the other cylindrical grinding process is the extremely crucial function of the crankshaft in itself. Crankshaft design requires meticulous attention from material selection to the various hardening processes. Each part of the crankshaft is designed to have different hardness meeting specific demands of the application. Grinding of the shoulder region is a surface grinding operation, while the grinding of the pin is a cylindrical grinding operation. This poses a great challenge in designing a wheel that performs both these processes efficiently.

With the incorporation of the latest advances in Abrasive grains and Vitrified bond technology, CUMI provides Crankshaft grinding wheels that can face each of these challenges. The basic composition of the wheels are designed to give maximum life and excellent form holding while physical forms like slotted wheels, sandwich wheels, dual grade wheels etc. enable the wheels to grind without burns.

FEATURES:

- Sharp & friable aluminium oxide grains
- Low temperature fired fusible vitrified bond system
- Uniform density and hardness across wheel diameter
- Perfectly balanced
- Sandwich option for higher feed rates & improved form holding



CRANKSHAFT GRINDING WHEELS

ADVANTAGES OF CUMI WHEELS

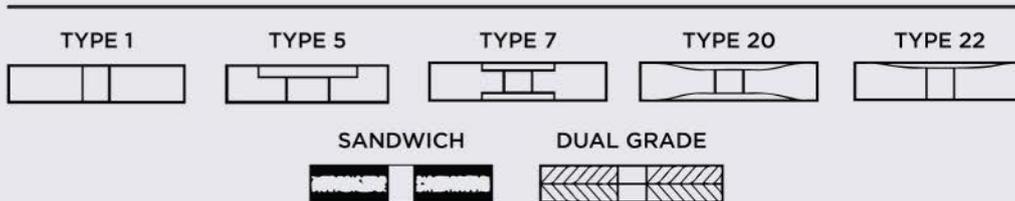


1. Lower BV (Barhausen value)
2. Lower dressing frequency
3. No surface cracks
4. Lower cost per component
5. Good form retention
(for better radius profile)

WIDTH OF PRODUCT RANGE

Abrasive Used	CUMI Code	Grit	Diameter		Thickness		Speed	Hardness	Structure
			mm	Inch	mm	Inch			
Ceramic Aluminum Oxide	CUMISA								
Sharp Crystal Aluminum Oxide	71HA								
Semi-Friable Grain	SA								
Pure Alumium Oxide	12A	46-80	600-1200	24 - 48	19 - 125	3/4 - 5	Up to 60	J - M	5 - 8
White Aluminum Oxide	AA								
Aluminum Oxide Blend	DA								
Brown aluminum Oxide	A								

SHAPES



AUTO COMPONENTS

COMMONLY USED MACHINES

- Zanrosso •Lampco •Prince •Tos •Schledum •Berco
- Churchill •Landis •Ribbon •Van Roman •Storm Vulcan
- Norton •Schou •Rex

Type	Operation	Speed	Best	Better	Good	
Forged Steel	Soft	35	12A467 J7 V2020	AA463 K5 V2020	A463 L5 V10X	
		50	12A467 I7 V2020/45	AA463 K5 V2020/45	A463 K5 V45X	
		60	71HA463 H7 V2020/60	12A467 I7 V2020/60	AA463 K5 V2020/60	
	Hard - Car	35	12A601 K5 V2020	SA601 K5 V2020	A601 K5 V10X	
		50	12A601 K5 V2020/45	AA601 K5 V2020/45	DA601 K5 V2020/45	
		60	71HA601 J7 V2020/60	AA601 K5 V2020/60	SA601 K5 V2020/60	
	Hard - commercial	35	12A467 J7 V2020	AA463 K5 V2020	A463 L5 V10X	
		50	12A467 I7 V2020/45	AA463 K5 V2020/45	A463 K5 V45X	
		60	71HA463 H7 V2020/60	12A467 I7 V2020/60	AA463 K5 V2020/60	
		For Softshoulder & Hard Center Grinding	60	2CUMISA542 J+6 V500/60(Sides) / AA602 J6 V500/60 (Center)	DA543 K5 V500/60(Sides) / DA601 K5 V500/60(Sides)	-
	Cast Iron		Up to 50	AA46 K5 V2020/45	SA46 K5 V2018/45	DA46 K5 V45
	Nodular Iron		Up to 50	1CUMISA461 K6 V2020/45	AA46 L5 V2020/45	5SA46 L5 V2020/45



CAMSHAFT



CAMSHAFT GRINDING WHEELS

ABOUT CAMSHAFT GRINDING WHEELS

CUMI's Camshaft wheels offer good form holding, free cutting ability together while maintaining the stringent geometrical and surface finish requirement to maintain consistent and tight surface finish tolerances. CUMI's versatile camshaft wheels can grind materials like forged steel and chilled cast iron with highest amount of stock removal without thermal damage on the cam flank.

CUMI also offers single wheel for both roughing and finishing operations

FEATURES:

- Sharp & friable Aluminium Oxide grains
- Vitrified Krystal bond system(V500)
- Uniform density and hardness across wheel diameter
- Perfectly balanced



CAMSHAFT GRINDING WHEELS

ADVANTAGES OF CUMI WHEELS



1. High productivity
2. Excellent form retention
3. Dimensional accuracy
4. Surface finish
5. Form accuracy

WIDTH OF PRODUCT RANGE

Abrasive Used	CUMI Code	Grit	Diameter		Thickness		Speed	Hardness	Structure
			mm	inch	mm	inch			
Ceramic Aluminium Oxide	CUMISA								
Semi friable Aluminium Oxide	SA	54 - 80	500 - 610	20 - 24	25 - 40	1 - 1 1/2	45, 60	J - M	5 - 8
White Aluminium Oxide	AA								
Brown Aluminium Oxide	A								

SHAPES



AUTO COMPONENTS

COMMONLY USED MACHINES

•Landis •Naxos Union •Schaudt •Fortuna



CAM LOBE (upto 60 MPS)

Type	Operation	Best	Better	Good
Case Hardened Steel	Rough	1CUMISA541 K6 VC500/60	5SA54 K5 V500/60	AA54 K5 V60
	Finish	1CUMISA801 J6 VC500/60	5SA80 J5 V500/60	AA80 I5 V60
	Rough & Finish	3CUMISA80 R20 BH99/60	1CUMISA80 R20 BH99/60	1CUMISA542 L6VC500/60
Nodular Iron	Rough	3CUMISA461 L6 V500/60	5SA463 L5 V500/60	AA463 L5 V2020/60
	Finish	3CUMISA801 J6 VC500/60	5SA80 J5 V500/60	AA80 I5 V60
Chilled Cast Iron	For Base Circle Diameter <= 25mm	3CUMISA80 R20 B99/60	5SA80 L5 V500/60	AA80 L5 V2020/60
	For Base Circle Diameter > 25mm	3CUMISA80 R23 B99/60	5SA801 J5 V500/60	AA801 J5 V2020/60

AUTO COMPONENTS

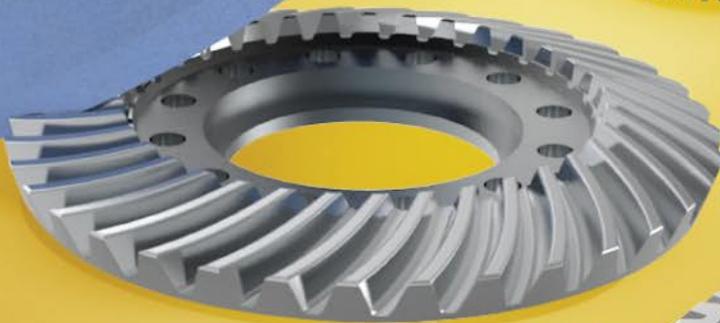


CAM JOURNAL (upto 45 MPS)

Type	Operation	Best	Better	Good
Case Hardened Steel	All Operations	1CUMISA601 J6 VC500/45	5SA60 K5 V500/45	A601 K5 V45
Nodular Iron	Rough	1CUMISA80 K6 VC500/45	5SA801 K5 V500/45	AA80 L5 V45



GEAR



GEAR GRINDING WHEELS

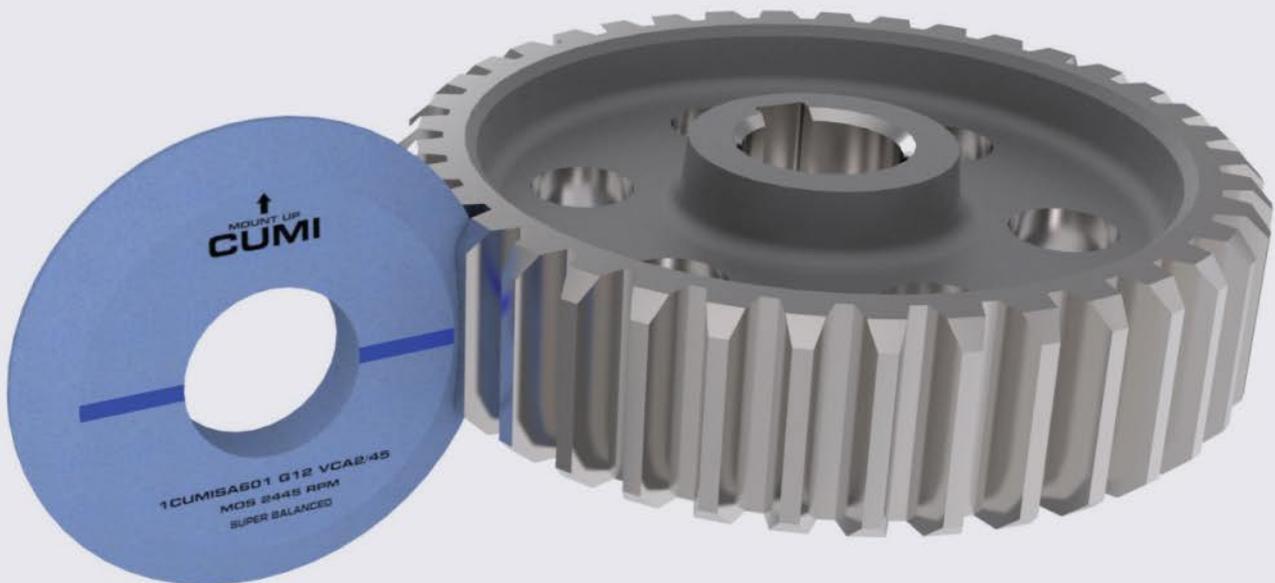
ABOUT GEAR GRINDING WHEELS

One of the most advanced grinding applications, the sheer amount of parameters that are measured/controlled during the grinding of gears poses enough of a challenge to give abrasive manufacturers a run for their money. Intricate profile accuracy while maintaining high Material removal rates (Q') and Dressing frequency (V') are the major requirements in this application.

CUMI's Specially designed sharp crystalline grain combination and Krystal bond systems enable us to predict wheel wear patterns and thereby modify our wheels to ensure that the necessary profile and surface roughness is achieved consistently while maintaining low cycle times. While the combination ensures performance, our world class manufacturing set up makes sure that all the varieties of gear grinding like single rib, multi rib, bevel etc. are covered.

FEATURES

- High performance Sharp, Microcrystalline abrasive blended with friable abrasives
- Fusible, glassy crystalline bond for improved form holding
- Special filling, pressing and sintering process for uniform hardness across width
- High precision CNC profiling of wheel and inspection



GEAR GRINDING WHEELS

ADVANTAGES OF CUMI WHEELS



1. Burn free surface
2. High feed rates - Q'
3. Reduced dress depth and frequency
4. Good form holding for profile accuracy
5. Controlled wear and highly consistent performance throughout working life



SINGLE RIB GEAR GRINDING

WIDTH OF PRODUCT RANGE

Abrasive Used	CUMI CODE	Grit Range	Diameter		Thickness		Hardness	Structure	Speed mps
			mm	inch	mm	inch			
Ceramic Aluminium Oxide	CUMISA	46 - 120	80 - 508	3 1/4 - 20	10 - 150	3/8 - 6	G - J	8 - 15	35 & 50
Sharp crystal Aluminium Oxide	71HA								
Sharp Aluminium Oxide blend	55A								
Pink Aluminium Oxide	RAA								

COMMONLY USED MACHINES

•Niles •Hafler •Maag

CONVENTIONAL PROCESS

Gear Module	Stock Removal	Best	Better	Good
Upto 8 M	Upto 5Q'W	1CUMISA601 G12 VCA2/45	55A601 G12 VCA2/45	RAA60 H10 V736/45
	6Q' to 8Q'W	71HA601 G13 VCA2/45	3CUMISA601 G13 VCA2/45	1CUMISA601 G12 VCA2/45
	Above 8Q'W	71HA601 G18 VCA2/45	3CUMISA601 G18 VCA2/45	1CUMISA601 G15 VCA2/45
Above 8 M	Upto 5Q'W	71HA601 G13 VCA2/45	3CUMISA601 G13 VCA2/45	1CUMISA601 G12 VCA2/45
	6Q' to 8Q'W	71HA601 G18 VCA2/45	3CUMISA601 G18 VCA2/45	1CUMISA601 G15 VCA2/45
	Above 8Q'W	71HA601 G21 VCA2/45	3CUMISA601 G21 VCA2/45	1CUMISA601 G18 VCA2/45



SINGLE RIB GEAR GRINDING

COMMONLY USED MACHINES

•Gleason •Pfauter •Samputensili •Hofler •Niles

CNC PROCESS

Gear Module	Stock Removal	Best	Better	Good
Upto 5 M	Upto 5Q'W	71HA601 G13 VCA2/45	3CUMISA601 G13 VCA2/45	1CUMISA601 G12 VCA2/45
	6Q' to 8Q'W	73HA601 G15 VCA2/45	71HA601 G13 VCA2/45	3CUMISA601 G13 VCA2/45
	Above 8Q'W	73HA601 G15 VCA2/45	71HA601 G13 VCA2/45	3CUMISA601 G13 VCA2/45
6 - 10 M	Upto 5Q'W	73HA601 G15 VCA2/45	71HA601 G13 VCA2/45	3CUMISA601 G13 VCA2/45
	6Q' to 8Q'W	73HA601 G18 VCA2/45	71HA601 G15 VCA2/45	3CUMISA601 G15 VCA2/45
	Above 8Q'W	73HA601 G21 VCA2/45	71HA601 G18 VCA2/45	3CUMISA601 G18 VCA2/45
Above 10 M	Upto 5Q'W	73HA601 G18 VCA2/45	71HA601 G15 VCA2/45	3CUMISA601 G15 VCA2/45
	6Q' to 8Q'W	73HA601 G21 VCA2/45	71HA601 G18 VCA2/45	3CUMISA601 G18 VCA2/45
	Above 8Q'W	-	-	-

MULTI RIB GEAR GRINDING

WIDTH OF PRODUCT RANGE

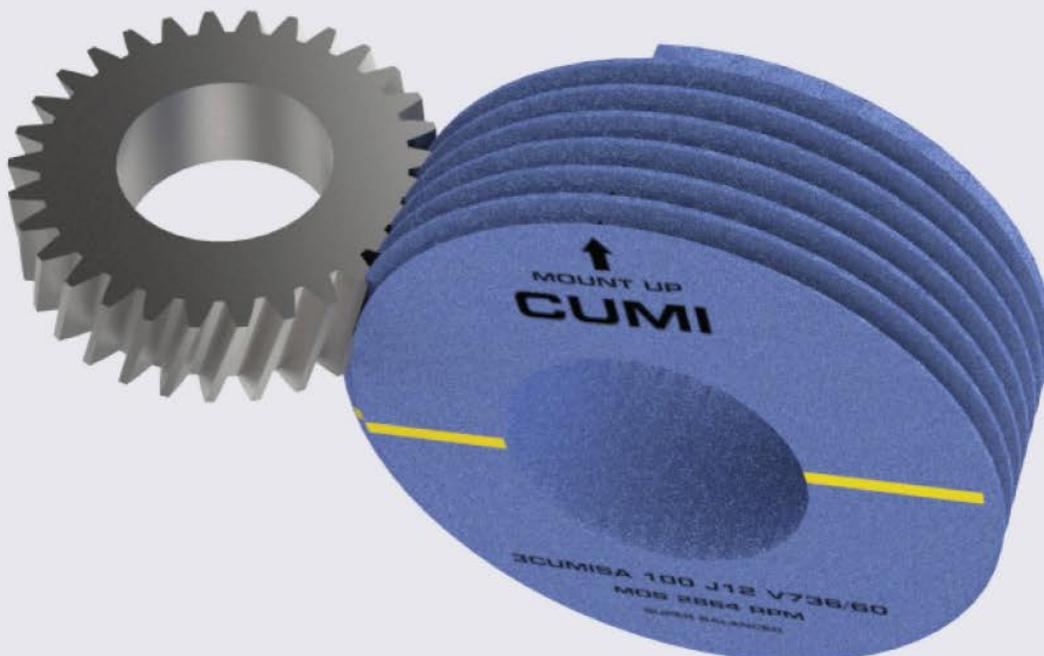
Abrasive Used	CUMI CODE	Structure	Speed mps	Grit Range	Diameter		Thickness		Hardness
					mm	inch	mm	inch	
Ceramic Aluminium Oxide	CUMISA	10 - 13	50, 63 & 80	60 - 120	250 - 400	10 - 16	80 - 250	3 1/4 - 10	I - K
Sharp Crystal Aluminium Oxide	71HA								
Sharp Aluminium Oxide blend	55A								
Ruby Pink Aluminium Oxide	24R								
Pink Aluminium Oxide	RA	5 - 7	35 & 50	60 - 180					
Semi friable Aluminium Oxide	SA	5 - 7							

COMMONLY USED MACHINES

- Reishauer (ZB/OZA/AZA/NZA)

CONVENTIONAL PROCESS

Gear Module	Best	Better	Good
upto 1.5 M	1CUMISA280 TDV547/45	-	RA280 TDV547/45
1.75 M - 2.25 M	3CUMISA80 I12 V736/45	55A80 I10 V736/45	SA100 I7 V677/45
2.5 M - 4 M	3CUMISA80 I12 V736/45	55A80 I10 V736/45	SA80 K5 V677/45
Above 4.25 M	3CUMISA60 J12 V736/45	55A60 J10 V736/45	SA60 K5 V677/45



MULTI RIB GEAR GRINDING

COMMONLY USED MACHINES

- Reishauer RZ301S, RZ361S, RZ362A
- Liebherr (LCS200 / LC280)
- Kapp •Gleason •Pfauter •Samputensili

CNC PROCESS

Gear Module	Best	Better	Good
upto 1.5 M	3CUMISA120 I12 V736/45	55R120 J12 V736/45	24R120 J12 V736/45
1.75 M - 2.25 M	3CUMISA100 J12 V736/45	55R100 J12 V736/45	24R100 J12 V736/45
2.5 M - 4 M	3CUMISA80 J12 V736/45	55R80 J12 V736/45	24R80 J12 V736/45
Above 4.25 M	3CUMISA60 K12 V736/45	55R60 K12 V736/45	24R60 K12 V736/45

COMMONLY USED MACHINES

- Reishauer RZ400, RZ150, RZ1000
- Leibherr (LCS200/LC280)

CNC (Creepfeed Type) PROCESS - 60mps

Gear Module	Best	Better	Good
upto 1.5 M	73HA120 I13 V736/60	71HA120 I12 V736/60	3CUMISA120 I12 V736/60
1.75 M - 2.25 M	73HA100 I13 V736/60	71HA100 I12 V736/60	3CUMISA100 I12 V736/60
2.5 M - 4 M	73HA80 I13 V736/60	71HA80 I12 V736/60	3CUMISA80 J12 V736/60

SHAVING CUTTER

WIDTH OF PRODUCT RANGE

Abrasive Used	CUMI CODE	Hardness	Structure	Grit Range	Diameter		Thickness		Speed mps
					mm	inch	mm	inch	
Sharp Aluminium Oxide blend	53A	G - I	10 - 13	100 - 120	750-800	29 1/2 - 31 1/2	20-50	3/4 - 2	35
White Aluminium Oxide	AA	I - K	5 - 8						
Pink Aluminium Oxide	RA								

COMMONLY USED MACHINES

- Hurth

Process	Best	Better	Good
Shaving Cutter	53A120 G13 VCA2	RA120 G6 TDV155	AA100 I8 VMPA



HONING & HOB RE-SHARPENING

WIDTH OF PRODUCT RANGE

Abrasive Used	CUMI CODE	Hardness	Structure	Grit Range	Diameter		Thickness		Speed mps
					mm	inch	mm	inch	
Ceramic Aluminium Oxide	CUMISA	I - K	6 - 8	80 - 220	80 - 508	3 1/4 - 20	10 - 50	3/8 - 2	35 & 50
Sharp crystal Aluminium Oxide	73HA	G - J	10 - 15						
Pink Aluminium Oxide blend	RAA								

COMMONLY USED MACHINES

- Prawema •SyncroFine •Gleason-Hurth •Fassler
- Seiwa •Emag •Kapp •Kanzaki Power

Type	Specification
Vitrified honing	CUMISA220 V894
Epoxy resin honing	CUMISA180 E895

Type	Best	Better	Good
Hob Re-sharpening	73HA60 G12 V736/45	3CUMISA80 J6 V500/45	RAA60 H10 V736/45



TOOL ROOM GRINDING



TOOL ROOM GRINDING WHEELS

ABOUT TOOL ROOM GRINDING WHEELS

Tool room grinding wheels find vast applications in the manufacture and regrinding of cutting tools like drills, reamers, milling cutters etc.,

CUMI's tool room wheels are available in like plain wheels (type 1), cup wheels (type 6 & 11), dish wheels (type 12), saucer wheels (type 13). They are available in both dry and wet grinding applications

FEATURES:

- Right choice of abrasive grain for specific materials
- Unique bond system for cool grinding and wheel form retention



TOOL ROOM GRINDING WHEELS

ADVANTAGES OF CUMI WHEELS



1. High productivity
2. Excellent form retention
3. Dimensional accuracy
4. Surface finish
5. Burn free component

WIDTH OF PRODUCT RANGE

Abrasive Used	CUMI Code	Grit	Diameter		Thickness		Speed mps	Hardness	Structure
			mm	inch	mm	inch			
Ceramic Aluminium Oxide	CUMISA								
Sharp Crystal Aluminium Oxide	71HA								
Pink Aluminium Oxide	RA	46 - 120	80 - 250	3 1/8 - 9	3 - 25	1/8 - 1	35 & 50	I - L	5 - 7
White Aluminium Oxide	AA								
Green Silicon Carbide	GC								
Silicon Carbide blend	CGC								

SHAPES



TOOL ROOM GRINDING WHEELS

Material	Operation	Speed	Best	Better	Good
High Speed Steel / Tool Steel / High Alloy Steel	Rough	35	1CUMISA46 J6 VC500	RA46/54 J6 V206	AA46/54 K5 V8
		50	1CUMISA46 J6 VC500 /45	RA46/54 J6 V206/45	AA46/54 K5 V45
	Finish	35	1CUMISA60 J6 VC500	RA60 J6 V206	AA60 K5 V8
		50	1CUMISA60 J6 VC500 /45	RA60 J6 V206/45	AA60 K5 V45
Tungsten Carbide		35	GC60 K5 VS2110	GC60 K5 VG	CGC60 K5 VG
		50	GC60 K5 VS2110/45	GC60 K5 VG/45	CGC60 K5 VG/45
Special Tool Steels	Rough	35	71HA461 J7 VC500	55A461 J7 VC500	RAA46/54 J6 V206
		50	71HA461 J7 VC500/45	55A461 J7 VC500/45	RAA46/54 J6 V206/45
	Finish	35	71HA60 J7 VC500	55A60 J7 VC500	RAA60 J6 V206
		50	71HA60 J7 VC500/45	55A60 J7 VC500/45	RAA60 J6 V206/45

BEARING INDUSTRY

COATED ABRASIVES



CARBORUNDUM UNIVERSAL LIMITED

CUMI'S COATED ABRASIVES

CUMI's wide range of coated abrasives comprises of abrasive sheets, rolls, belts, fiber discs, flap discs, PSA, hook 'n loop, quick change discs, double sided discs, cartridge rolls, shaft mounted flap wheels & flap wheels.



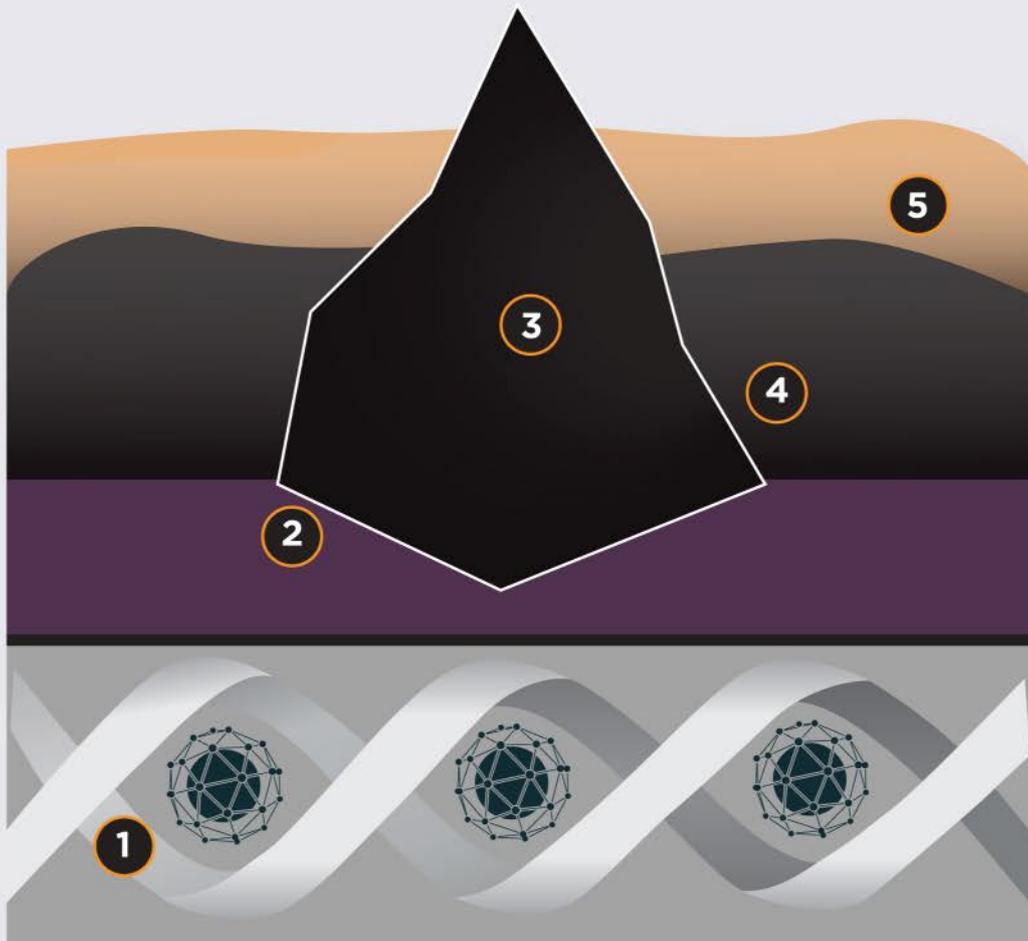
With state-of-the-art Peter Schwabe Maker, CUMI produces the widest range of high quality coated abrasive products for various applications meeting stringent customer demands.



COATED ABRASIVES

About Coated Abrasive

A coated abrasive is composed of three primary raw materials - abrasive grains, backing and bonding agent. The abrasive grains are primarily attached to a backing by means of a bonding agent. Coated abrasives are primarily used for heavy stock removal, grinding, de-burring, blending, cleaning, polishing & finishing operations.



STRUCTURE

- 1 BACKING
- 2 MAKER COAT
- 3 ABRASIVE GRAIN
- 4 SIZER COAT
- 5 TOP COAT *OPTIONAL

STRUCTURE OF COATED ABRASIVES

1. BACKING

Backing materials form the base of coated abrasives and anchor the abrasive grains with bonding agent. The various backings used in the manufacture of coated abrasives are as follows:

Paper • Cloth • Vulcanized Fiber • Polyester film

1.1 PAPER:

Paper backings vary from A-weight (lightest, most flexible) to F-weight (heaviest, least flexible). Some specialty products include latex treated paper for flexibility and tear resistance. Paper backings are available in the forms of Abrasive sheets, rolls, belts, PSA, hook'n loop, double side discs and plain discs.

PAPER

MOST FLEXIBLE			LEAST FLEXIBLE		
A - weight	B - weight	C - weight	D - weight	E - weight	F - weight
(95 g/m ²)	(105 g/m ²)	(120 g/m ²)	(150 g/m ²)	(220 g/m ²)	(270 g/m ²)

1.2 CLOTH:

The cloth backings undergo a series of treatments to impart flexibility, stiffness and other characteristics depending on the application. CUMI's range of cloth backings are carefully chosen right from the weaving to processing, making them highly suitable for every application. Cloth backings are primarily classified by weight & yarn constructions and are available in Cotton, Polycotton and Polyester.

CLOTH

MOST FLEXIBLE		LEAST FLEXIBLE	
J-WEIGHT	X-WEIGHT	Y-WEIGHT	YY-WEIGHT

1.3 FIBER:

Vulcanized fiber backings are primarily used for the manufacture of jumbo based fiber discs, IDC based fiber discs and quick change discs. Fiber backings are available in three variants which are chosen depending on the end application.

	RECOMMENDED FOR
0.95 mm	applications demanding heavy stock removal
0.85 mm	applications demanding medium - high pressure grinding (Exclusive for IDC)
0.80 mm	applications demanding medium - high pressure grinding
0.60 mm	finishing applications

STRUCTURE OF COATED ABRASIVES

2. MAKER COAT

The maker coat plays a crucial role of anchoring the abrasive grain to the backing firmly. The primarily used bonding agents are glue, semi-synthetic resin & synthetic resin which are chosen depending on the end application. Synthetic resins are used for heavy grinding operations & glue bond is preferred for hand sanding operations.

3.ABRASIVE GRAINS

Abrasive grains perform the material removal action supported by the backing and bonding agent.

Abrasive grains used in CUMI's coated abrasives are classified into 2 major variants:

- a) Natural abrasive grains
- b) Synthetic abrasive grains

NATURAL ABRASIVE GRAINS

- | | |
|------------|------------------------------------------------------------------------|
| i. Emery | Blocky shaped grain for hand sanding metal applications |
| ii. Garnet | Sharp edged soft grain for wood working applications |
| iii. Flint | Friable grain suitable for paint removal and hand sanding applications |

SYNTHETIC ABRASIVE GRAINS

- | | |
|------------------------------|-----------------------------------------------------------------------------------------------------------------|
| i. Eco Aluminium Oxide | Friable Aluminium Oxide grain ideal for light operations |
| ii. Brown Aluminium Oxide | Tough Aluminium Oxide grain suitable for both hand sanding and machine applications |
| iii. White Aluminium Oxide | Friable Aluminium Oxide grain for fast cutting action |
| iv. Premium Aluminium Oxide | Special treated Aluminium Oxide grain for superior performance |
| v. Silicon Carbide | Hard and friable grain ideal for non-ferrous materials |
| vi. Zirconia alumina | Tough and hard premium abrasive grain for heavy duty grinding applications |
| vii. Ceramic Aluminium Oxide | Micro-crystalline abrasive grain known for its high performance & unique fracture characteristics upon pressure |

The important characteristics to be considered when choosing an abrasive grain are:

- Hardness
- Toughness
- Nature of fracture
- Grain shape and size

STRUCTURE OF COATED ABRASIVES

4. SIZER COAT

In this process, the bonding agent polymerizes along with the maker coat thereby reinforcing the abrasive grains for grinding operation. Special products for wood application incorporate anti-static material to prevent clogging

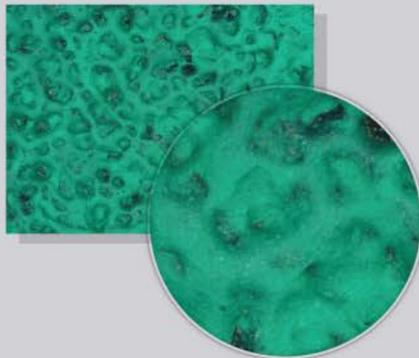
5. TOP COAT *OPTIONAL

This coating is applied over the sizer coat to impart special features to coated abrasives. The two major top coat variants are

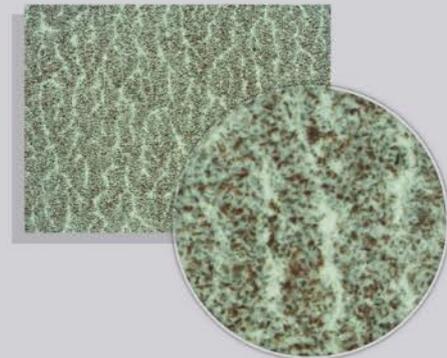
a. Anti-clogging coat : This comprises of a stearate coating which acts as a lubricant that prevents clogging by reducing friction thereby increasing life of the product

b. Super-size coat : This coating comprises of a 'Fluorine' based grinding aid which prevents increase in temperature in Stainless steel & high alloy steels, rendering a cooler cutting action, increasing material removal rate and product life.

SUPER SIZE COAT



ANTI CLOGGING COAT



TYPES OF COATING

DEFINITION	DESCRIPTION	CODE
Close Coat	The backing surface is coated with 90-95% grit volume. It has got the longest life and best finish.	●
Semi-Open Coat	The backing surface is coated 50- 75% grit volume. It has Anti-loading characteristics	◐
Open Coat	The backing surface is coated with approx. 50% grit volume	○

UNDERSTANDING THE PICTOGRAMS

CUMI's versatile range of products come in various forms. The pictograms below are indicative of the same.

FORMS



SHEETS



ROLLS



CARTRIDGE ROLLS



NARROW BELT



HARD WOOD
FLOOR BELT



FIBER DISC
ROUND HOLE



FIBER DISC
SLIT HOLE



FIBER DISC
SLOT HOLE



FLAP DISC



SHAFT MOUNTED
FLAP WHEEL



HOOK 'N LOOP



PSA



QUICK CHANGE DISC



DOUBLE SIDED DISC

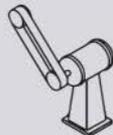


FLAP WHEEL

MACHINES



ANGLE GRINDER



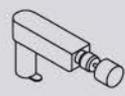
BACK STAND
GRINDER



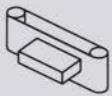
CENTRELESS
FINISHING MACHINE



DIE GRINDER



DRILLING MACHINE



EDGE SANDING
MACHINES



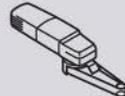
FLEXIBLE SHAFT
GRINDER



HAND BLOCK



HAND SANDING



HAND TOOL BELT
GRINDER



ORBITAL SANDER



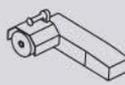
PARQUET SANDER



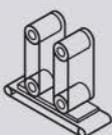
RANDOM ORBITAL
SANDER



RIGHT ANGLE DIE
GRINDER



SATIN FINISHING
MACHINE



THROUGH-FEED
GRINDING



WIDE BELT
FINISHING MACHINE



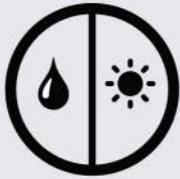
FLOOR STANDING
GRINDER

SPECIALITY



ANTI-SLIP

Special anti-slip coating on the backing that minimizes slipping and aids fast & comfortable sanding.



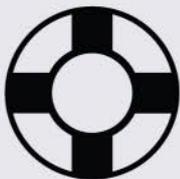
WET / DRY

The Abrasive products that possess this speciality can be used in both wet and dry conditions.



ANTI-CLOG

Products with this pictogram consist of a stearate coating which acts as a lubricant minimizing the clogging effect during sanding that reduces friction thereby prolonging life.



LATEX

Products with this symbol consist of latex impregnated backing which offers greater amount of flexibility & tear resistance. Ideal for contour sanding.



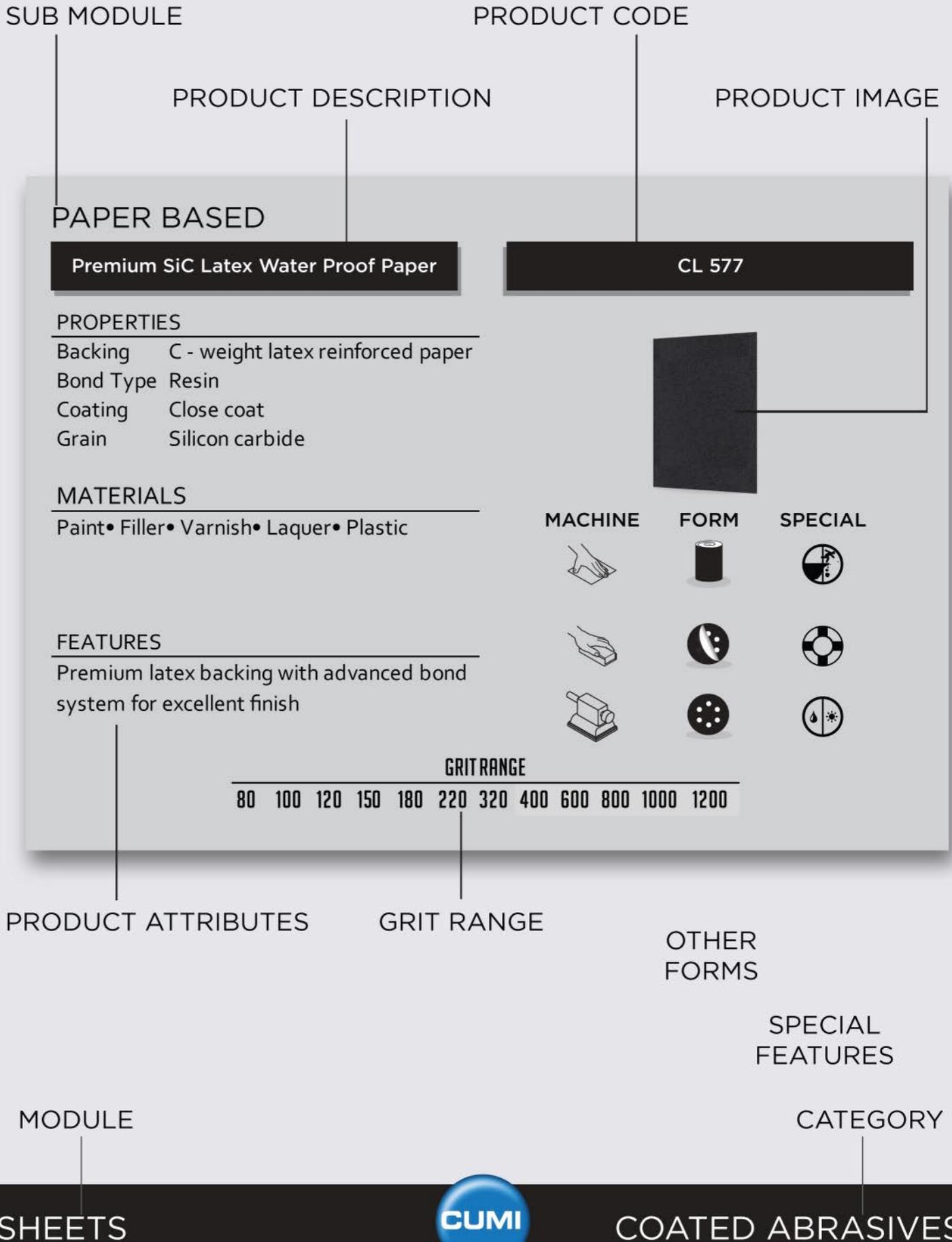
SUPER SIZE

An additional coating of active fillers resists increase in temperature thereby providing a cooler cutting action. Highly recommended for Stainless Steel.

PRODUCT CODE EXPLANATION

Y	S	5	8	8
Backing	Internal Process Code	Bond	Abrasive	Internal Process Number
Paper A - 95 gsm B - 105 gsm C - 110 gsm D - 150 gsm E - 220 gsm F - 270 gsm G - 350 gsm Fiber F - 0.6mm Fiber V - 0.8/0.85/ 0.95mm Fiber T - Natural Fiber Cloth P - Plain weave Cotton / Polycotton J - Cotton / Polycotton X - Cotton / Polycotton Y - Polycotton / Polyester Film L - Film		1 - Glue / Glue 2 - Resin / Glue 3 - Alkyd / Alkyd 4 - Resin / Alkyd 5 - Resin / Resin 6 - UF / UF 7 - UF / Glue	0 - Eco Aluminium Oxide 1 - Flint 2 - Emery 3 - Garnet 4 - Aluminium Oxide 5 - White Aluminium Oxide 6 - Premium Aluminium Oxide 7 - Silicon Carbide 8 - Zirconia Alumina 9 - Ceramic Aluminium Oxide	

HOW TO READ THE BROCHURE

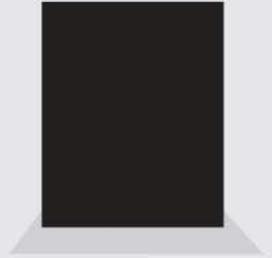


SHEETS



SHEETS

CUMI offers wide range of products for hand sanding and for hand held power tools. Products are specially designed for particular work piece and mode of operation and are available for wet and dry sanding application. The products are supplied in cloth or paper backing for recommended application. CUMI also offers sheets and strips in wide range of designs with hole patterns for dust extraction.



ADVANTAGES OF CUMI SHEETS

- Fast cut rate
- Superior life
- Smooth finish
- Latex option for increased flexibility
- Stearate option for reduced loading



AVAILABLE VARIANTS

	PAPER		CLOTH		FIBRE
CL 577	CP 547	DV/CV 371	JC 565	PG 121	LF 567
CL 575	DR 551	CR 131	XS 542		
CL 565	CR 663	CR 121	JG 502		
CL 567	CR 661	CR 111	PS 502		

APPLICATION GUIDE

BACKING	CODE	PRODUCT DESCRIPTION	COATING	MATERIAL								
				Steel	Stainless Steel	Non Ferrous Metal	Wood	Wall	Paint	Filler	Varnish • Lacquer	Plastic
PAPER	CL 577	Premium SiC Latex Water Proof Paper	●						●	●	●	●
	CL 575	SiC Latex Water Proof Paper	●						●	●	●	●
	CL 565	Premium AIO Latex Water Proof Paper	●				●		●	●	●	●
	CL 567	AIO Latex Water Proof Paper	●				●		●	●	●	●
	CP 547	AIO Stearate Paper	◐				●	●		●		
	DR 551	CUMI White Paper	◐	●			●	●	●	●		
	CR 663	AIO Cabinet Gold Paper	◐				●	●				
	CR 661	AIO Cabinet Paper	◐				●	●				
	DV/CV 371	SiC Water Proof Paper	●	●	●	●	●	●	●	●	●	●
	CR 131	Garnet Paper	○				●					
	CR 121	Emery Paper	●	●		●						
	CR 111	Flint Paper	●				●	●				
CLOTH	JC 565	AIO Flexible Cloth Sheet	◐	●	●		●		●		●	●
	XS 542	X-weight AIO Cloth Sheet	◐	●			●		●			
	JG 502	J-weight AIO Cloth Sheet	◐	●			●		●			
	PS 502	Plain weave AIO Cloth Sheet	◐	●			●		●			
	PG 121	Emery Cloth Sheet	●	●		●						
FILM	LF 567	AIO Film Sheet	●	●	●	●			●	●		

● CLOSE COAT ◐ SEMI-OPEN COAT ○ OPEN COAT

PAPER BASED

Premium SiC Latex Water Proof Paper

PROPERTIES

Backing C/B-weight latex reinforced paper
 Bond Type Resin
 Coating Close coat
 Grain Silicon Carbide

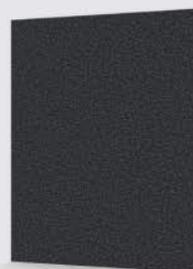
MATERIALS

Paint• Filler• Varnish• Laquer• Plastic

FEATURES

Premium latex backing with advanced bond system for excellent finish

CL 577



MACHINE



FORM



SPECIAL



GRITRANGE

80 100 120 150 180 220 320 400 600 800 1000 1200 1500 2000

SiC Latex Water Proof Paper

PROPERTIES

Backing C/B - weight latex reinforced paper
 Bond Type Resin
 Coating Close coat
 Grain Silicon Carbide

MATERIALS

Paint• Filler• Varnish• Laquer• Plastic

FEATURES

High quality latex paper for flexibility and good cutting action

CL 575



MACHINE



SPECIAL



GRITRANGE

80 100 120 150 180 220 240 280 320 400 600 800 1000 1200 1500 2000 2500 3000

PAPER BASED

Premium AIO Latex Water Proof Paper

PROPERTIES

Backing C/B - weight latex reinforced paper
 Bond Type Resin
 Coating Close coat
 Grain Premium Aluminium Oxide

MATERIALS

Wood • Paint • Filler • Varnish • Laquer •
 Plastic

FEATURES

Premium latex backing with advanced bond system for excellent finish

CL 565



MACHINE

SPECIAL



GRITRANGE

80 100 120 150 180 220 240 280 320 400 600 800 1000 1200 1500 2000

AIO Latex Water Proof Paper

PROPERTIES

Backing C/B- weight latex reinforced paper
 Bond Type Resin
 Coating Close coat
 Grain Premium Aluminium Oxide

MATERIALS

Wood • Paint • Filler • Varnish • Laquer •
 Plastic

FEATURES

Premium Aluminium Oxide with grains for quick cutting action

CL 567



MACHINE

FORM

SPECIAL



GRITRANGE

80 100 120 150 180 220 240 280 320 400 600 800 1000 1200 1500 2000

PAPER BASED

AIO Stearate Paper

PROPERTIES

Backing C - weight paper
 Bond Type Resin
 Coating Semi-open coat
 Grain Aluminium Oxide

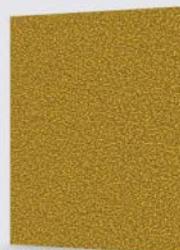
MATERIALS

Wood • Wall • Filler

FEATURES

Stearate coating for anti-clogging effect

CP 547



MACHINE

FORM

SPECIAL



GRITRANGE

60 80 100 120 150 180 220 240 280 320 400 600

CUMI White Paper

PROPERTIES

Backing D - weight paper
 Bond Type Resin
 Coating Semi-open coat
 Grain White Aluminium Oxide

MATERIALS

Steel • Wood • Wall • Paint • Filler

FEATURES

Friable grains for faster cutting action

DR 551



MACHINE

FORM

SPECIAL



GRITRANGE

40 50 60 80 100 120 150 180 220

PAPER BASED

SiC Water Proof Paper

PROPERTIES

Backing D / C - Wet Strength weight paper
Bond Type Resin
Coating Close coat
Grain Silicon Carbide

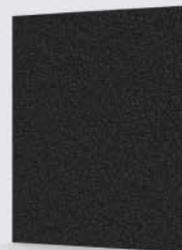
MATERIALS

Steel • Stainless Steel • Non Ferrous Metal •
Wood • Wall • Paint • Varnish • Laquer • Filler •
Plastic

FEATURES

Special bond provides combination of
flexibility & strength

DV / CV 371



MACHINE

FORM

SPECIAL



GRIT RANGE

60 80 100 120 150 180 220 240 280 320 400 500 600 800 1000 1200

Garnet Paper

PROPERTIES

Backing C - weight paper
Bond Type Glue
Coating Open coat
Grain Garnet

MATERIALS

Wood

FEATURES

Garnet grains for good finish

CR 131



MACHINE



GRIT RANGE

36 50 60 80 100 120 150 180

PAPER BASED

Emery Paper

PROPERTIES

Backing C - weight paper
Bond Type Glue
Coating Close coat
Grain Emery

MATERIALS

Steel • Non Ferrous Metal

FEATURES

Modified bond adheres to contours

CR 121



MACHINE



GRIT RANGE

50 60 80 100

Flint Paper

PROPERTIES

Backing C - weight paper
Bond Type Glue
Coating Close coat
Grain Flint

MATERIALS

Wood • Wall

FEATURES

Good quality kraft paper for dry sanding

CR 111



MACHINE



GRIT RANGE

36 50 60 80 100 120 150 180

CLOTH BASED

AIO Flexible Cloth Sheet

PROPERTIES

Backing J - weight cotton
Bond Type Resin
Coating Semi-open coat
Grain Premium Aluminium Oxide

MATERIALS

Steel • Stainless Steel • Wood • Paint •
Varnish • Lacquer • Plastic

FEATURES

Special flexible cloth for contour sanding

JC 565



MACHINE

FORM



GRITRANGE

60 80 100 120 150 180 220 240 280 320 400

X-weight AIO Cloth Sheet

PROPERTIES

Backing X - weight cotton
Bond Type Resin
Coating Semi-open coat
Grain Aluminium Oxide

MATERIALS

Steel • Wood • Paint

FEATURES

Modified bond system for extra durability

XS 542



MACHINE

FORM



GRITRANGE

50 60 80 100 120

CLOTH BASED

J-weight AIO Cloth Sheet

PROPERTIES

Backing J - weight cotton
Bond Type Resin
Coating Semi-open coat
Grain Eco Aluminium Oxide

MATERIALS

Steel • Wood • Paint

FEATURES

Economical product for all purpose general sanding

JG 502



MACHINE

FORM



GRITRANGE

50 60 80 100 120

Plain Weave AIO Cloth Sheet

PROPERTIES

Backing Plain weave poly cotton
Bond Type Resin
Coating Semi-open coat
Grain Eco Aluminium Oxide

MATERIALS

Steel • Wood • Paint

FEATURES

Plain weave poly cotton cloth for extra flexibility and durability.

PS 502



MACHINE

FORM



GRITRANGE

40 60 80 100 120 150 180 220 240 320 400

CLOTH BASED

Emery Cloth Sheet

PG 121

PROPERTIES

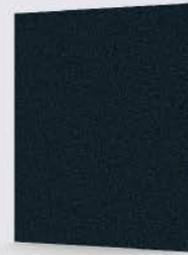
Backing Plain weave cotton
Bond Type Glue
Coating Close coat
Grain Emery

MATERIALS

Steel • Non Ferrous Metal

FEATURES

Light weight backing with soft bond for good finish



MACHINE



GRITRANGE

24 36 60 80 100 120 150 180 220



FILM BASED

AIO Film Sheet

LF 567

PROPERTIES

Backing Film backing
Bond Type Resin
Coating Close coat
Grain Premium Aluminium Oxide

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal •
Paint • Filler

FEATURES

Film backing facilitates excellent finish



MACHINE

FORM



GRITRANGE

60 80 100 120 150 180 220 240 280 320 400 600 800 1000 1200 1500 2000

SHEETS



COATED ABRASIVES

ROLLS



ROLLS

CUMI's paper and cloth backed rolls find extensive use in cleaning, de-rusting and finishing various types of material. These rolls are manufactured using either Emery, Aluminium Oxide, Silicon Carbide grains with specially formulated resins and compatible backing suited for optimum performance in wood, leather, plastic, metal, rubber and glass industries. Coated abrasive rolls are designed for fast and easy sanding of various surfaces and can be torn to exact lengths as needed.



ADVANTAGES OF CUMI ROLLS

- Increased durability
- Adheres to contour sanding
- Good tearable properties
- Highly flexible products for special applications



PAPER BASED

SiC Paper Roll

PROPERTIES

Backing E - weight paper
Bond Type Resin
Coating Close coat
Grain Silicon Carbide

MATERIALS

Leather

FEATURES

Premium Silicon Carbide grain ensures excellent finish on leather

E 601 / 401



MACHINE



GRITRANGE

80 100 120 150 180 220 240 320 400 500 600 800

Green Paper Roll

PROPERTIES

Backing E / D - weight paper
Bond Type Resin
Coating Open coat
Grain White Aluminium Oxide

MATERIALS

Wood • Paint • Filler

FEATURES

Stiff paper for faster cutting action with smooth finish

EP / DP 558



MACHINE



FORM



GRITRANGE

40 60 80 100 120 150

PAPER BASED

Green Paper Roll

PROPERTIES

Backing C - weight paper
 Bond Type Resin
 Coating Open coat
 Grain White Aluminium Oxide

MATERIALS

Wood • Paint • Filler

FEATURES

Flexible paper for faster cutting action with smooth finish

GRIT RANGE

36 60

CP 558



MACHINE

FORM



AIO Paper Roll

PROPERTIES

Backing F - weight paper
 Bond Type Resin
 Coating Semi-open coat
 Grain Aluminium Oxide

MATERIALS

Steel • Wood • Paint

FEATURES

Durable paper for general purpose sanding

GRIT RANGE

24 36 40 50 60 80 100 12150

FP / EP 544



MACHINE

FORM



CLOTH BASED

X- weight Premium AIO Abrasive Cloth Roll

XF 569

PROPERTIES

Backing X - weight flexible cotton
Bond Type Resin
Coating Close coat
Grain Premium Aluminium Oxide

MATERIALS

Steel • Stainless Steel • Wood • Leather

FEATURES

For applications demanding high cut rate



MACHINE

FORM



GRIT RANGE

60 80 100 120 150 180 220 320 400 600



ROLLS



COATED ABRASIVES

CLOTH BASED

X- Weight Premium AIO Industrial Cloth Roll

XF 567

PROPERTIES

Backing	X - weight cotton
Bond Type	Resin
Coating	Close coat
Grain	Premium Aluminium Oxide

MATERIALS

Steel•Stainless Steel• Wood• Leather

FEATURES

Premium grains with flexible cotton backing for aggressive cut & high performance



MACHINE

FORM



GRITRANGE

36 50 60 80 100 120 150 180 220 320 400 600

X- Weight AIO Industrial Cloth Roll

XG 542

PROPERTIES

Backing	X - weight cotton
Bond Type	Resin
Coating	Close coat
Grain	Aluminium Oxide

MATERIALS

Steel•Stainless Steel• Wood• Leather

FEATURES

Heat resistant bond provides good life & finish



MACHINE

FORM



GRITRANGE

36 50 60 80 100 120 150 180 220 320 400 600

CLOTH BASED

J- Weight AIO Flexible Shop Roll

PROPERTIES

Backing J - weight flexible cotton
 Bond Type Resin
 Coating Semi-open coat
 Grain Premium Aluminium Oxide

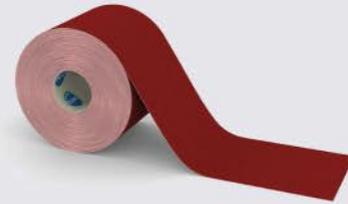
MATERIALS

Steel • Stainless Steel • Non Ferrous Metal •
 Wood • Leather

FEATURES

Flexible cotton cloth assists in tearability

JC 565



MACHINE

FORM



GRIT RANGE

60 80 100 120 150 180 220 240 280 320 400

X- Weight AIO Cloth Roll

PROPERTIES

Backing X - weight cotton
 Bond Type Resin
 Coating Semi-open coat
 Grain Aluminium Oxide

MATERIALS

Steel • Wood • Paint

FEATURES

Modified bond system for extra durability

XS 542



MACHINE

FORM



GRIT RANGE

50 60 80 100 120

CLOTH BASED

J- Weight AIO Shop Roll

PROPERTIES

Backing J - weight cotton
 Bond Type Resin
 Coating Close coat
 Grain Aluminium Oxide

MATERIALS

Steel • Paint

FEATURES

Special bond adheres to profiles

JG 243



MACHINE

FORM



GRITRANGE

36 40 50 60 80 100 120 150 180 220 240 280 320 400 500

J- Weight AIO Cloth Roll

PROPERTIES

Backing J- weight cotton
 Bond Type Resin
 Coating Semi-open coat
 Grain Eco Aluminium Oxide

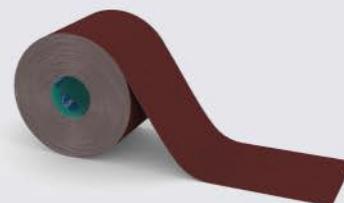
MATERIALS

Steel • Wood • Paint

FEATURES

Economical product for all purpose general sanding

JG 502



MACHINE

FORM



GRITRANGE

50 60 80 100 120

CLOTH BASED

Plain weave AIO Cloth Roll

PROPERTIES

Backing Plain weave poly cotton
Bond Type Resin
Coating Close coat
Grain Eco Aluminium Oxide

MATERIALS

Steel • Wood • Paint

FEATURES

Plain weave poly cotton cloth for extra flexibility and durability.

GRITRANGE

40 60 80 100 120 150 180 220 240 320 400

Emery Cloth Roll

PROPERTIES

Backing Plain weave cotton
Bond Type Glue
Coating Close coat
Grain Emery

MATERIALS

Steel • Non Ferrous Metal

FEATURES

Light weight backing with soft bond for good finish

GRITRANGE

24 36 50 60 80 100 120 150 180 220

PS 502



MACHINE



FORM



PG 121



MACHINE



FORM





BELTS



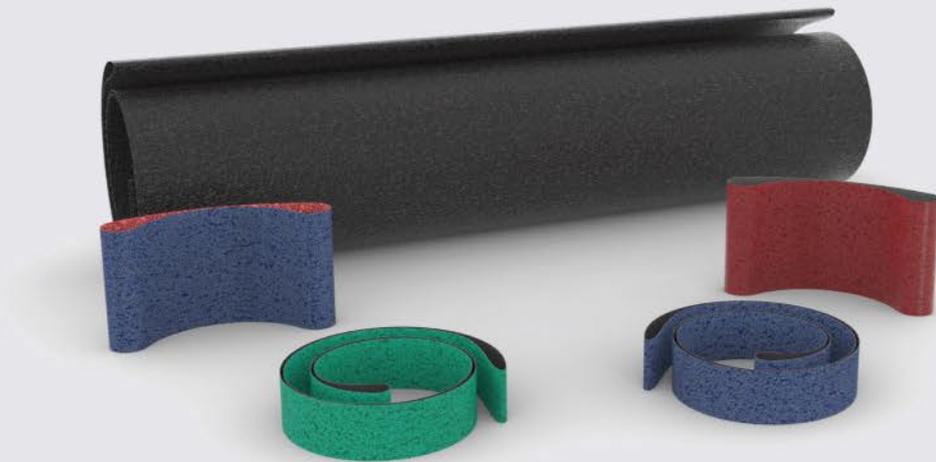
BELTS

CUMI offers belts suitable for all sanding and grinding operations in wide range of sizes on cloth and paper backings. Special designs for customized applications i.e. metal working, wood working are available. Belts are made on backings with high tensile strength and optimum stretch resistance. CUMI supplies long, narrow and wide belts with various types of joints. The type of joint required depends on the work piece involved and machine used.



ADVANTAGES OF CUMI BELTS

- Wide range of backing from highly flexible to most sturdy
- Premium grains for enhanced performance
- Closely graded grains
- Modified bonds for improved grain retention
- Optional supersize coat for cooler cutting action



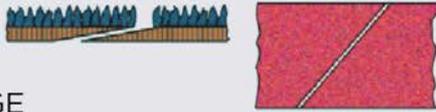
AVAILABLE VARIANTS

PAPER	CLOTH		
	WOOD	METAL	
FP 567	YS 595	YS 592	JF 567
	XS 581	YY585	YW 571
	YS 575	YY 583	
	YS 549	YS 562	

JOINTS

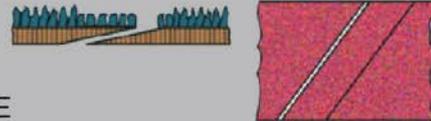
LAP JOINTS

GLUED OVERLAPPED



USAGE
Narrow & Wide belts

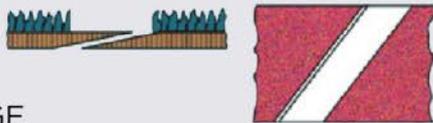
GLUED OVERLAPPED, GRAIN TIPS REMOVED



USAGE
Flexible belt for wood sanding

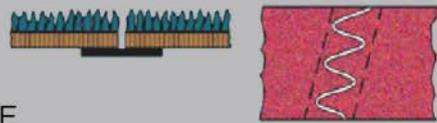
LAP JOINT - TOP LAP FULLY SKIVED

DIAGONAL CUT, GLUED OVERLAPPED, GRAIN AREA REMOVED COMPLETELY



USAGE
For all short belts

ZIGZAG JOINT GLUED BENEATH



USAGE
Cloth belts for the glass | wood industry

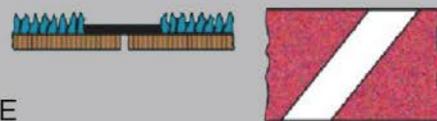
BUTT JOINT (FIBRE REINFORCED TAPE)

BUTT JOINT, GLUED BENEATH



USAGE
Flexible belt for the fittings industry

BUTT JOINT, DIAGONAL CUT, GRAIN AREA REMOVED COMPLETELY, TAPE ON THE GRAIN SIDE



USAGE
Only for special applications

CLOTH BASED- FOR WOOD

Ceramic Cloth Belt

PROPERTIES

Backing Y - weight heavy polyester
Bond Type Resin
Coating Semi-open coat
Grain Ceramic Aluminium Oxide

MATERIALS

Hardwood Floor • Wood • MDF • Particle Board

FEATURES

For a high rate of cut without burn marks

YS 595



MACHINE SPECIAL



GRIT RANGE

36 60 80 120

Zirconia Cloth Belt

PROPERTIES

Backing X - weight poly cotton
Bond Type Resin
Coating Semi-open coat
Grain Zirconia Alumina

MATERIALS

Non Ferrous Metal • Hardwood Floor • Wood

FEATURES

Durable backing with self sharpening grains provides outstanding performance

XS 581



MACHINE FORM



GRIT RANGE

36 60 80 120

CLOTH BASED- FOR METAL

Ceramic Cloth Belt

PROPERTIES

Backing Y - weight heavy polyester
 Bond Type Resin
 Coating Close coat
 Grain Ceramic Aluminium Oxide

MATERIALS

Steel • Stainless Steel • High Carbon Steel • Titanium

FEATURES

Micro crystalline ceramic grains enhances cut rate & durability

GRIT RANGE

36 60 80 120

YS 592



MACHINE SPECIAL



Zirconia Cloth Belt with Top Coat

PROPERTIES

Backing Y - weight heavy polyester
 Bond Type Resin
 Coating Close coat
 Grain Zirconia Alumina

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal • High Carbon Steel • Titanium

FEATURES

Tough bond with supersize coat ensures cooler cutting action

GRIT RANGE

36 60 80 120

YY 585



MACHINE FORM SPECIAL



CLOTH BASED- FOR METAL

Zirconia Cloth Belt

PROPERTIES

Backing Y - weight heavy polyester
 Bond Type Resin
 Coating Close coat
 Grain Zirconia Alumina

MATERIALS

Steel • Non Ferrous Metal • High Carbon Steel

FEATURES

Tough bond with Zirconia Alumina grains for an aggressive cut

GRIT RANGE

36 60 80 120

YY 583



MACHINE



FORM



SPECIAL



AIO Cloth Belt

PROPERTIES

Backing Y - weight polycotton
 Bond Type Resin
 Coating Close coat
 Grain Premium Aluminium Oxide

MATERIALS

Steel • Non Ferrous Metal • High Carbon Steel • Titanium

FEATURES

Premium grains and resin combination for high material removal rate

GRIT RANGE

36 60 80 120

YS 562



MACHINE



FORM



CLOTH BASED- FOR METAL

AIO Flexible Cloth Belt

PROPERTIES

Backing J - weight polycotton
 Bond Type Resin
 Coating Semi-open coat
 Grain Premium Aluminium Oxide

MATERIALS

Non Ferrous Metal

FEATURES

Flexible backing assists in contour sanding

JF 567



MACHINE



GRITRANGE

60 80 100 120 150 180 220 280 320 400

SiC Cloth Belt

PROPERTIES

Backing Y - weight polyester
 Bond Type Resin
 Coating Close coat
 Grain Silicon Carbide

MATERIALS

Steel • Stainless Steel • Glass

FEATURES

Close Graded grains for excellent cut & finish

YW 571



MACHINE

SPECIAL



GRITRANGE

60 80 100 120 150 180 220 320 400

FIBER DISCS



FIBER DISCS

CUMI's fiber discs are designed for applications ranging from heavy stock removal to finishing operations. Made from a vulcanized fiber backing and high performance bond system, these fiber discs are available in aluminium oxide, Silicon Carbide, Zirconia Alumina and Ceramic Aluminium Oxide variants.

The high quality fiber, available in different thickness has high mechanical strength and stable at high grinding temperatures. These discs are designed for high speed operations with hand held grinding machines - pneumatic, electrical.

Cumi's range of fiber discs are available in 3 different variants:

- a. IDC fiber discs
- b. Jumbo fiber discs
- c. Trimmable discs

ADVANTAGES OF CUMI FIBER DISCS

- Special treated grains for maximum cut rate
- Imported vulcanized fiber for high strength
- High performance bond for longer life
- Active fillers for increased performance



ROUND HOLE



SLIT HOLE



SLOT HOLE



AVAILABLE VARIANTS

IDC FIBER DISCS		TRIMMABLE DISCS		JUMBO FIBER DISCS	
VR 599	VR 569	TD 592	TD 549	VR 581	VR/FR 561
VR 589		TD 585		VR 571	VR/FR 543

APPLICATION GUIDE

BACKING	CODE	PRODUCT DESCRIPTION	COATING	MATERIAL							
				Steel	Stainless Steel	Non Ferrous Metal	Chrome Steel	Castings	Glass Fiber	Wood	Stone / Glass / Marble
IDC	VR 599	CUMI Krypton	●	●	●		●	●			
	VR 589	CUMI Zing	●	●	●		●	●	●		
	VR 569	Alpha	●	●	●	●			●	●	
JUMBO BASED	VR 581	Blue Spark Zirconia	●	●	●		●	●	●		
	VR 571	SiC Fiber Disc	◐			●				●	●
	VR / FR 561	Alpha Supreme	●	●	●	●			●	●	
	VR / FR 543	Cumi Flex AIO	●	●	●	●			●	●	
TRIMMABLE DISCS	TD 592	Ceramic Trimmable Disc	●	●	●		●	●			
	TD 585	Zirconia Trimmable Disc	●	●	●		●	●	●		
	TD 549	AIO Trimmable Disc	●	●		●			●		

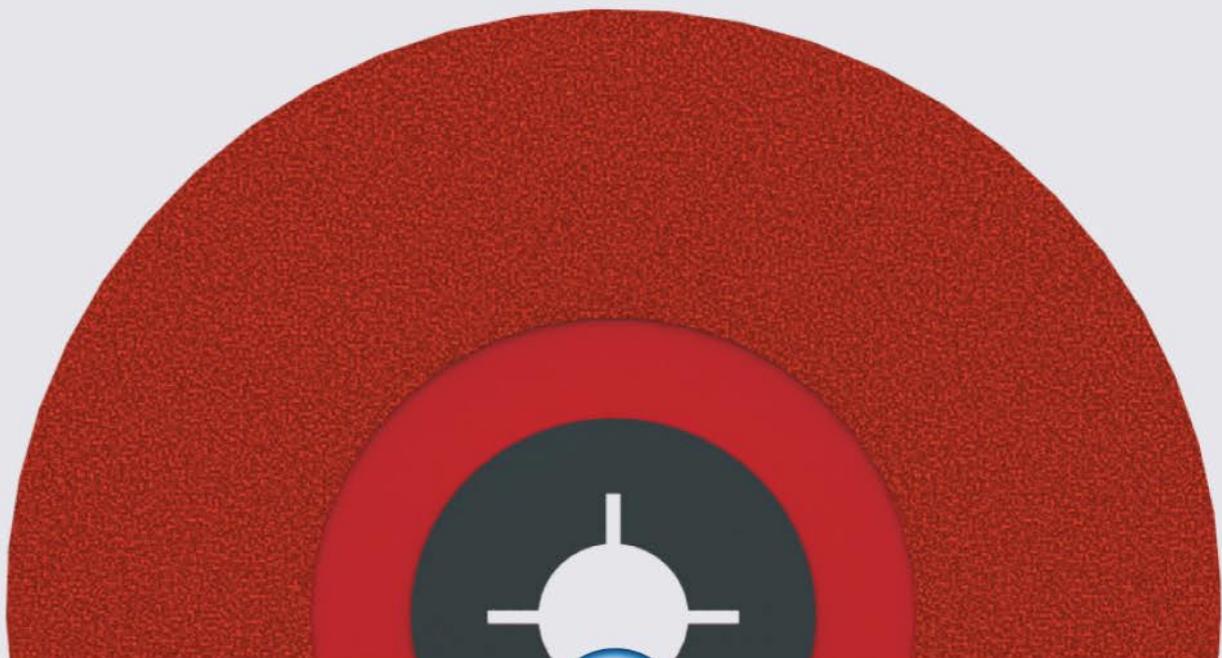
● CLOSE COAT ◐ SEMI-OPEN COAT

IDC FIBER DISCS

CUMI is one of the few abrasive players to manufacture IDC range of fiber discs. IDC stands for Individual Disc Coating. As the name implies, these discs are individually coated with a superior bond and grain combination. Typically, in a jumbo fiber discs, the jumbo is punched to the required shape. Due to this action, the outer edges of the discs tend to get weaker resulting in premature grain shedding. By coating individually, grain adhesion on the periphery of the disc drastically reduces grain shedding resulting in high performance.

The advantages of IDC over conventional fiber discs are:

- a) Strong & uniform grain coating at the edges
- b) Reduced grain shedding
- c) Lower edge wear
- d) Improved grain retention for longer life



IDC FIBER DISCS

CUMI Krypton

PROPERTIES

Backing 0.8 / 0.85mm vulcanised fiber
Bond Type Resin
Coating Close coat
Grain Ceramic Aluminium Oxide

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal •
Chrome Steel • Castings

FEATURES

Ceramic grains with super-size coat for best in class performance

GRIT RANGE

24 36 60 80 100 120

VR 599



MACHINE



CUMI Zing

PROPERTIES

Backing 0.8 / 0.85mm vulcanised fiber
Bond Type Resin
Coating Close coat
Grain Zirconia Alumina

MATERIALS

Steel • Stainless steel • Chrome steel •
Castings • Glass fiber

FEATURES

Premium grains for aggressive edge grinding

GRIT RANGE

24 36 60 80 100 120

VR 589



MACHINE



IDC FIBER DISCS

Alpha

VR 569

PROPERTIES

Backing 0.8 / 0.85mm vulcanised fiber
Bond Type Resin
Coating Close coat
Grain Premium Aluminium Oxide

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal •
Glass Fiber • Wood

FEATURES

Special bond for metal grinding application

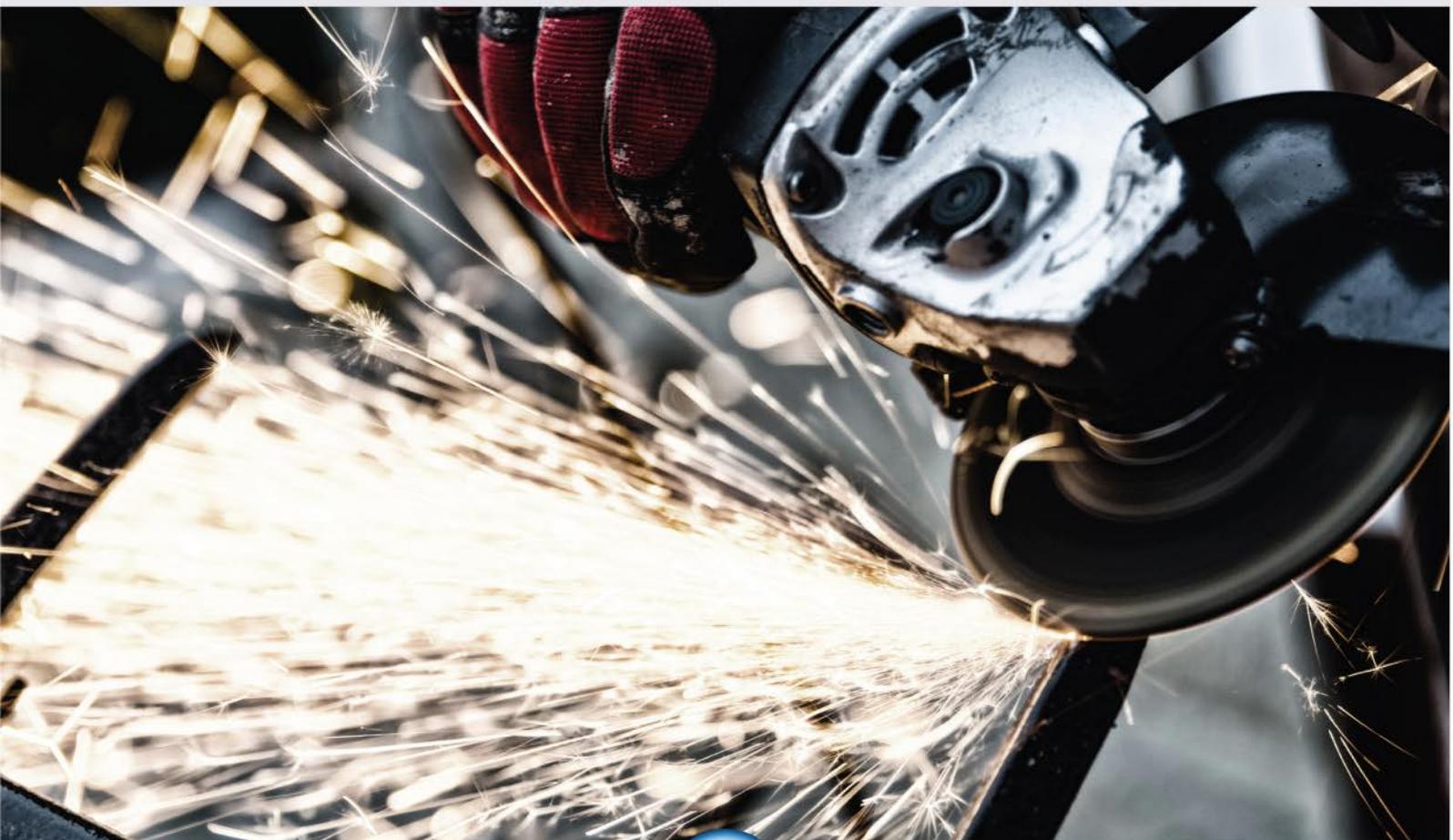


MACHINE



GRITRANGE

24 36 50 60 80 100 120



FIBER DISCS

CUMI

COATED ABRASIVES

JUMBO FIBER DISCS

Blue Spark Zirconia

PROPERTIES

Backing 0.8mm vulcanised fiber
Bond Type Resin
Coating Close coat
Grain Zirconia Alumina

MATERIALS

Steel • Stainless steel • Chrome steel •
Castings • Glass fiber

FEATURES

Premium grains for aggressive cut

VR 581



MACHINE

FORM



GRIT RANGE

24 36 50 60 80 100 120

SiC Fiber Disc

PROPERTIES

Backing 0.8mm vulcanised fiber
Bond Type Resin
Coating Semi-open coat
Grain Silicon carbide

MATERIALS

Non Ferrous Metal • Wood • Stone • Glass •
Marble

FEATURES

Semi-open coat ensures minimal loading

VR 571



MACHINE

FORM



GRIT RANGE

24 36 50 60 80 100 120

JUMBO FIBER DISCS

Alpha Supreme

PROPERTIES

Backing 0.8mm / 0.6mm vulcanised fiber
Bond Type Resin
Coating Close coat
Grain Premium Aluminium Oxide

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal
Glass fiber • Wood

FEATURES

Long life with good finish

VR / FR 561



MACHINE



FORM



GRIT RANGE

24 36 50 60 80 100 120

Cumi Flex AIO

PROPERTIES

Backing 0.8mm / 0.6mm vulcanised fiber
Bond Type Resin
Coating Close coat
Grain Aluminium Oxide

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal •
Glass Fiber • Wood

FEATURES

Suitable for all purpose general grinding

VR / FR 543



MACHINE

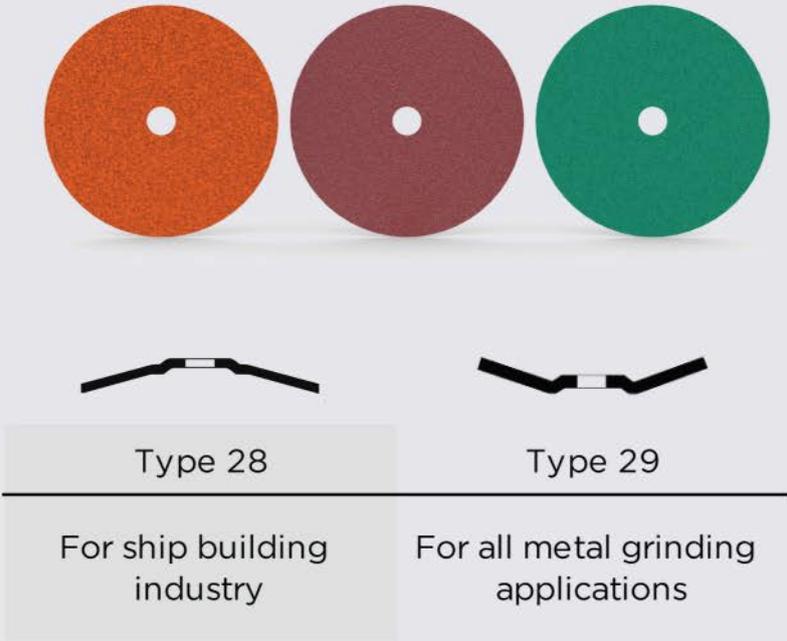


GRIT RANGE

24 36 50 60 80 100 120

TRIMMABLE DISCS

Trimmable discs are CUMI's new range of natural fiber disc. The backing of these discs are made out of natural jute which can be trimmed. These fiber discs require no backing pad and are absolutely curl free. CUMI's trimmable fiber discs are available in two different shapes.



Type 28
For ship building industry

Type 29
For all metal grinding applications

TRIMMABLE DISCS

AIO Trimmable Disc

PROPERTIES

Backing Natural fiber
Bond Type Resin
Coating Close coat
Grain Aluminium Oxide

MATERIALS

Steel • Non Ferrous Steel • Glass fiber

FEATURES

Combination of aggressive performance and curl free structure

TD 549



MACHINE



TYPES



GRIT RANGE

24 36 60 80 120

TRIMMABLE DISCS

Ceramic Trimmable Disc

PROPERTIES

Backing	Natural fiber
Bond Type	Resin
Coating	Close coat
Grain	Ceramic Aluminium Oxide

MATERIALS

Steel • Stainless steel • Chrome steel •
Castings

FEATURES

Combination of aggressive performance and
curl free structure

GRIT RANGE

36 60 80 120

TD 592



MACHINE



TYPES



Zirconia Trimmable Disc

PROPERTIES

Backing	Natural fiber
Bond Type	Resin
Coating	Close coat
Grain	Zirconia Alumina

MATERIALS

Steel • Stainless steel • Chrome steel •
Castings • Glass fiber

FEATURES

Combination of aggressive performance and
curl free structure

GRIT RANGE

36 60 80 120

TD 585



MACHINE



TYPES



FLAP DISCS



FLAP DISCS

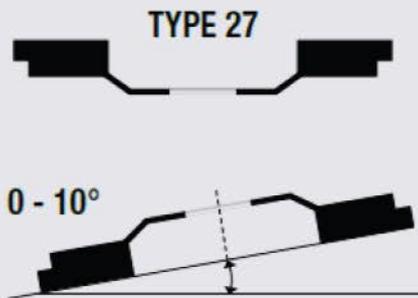
CUMI's flap disc are the one stop solution for grinding & polishing operations.

Typically, a flap disc is made of 3 components:

- Backing pad
- Bonding agent
- Abrasive cloth flaps.

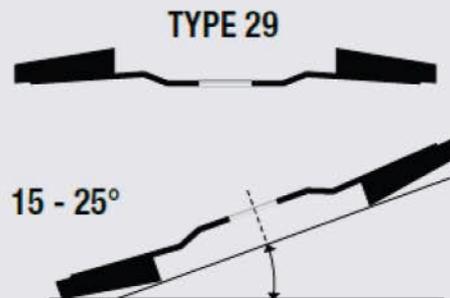


The significance of flap disc is that the abrasive grains perform the cutting action. Once the grains are fully consumed, the work piece comes in contact with the cloth material which wears away giving rise to new abrasive material to perform the operation once again. For this reason, flap discs are preferred over fiber discs and D.C wheels



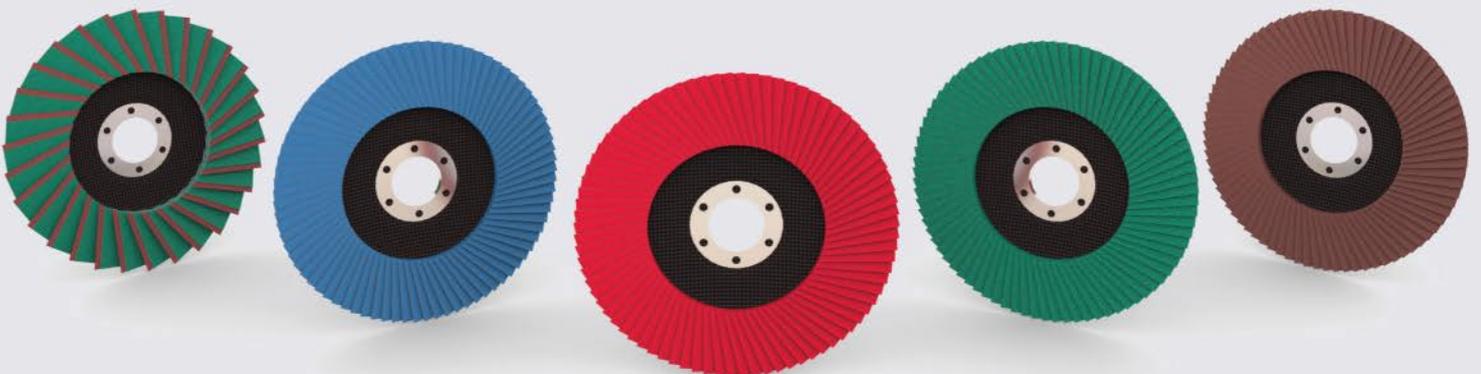
Flat flap disc for maximum contact surface for grinding.

Best suited for surface grinding applications.



Conical flap disc provides greater angles.

Best suited for grinding concave surfaces, difficult to reach areas.



BACKING PAD VARIANTS

FIBRE GLASS



Widely used variety in market

PLASTIC



Light weight & trimmable pads

ALUMINIUM



More sturdy & absorbs vibration

All of the above varieties are also available in 5/8-11" mounting hub for reduced change over time

PRODUCT LABEL EXPLANATION

EUROPEAN SAFETY STANDARD EN 12413

MAXIMUM OPERATING SPEED



CUMIFLEX BRANDING

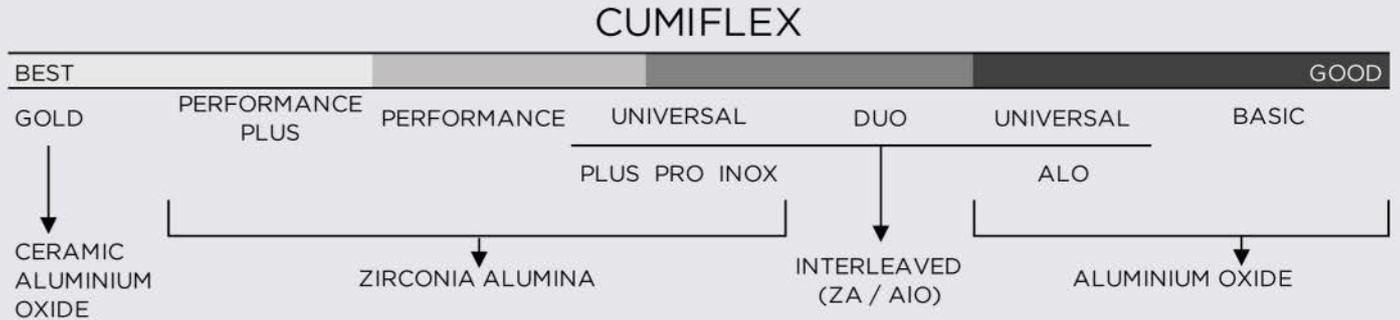
SPEED BAND

PICTOGRAM

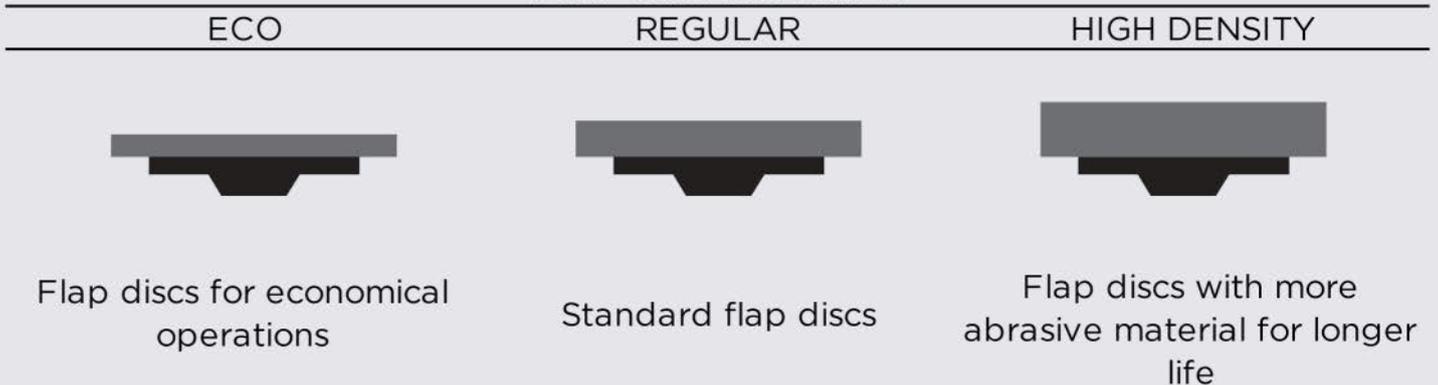
PRODUCT DIMENSION

ABOUT CUMIFLEX FLAP DISCS:

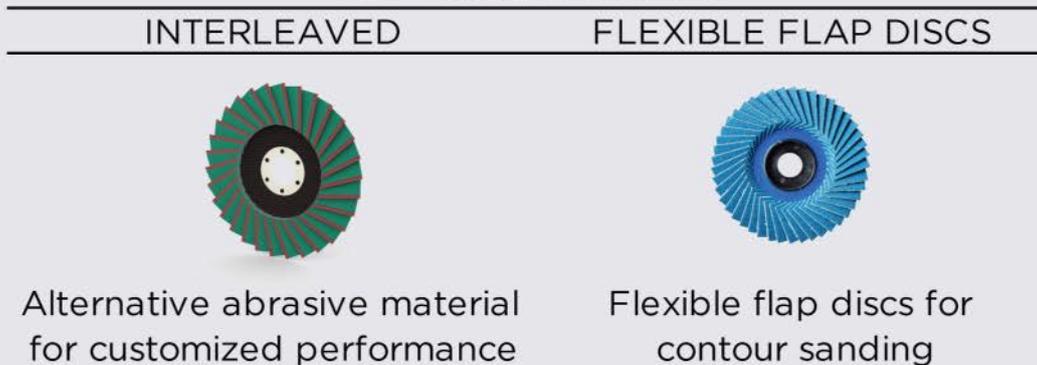
Cumiflex range of flap discs are manufactured with specially designed abrasive cloth exclusively for flap discs. The abrasive materials are chosen depending on the end application thereby yielding maximum performance and longer life. Cumiflex range of flap discs increases productivity and reduces total grinding costs. Cumiflex flap discs can be broadly classified under the following categories :



FLAP DISC DENSITIES



FLAP DISC VARIANTS



CLOTH BASED

Cumiflex Gold

PROPERTIES

Backing Y - weight polycotton
Bond Type Resin
Coating Semi-open
Grain Ceramic Aluminium Oxide

MATERIALS

Steel • Stainless Steel

FEATURES

Faster cut-rate with reduced grinding temperature

GRIT RANGE
40 60 80 120

YS 599



MACHINE SPECIAL



Cumiflex Performance Plus

PROPERTIES

Backing Y - weight polycotton
Bond Type Resin
Coating Semi-open
Grain Zirconia Alumina

MATERIALS

Steel • Stainless Steel

FEATURES

Premium Zirconia Alumina grains assists in faster cutting action under pressure

GRIT RANGE
40 60 80 120

YS 589



MACHINE SPECIAL



CLOTH BASED

Cumiflex Performance

PROPERTIES

Backing X - weight polycotton
Bond Type Resin
Coating Close coat
Grain Zirconia Alumina

MATERIALS

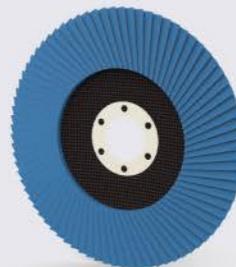
Steel • Stainless Steel

FEATURES

Close coat for aggressive cut & longer life

GRIT RANGE
24 36 60 80 120

XS 581



MACHINE



FORM



Cumiflex Universal Pro

PROPERTIES

Backing Y - weight polycotton
Bond Type Resin
Coating Semi-open
Grain Zirconia Alumina

MATERIALS

Steel • Stainless Steel

FEATURES

Special coating for cooler cutting action in stainless steel. Suitable for heavy duty grinding

GRIT RANGE
40 60 80 120

YS 588



MACHINE



FORM



SPECIAL



CLOTH BASED

Cumiflex Universal Plus

PROPERTIES

Backing X - weight cotton
 Bond Type Resin
 Coating Semi-open
 Grain Zirconia Alumina

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal • Wood

FEATURES

Special coating for cooler cutting action in stainless steel. Suitable for light to medium pressure grinding

GRIT RANGE

60 80 120

XS 588



MACHINE



FORM



SPECIAL



Cumiflex Universal Inox

PROPERTIES

Backing X - weight cotton
 Bond Type Resin
 Coating Semi-open
 Grain Zirconia Alumina

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal • Wood

FEATURES

Suitable for all purpose general grinding

GRIT RANGE

40 60 80 120

XD 589



MACHINE



FORM



CLOTH BASED

Cumiflex Duo

PROPERTIES

Backing X - weight polycotton
Bond Type Resin
Coating Close coat
Grain Zirconia Alumina /
Aluminium Oxide

MATERIALS

Steel • Stainless Steel

FEATURES

Combination of Zirconia Alumina and Aluminium Oxide abrasive flaps for economical and efficient grinding

GRIT RANGE

40 60 80 120

XS588/XD540



MACHINE SPECIAL



Cumiflex Universal AIO

PROPERTIES

Backing X - weight polycotton
Bond Type Resin
Coating Close coat
Grain Premium Aluminium Oxide

MATERIALS

Steel • Stainless Steel

FEATURES

Suitable for heavy duty grinding

GRIT RANGE

36 60 80 120

XS 561



MACHINE FORM



CLOTH BASED

Cumiflex Basic

XD 549

PROPERTIES

Backing X - weight cotton
Bond Type Resin
Coating Semi-open
Grain Aluminium Oxide

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal •
Wood

FEATURES

Suitable for all purpose general grinding



GRIT RANGE

40 60 80 120

DISCS



DISCS

CUMI's discs find extensive use in surface preparation applications on metal, composite, wood, wall etc.,. Available in paper, cloth, film and fiber backing with different abrasives suiting different needs, they are designed for stripping, intermediate finishing and polishing applications. Wide range of hole patterns available to suit different machines.

- PSA • Hook'n loop • Plain discs
- Quick change discs
- Double side discs



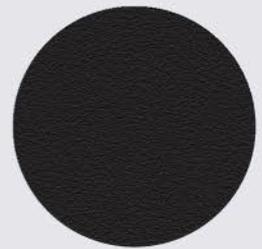
HOOK 'N LOOP



QUICK CHANGE DISC



PSA



DOUBLE SIDED DISC



PSA / HOOK 'N LOOP DISCS

Cumi's PSA / Hook 'n loop discs are available in a wide range of sizes and hole patterns to suit different machines and applications. All of these discs are also available as individual discs based on customer requirement



PSA



HOOK 'N LOOP



HOLE PATTERNS



5" 5holes



5" 8holes



5" 9holes



6" 5holes



6" 8holes



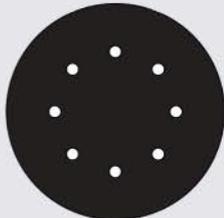
6" 9holes



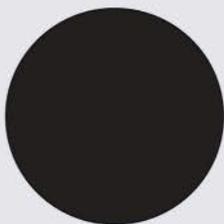
6" 16holes



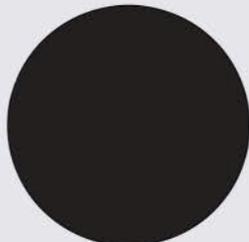
7" 8holes



9" 8holes



9" no holes



10" no holes

PAPER BASED

Ceramic Paper Disc

PROPERTIES

Backing F - weight paper
Bond Type Resin
Coating Semi-open coat
Grain Ceramic Aluminium Oxide

MATERIALS

Steel • Stainless Steel • Filler • Glass Fiber •
Wood • Cement • Paint • Varnish

FEATURES

Premium Ceramic Aluminium Oxide grains
for faster cutting action and longer life

GRIT RANGE

60 80 100 120

FP 594



MACHINE



FORMS



Zirconia Paper Disc

PROPERTIES

Backing F - weight paper
Bond Type Resin
Coating Semi-open coat
Grain Zirconia Alumina

MATERIALS

Steel • Stainless Steel • Filler • Glass Fiber •
Wood • Cement • Paint • Varnish

FEATURES

Modified bond system for high cut rate

GRIT RANGE

60 80 120

FP 584



MACHINE



FORMS



PAPER BASED

SiC Paper Disc

PROPERTIES

Backing F - weight paper
Bond Type Resin
Coating Semi-open coat
Grain Silicon Carbide

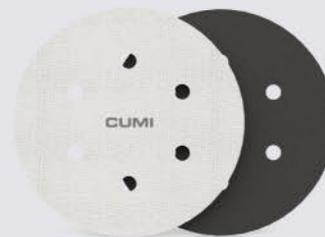
MATERIALS

Steel • Stainless Steel • Filler • Glass Fiber •
Wood • Cement

FEATURES

Modified Bond system for fast cutting action

FP 574



MACHINE

FORM



GRIT RANGE

60 80 120 150

AIO Paper Disc

PROPERTIES

Backing F - weight paper
Bond Type Resin
Coating Semi-open coat
Grain Premium Aluminium Oxide

MATERIALS

Steel • Stainless Steel • Filler • Glass Fiber •
Wood • Cement • Paint • Varnish

FEATURES

Modified Bond system for extra durability

FP 567



MACHINE

FORM



GRIT RANGE

60 80 120 150 180 220 320

PAPER BASED

AIO Anti Static Paper Disc

PROPERTIES

Backing C - weight paper
Bond Type Resin
Coating Semi-open coat
Grain Aluminium Oxide

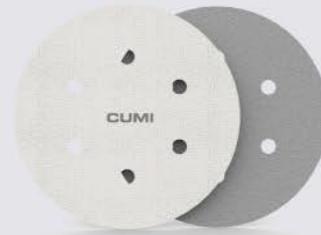
MATERIALS

Steel • Stainless Steel • Filler • Glass Fiber •
Wood • Cement • Paint • Varnish

FEATURES

Antistatic property enhances performance

CP 544



MACHINE

FORM



GRIT RANGE

40 60 80 120 150 180 220 320 400

AIO Stearate Paper Disc

PROPERTIES

Backing C - weight paper
Bond Type Resin
Coating Semi-open coat
Grain Aluminium Oxide

MATERIALS

Filler • Glass Fiber • Wood

FEATURES

Special stearate coating for anti-clogging effect

CP 547



MACHINE

FORM



GRIT RANGE

60 80 100 120 150 180 220 240 280 320 400 600

CLOTH BASED

Ceramic Cloth Disc

PROPERTIES

Backing Y - weight polycotton
Bond Type Resin
Coating Close coat
Grain Ceramic Aluminium Oxide

MATERIALS

Steel • Stainless Steel

FEATURES

Micro crystalline ceramic grains enhances cut rate & durability

GRITRANGE

36 60 80 120

YS 592



MACHINE

FORM

SPECIAL



Premium Zirconia Cloth Disc

PROPERTIES

Backing Y - weight heavy polyester
Bond Type Resin
Coating Close coat
Grain Zirconia Alumina

MATERIALS

Steel • Stainless Steel

FEATURES

Tough bond with supersize coat ensures cooler cutting action

GRITRANGE

36 60 80 120

YY 585



MACHINE

FORM

SPECIAL



CLOTH BASED

Zirconia Cloth Disc

PROPERTIES

Backing X - weight polycotton
Bond Type Resin
Coating Semi-open coat
Grain Zirconia Alumina

MATERIALS

Steel • Stainless Steel • Filler • Glass Fiber •
Wood • Paint • Varnish

FEATURES

Durable backing with self sharpening grains provide outstanding performance

GRIT RANGE
24 36 60 80 120

XS 581



MACHINE

FORM



Zirconia Cloth Disc

PROPERTIES

Backing Y - weight polycotton
Bond Type Resin
Coating Close coat
Grain Zirconia Alumina

MATERIALS

Steel • Stainless Steel • Paint • Varnish

FEATURES

Self sharpening grains provide outstanding performance

GRIT RANGE
80 120

YS 582



MACHINE



CLOTH BASED

AIO Cloth Disc

XS 561

PROPERTIES

Backing X - weight polycotton
Bond Type Resin
Coating Close coat
Grain Premium Aluminium Oxide

MATERIALS

Steel • Stainless Steel • Filler • Glass Fiber •
Wood • Paint • Varnish

FEATURES

Premium grains & resin for high material
removal rate



MACHINE

FORM



GRIT RANGE

36 60 80 120



PSA / HOOK 'N LOOP



COATED ABRASIVES

FILM BASED

AIO Film Disc

LF 567

PROPERTIES

Backing	Film backing
Bond Type	Resin
Coating	Close coat
Grain	Premium Aluminium Oxide

MATERIALS

Steel • Stainless Steel • Filler • Glass Fiber •
Wood • Paint • Varnish

FEATURES

Film backing facilitates excellent finish



MACHINE



GRITRANGE

60 80 100 120 150 180 220 240 280 320 400 600 800 1000 1200 1500 2000



PSA / HOOK 'N LOOP



COATED ABRASIVES

QUICK CHANGE DISCS

Cumi's range of quick change discs are the ideal choice for operations ranging from grinding to finishing. Due to its quick change system, these discs have gained more popularity increasing productivity and reducing change over time drastically. Quick change discs are available in two types of fastener attachments



TYPE R

Roll on/ roll off style threaded bush

Bush made of plastic



TYPE S

Turn on/ Turn off style bush

Bush made of metal



CLOTH BASED

Ceramic Cloth Disc

PROPERTIES

Backing Y - weight heavy polyester
 Bond Type Resin
 Coating Close coat
 Grain Ceramic Aluminium Oxide

MATERIALS

Steel • Stainless Steel • Titanium • Casting

FEATURES

Tough bond with supersize coat ensures cooler cutting action

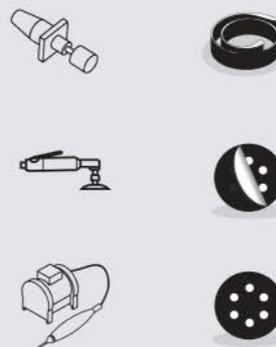
GRIT RANGE

36 60 80 120

YS 592



MACHINE FORM



Premium Zirconia Cloth Disc

PROPERTIES

Backing Y - weight heavy polyester
 Bond Type Resin
 Coating Close coat
 Grain Zirconia Alumina

MATERIALS

Steel • Stainless Steel • Titanium • Casting

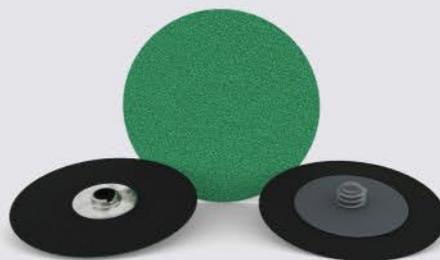
FEATURES

Tough bond with supersize coat ensures cooler cutting action

GRIT RANGE

36 60 80 120

YY 585



MACHINE FORM SPECIAL



CLOTH BASED

Zirconia Cloth Disc

PROPERTIES

Backing Y - weight polycotton
Bond Type Resin
Coating Semi-open
Grain Zirconia Alumina

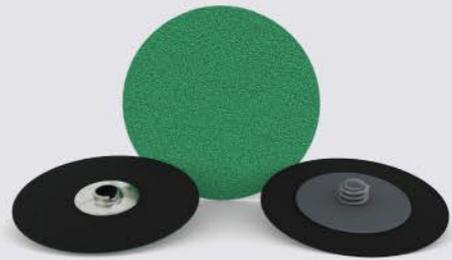
MATERIALS

Steel • Stainless Steel

FEATURES

Special coating for cooler cutting action in stainless steel

YS 588



MACHINE



FORM



SPECIAL



GRIT RANGE

40 60 80 120

FIBER BASED

Blue Spark

PROPERTIES

Backing 0.8mm Vulcanised Fibre
Bond Type Resin
Coating Close
Grain Zirconia Alumina

MATERIALS

Steel • Stainless Steel • Titanium • Casting

FEATURES

Premium grains for aggressive cut

GRIT RANGE

24 36 50 60 80

VR 581



MACHINE

FORM



Alpha Supreme

PROPERTIES

Backing 0.8mm Vulcanised Fibre
Bond Type Resin
Coating Semi-open
Grain Premium Aluminium Oxide

MATERIALS

Steel • Stainless Steel

FEATURES

Long life with good finish

GRIT RANGE

24 36 50 60 80

VR 561



MACHINE

FORM



BEARING INDUSTRY

NON WOVEN ABRASIVES



CARBORUNDUM UNIVERSAL LIMITED

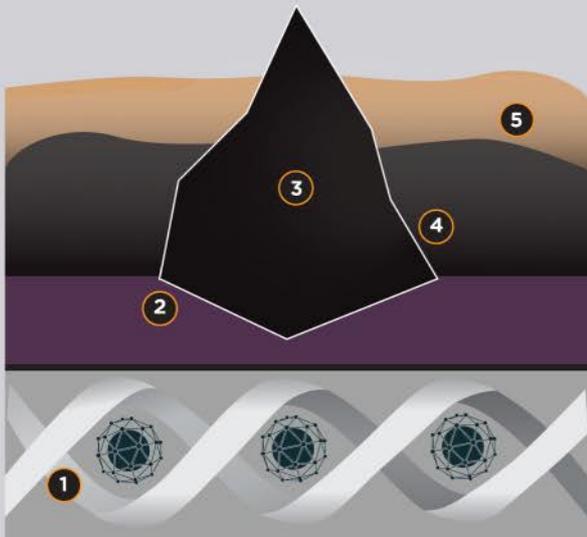
About CUMITEX Non Woven Abrasives:

CUMI proudly presents its “CUMITEX” range of non-woven abrasive products for high performance polishing, blending, deburring, cleaning and finishing applications. Cumitex non-woven abrasives are three dimensional composite materials made from high tenacity **Polyamide 66** fibers uniformly coated with high performance abrasive grains and water proof bond.

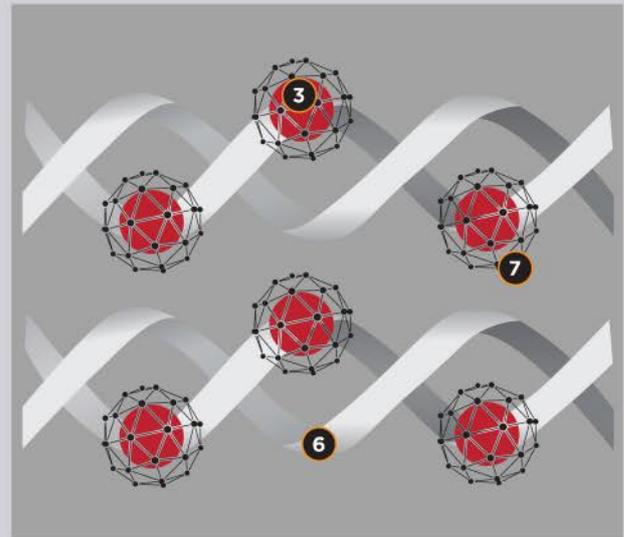
The Cumitex range of non-woven abrasives consists of flat stocks (hand pads & rolls), surface conditioning belts, unitized wheels, convolute wheels, quick change discs, unitized discs, shaft mounted flap wheels and flange mounted flap wheels.

COMPARISON BETWEEN THE STRUCTURES

COATED ABRASIVES



NON WOVEN ABRASIVES



- 1 BACKING
- 2 MAKER COAT
- 3 ABRASIVE GRAIN
- 4 SIZER COAT
- 5 TOP COAT
*OPTIONAL
- 6 FIBER
- 7 RESIN BINDER

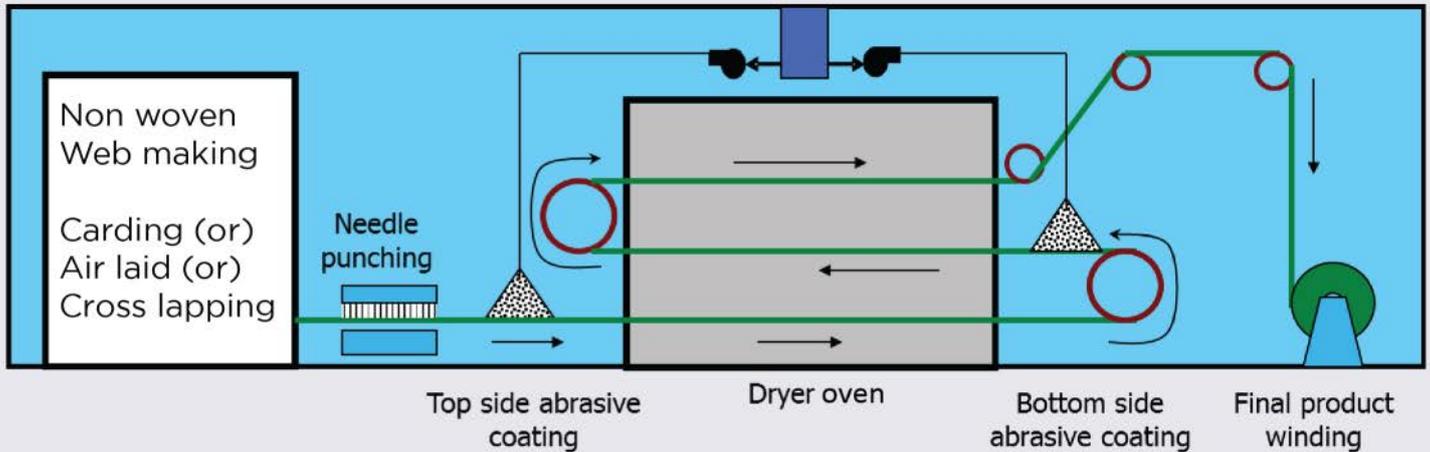
COATED ABRASIVES

Single layer of abrasives
Rigid woven cloth backing
(For material removal)
Closed backing structure

NON WOVEN ABRASIVES

Multiple layers of abrasives
Flexible non woven backing
(For polishing)
Open backing structure

MANUFACTURING PROCESS



CUMITEX NON WOVEN COMPOSITIONS

NON WOVEN FABRIC	ABRASIVE GRAINS	BINDERS
Polyamide 66 (Nylon Fiber)	Silicon Carbide	Phenolic
	Aluminum Oxide	Acrylic
	Feldspar	Epoxy
Polyester (For selected hand scouring pads)	Garnet	Coupling agents
	Calcium Carbonate	Lubricants
	Talc	Polyurethane

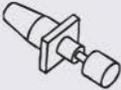
Performance Requirement

- Cutting action
- Compression resistance
- Finish generation
- Elongation resistance
- Product life
- Water proof



APPLICATIONS OF NON WOVEN ABRASIVES

INDUSTRIAL APPLICATIONS		CONSUMER APPLICATIONS	
METAL WORKING	WOOD WORKING	HOME CARE	HOSPITALITY
Cleaning	Denibbing/Defuzzing	Floor cleaning pads	Kitchen scrub pads
Deburring	Sealer/Lacquer sanding		
Blending	Profile Sanding		
Polishing/Finishing	Floor Sanding		

INDUSTRIAL PROCESS	MACHINES	NON WOVEN PRODUCTS	
<p>DEBURRING: Removal of burrs and sharp edges created by heavy duty actions like abrasive grinding, cutting, shearing etc., without altering the geometry of the base material</p> <p>BLENDING: Levelling off surface imperfections created by welding, abrasive grinding and shearing operations</p> <p>SURFACE CONDITIONING: Preparing the surfaces for painting, electroplating etc.,</p> <p>POLISHING AND FINAL FINISHING: Generating aesthetic and functional finishes on metals, plastics, wood etc.,</p>		 <p>Unitised discs</p>	
		<p>STRAIGHT DIE GRINDERS: Deburring, Blending</p>	 <p>Shaft mounted flap wheels</p>
		<p>RIGHT ANGLE DIE GRINDERS: Deburring, Blending, Surface Conditioning</p>	 <p>Quick change discs</p>
		<p>BENCH GRINDERS: Surface Conditioning, Finishing</p>	 <p>Unitized wheels</p>
		<p>CENTERLESS POLISHING MACHINE Surface Conditioning, Finishing</p>	 <p>Convolute wheels</p>

UNDERSTANDING THE PICTOGRAMS

CUMI's versatile range of products come in various forms. The pictograms below are indicative of the same.

FORMS



SHEETS



ROLLS



FLAP WHEELS

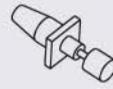
MACHINES



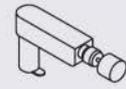
ANGLE GRINDER



BACK STAND
GRINDER



DIE GRINDER



DRILLING MACHINE



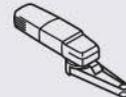
FLEXIBLE SHAFT
GRINDER



FLOOR STANDING
GRINDER



HAND SANDING



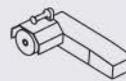
HAND TOOL BELT
GRINDER



ORBITAL SANDER



PARQUET SANDER



SATIN FINISHING
MACHINE



VIBRATION SANDER

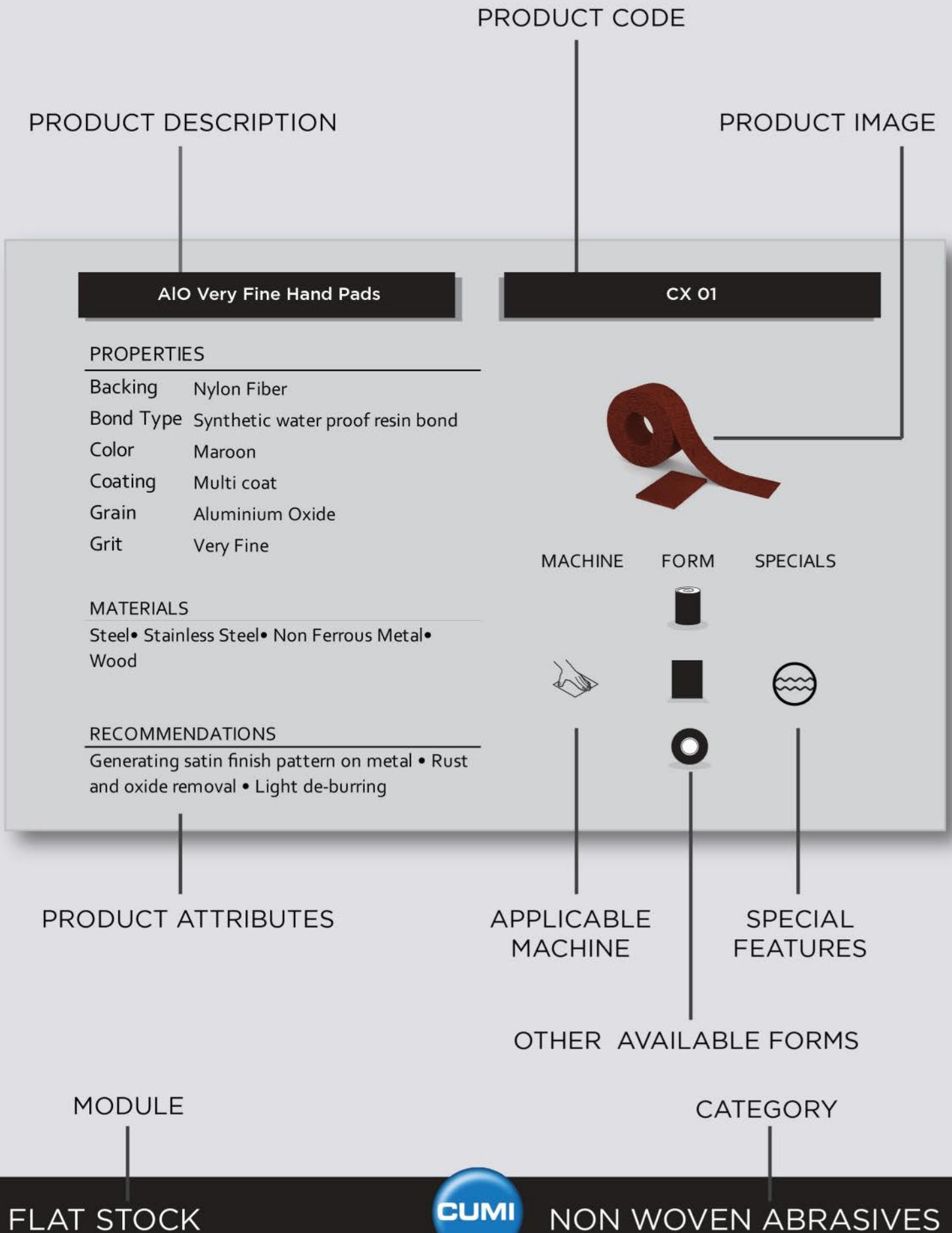
SPECIALITY



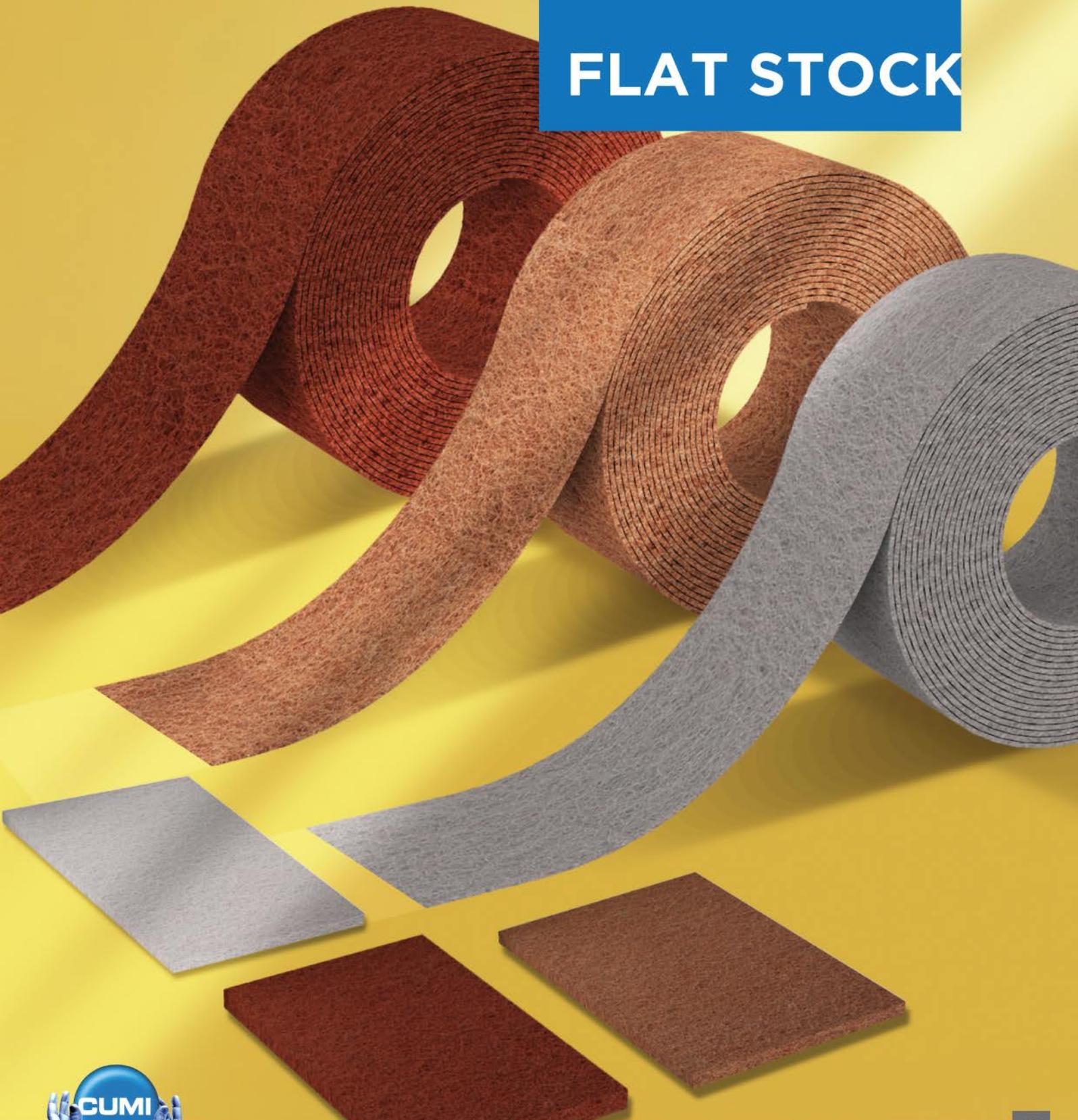
ANTI-CLOG

Products with this pictogram consists of a stearate lubricant which minimizes the clogging effect during sanding inturn reducing friction and pro-longing life.

HOW TO READ THE BROCHURE



FLAT STOCK



FLAT STOCK (HAND PADS & ROLLS)

- Cumitex offers wide range of nonwoven flat stock (hand pads & rolls) for free sanding and machine sanding operations.
- Made from premium quality nylon web, coated with high performance synthetic abrasive grains and water proof resin bond system, these products do not load / clog and can be used with water and polishing compounds.
- Cumitex range of flat stock are ideal for cleaning, rust removal, generating decorative finishes on brass, carbon steel, aluminium, stainless steel and wood.

PRODUCT CODE EXPLANATION

CUMI CODE	GRAIN	GRIT	TYPE	COLOR
CX 01	Aluminium Oxide	Very Fine	Flexible	Maroon
CX 02	Aluminium Oxide	Medium	Stiff	Tan
CX 03	Silicon Carbide	Micro Fine	Flexible	Light Grey
CX 04	Silicon Carbide	Ultra Fine	Flexible	Dark Grey
CX 05	Aluminium Oxide	Fine	High Strength	Maroon
CX 06	Aluminium Oxide	Fine	High Strength	Green
CUMITEX SUPER	Aluminium Oxide	Very Fine	Flexible	Maroon
CUMITEX GP MAROON	Aluminium Oxide	Very Fine	Highly Flexible	Maroon
CUMITEX GP GREEN	Aluminium Oxide	Medium	Highly Flexible	Green
CUMITEX MD9650	Aluminium Oxide	Very Fine	Flexible	Green
CUMITEX ECO GREEN	Feldspar	Very Fine	Flexible	Green
CUMITEX HD WHITE	Feldspar	Micro Fine	Flexible	White

CUMITEX PRODUCT SPECTRUM

AGGRESSIVE				FINISH		
CX 02	CX 05	CX 01	Super	CX 04	CX 03	HD WHITE
	CX 06		GP Maroon			
			GP Green			
			MD 9650			
			Eco Green			



APPLICATION GUIDE

CODE	PRODUCT DESCRIPTION	MATERIAL									
		Steel	Stainless Steel	Non Ferrous Metal	Wood	Wall	Ceramic	Paint	Varnish	Plastic	Kitchen Scrub Pads
CX 01	AIO Very Fine Hand Pads	•	•	•	•						
CX 02	AIO Medium Hand Pads	•	•	•	•	•	•				
CX 03	SiC Ultra Fine Hand Pads	•						•	•	•	
CX 04	SiC Micro Fine Hand Pads	•						•	•	•	
CX 05	AIO Fine Hand Pads	•	•		•	•					
CX 06	AIO Fine Hand Pads	•	•		•	•					
CUMITEX SUPER	AIO Very Fine Hand Pads	•	•	•	•						
CUMITEX GP MAROON	AIO Very Fine Hand Pads	•	•	•	•						
CUMITEX GP GREEN	AIO Very Fine Hand Pads	•	•	•	•						
CUMITEX MD9650	Alo Very Fine hand scouring pads										•
CUMITEX ECO GREEN	Feldspar Very Fine hand scouring pads										•
CUMITEX HD WHITE	Non Abrasive hand pads						•	•	•	•	

Hand Pads Size		
Available Size	(mm)	inch
Width x Length	152 x 229	6 X 9

Roll Size				
Available Roll Size	mm		inch	
	Min	Max	Min	Max
Width	152	1016	6	40

GRIT	GRIT RANGE
COARSE	60 - 80
MEDIUM	100 - 120
FINE	150 - 220
VERY FINE	240 - 400
ULTRA FINE	600 - 800
MICROFINE	1000 - 1200

AIO Very Fine Hand Pads

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Maroon
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Very Fine

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal • Wood

RECOMMENDATIONS

Generating satin finish pattern on metal • Rust and oxide removal • Light de-burring

CX 01



MACHINE

FORM

SPECIALS



AIO Medium Hand Pads

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Tan
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Medium

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal • Wood • Ceramics • Wall

RECOMMENDATIONS

Generating coarse finish pattern on metal • Sanding of ceramic and sanitary wares • Light de-burring

CX 02



MACHINE

FORM

SPECIALS



SiC Ultra Fine Hand Pads

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Grey
Coating	Single Coat
Grain	Silicon Carbide
Grit	Ultra Fine

MATERIALS

Stainless Steel • Paint • Varnish • Plastic

RECOMMENDATIONS

Generating glossy finish on metals •
Architectural metal works • Auto after and
paint shop

CX 03



MACHINE

FORM



SiC Micro Fine Hand Pads

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Grey
Coating	Single Coat
Grain	Silicon Carbide
Grit	Micro Fine

MATERIALS

Stainless Steel • Paint • Varnish • Plastic

RECOMMENDATIONS

Generating glossy finish on metals •
Architectural metal works • Auto after and
paint shop

CX 04



MACHINE

FORM



AIO Fine Hand Pads

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Maroon
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Fine

MATERIALS

Steel • Stainless Steel • Wood • Wall

RECOMMENDATIONS

Aggressive cutting action • Creates coarse to satin finish on metals

AIO Fine Hand Pads

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Green
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Fine

MATERIALS

Steel • Stainless Steel • Wood • Wall

RECOMMENDATIONS

Aggressive cutting action • Creates coarse to satin finish on metals

CX 05



MACHINE



FORM



SPECIALS



CX 06



MACHINE



FORM



SPECIALS



AIO Very Fine Hand Pads

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Maroon
Coating	Single coat
Grain	Aluminium Oxide
Grit	Very Fine

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal • Wood

RECOMMENDATIONS

General purpose cleaning • Rust and oxide removal • Generating satin finish pattern

CUMITEX SUPER



MACHINE

FORM



AIO Very Fine Hand Pads

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Maroon
Coating	Single coat
Grain	Aluminium Oxide
Grit	Very Fine

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal • Wood

RECOMMENDATIONS

Excellent finish and Ra values on metal • Orbital sanders • Wood sanding

CUMITEX GP MAROON



MACHINE

FORM



AIO Very Fine Hand Pads

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Green
Coating	Single Coat
Grain	Aluminium Oxide
Grit	Very Fine

MATERIAL

Steel • Stainless Steel • Non Ferrous Metal • Wood

RECOMMENDATIONS

Excellent finish and Ra values on metal • Orbital Sanders • Wood sanding

CUMITEX GP GREEN



MACHINE



FORM



AIO Very Fine Hand Scouring Pads

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Green
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Very Fine

MATERIALS

Kitchen utensils (Ferrous & Non - Ferrous)

RECOMMENDATIONS

Hand scouring application for tough stain removal

CUMITEX MD 9650



MACHINE



FORM





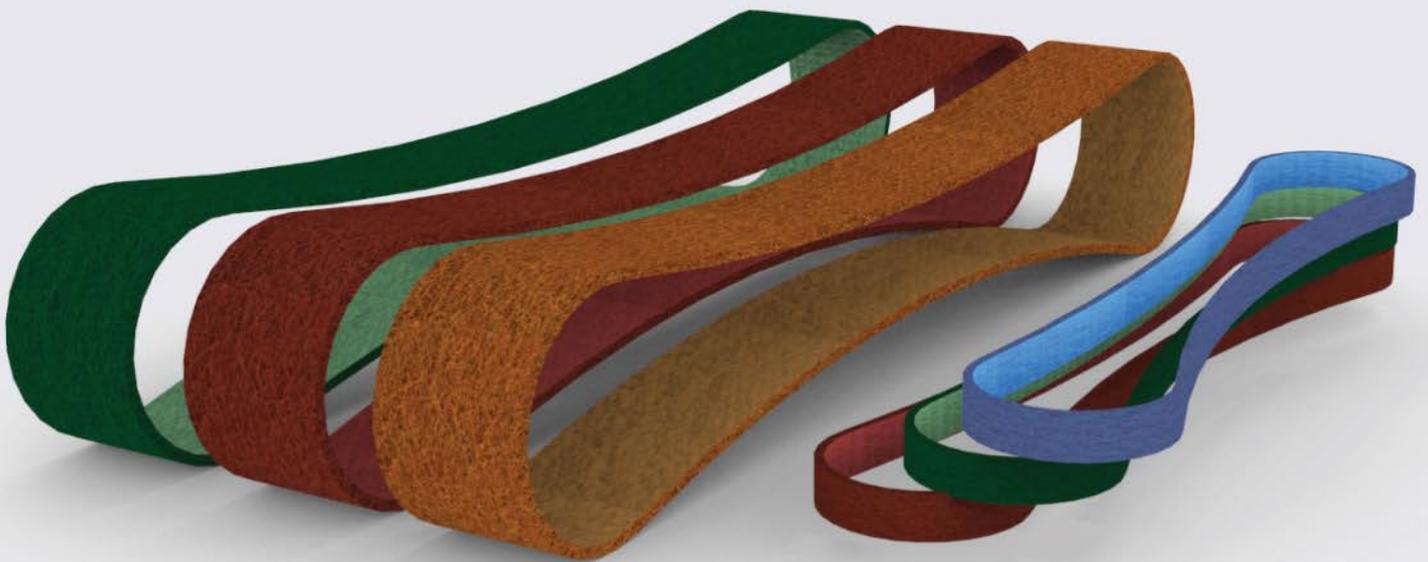
SCM BELTS



SCM BELTS

- Cumitex SCM Belts are made out of a strong non-woven structure to produce aggressive & consistent cutting action
- SCM Belts are waterproof, solvent resistant & can be used with lubricants
- They are Ideal for weld blending, light deburring & removal of surface imperfections

AVAILABLE SIZES	mm	inch
Width x Length	6 x 520	¼ x 20 ½
	19 x 520	¾ x 20 ½
	13 x 610	½ x 24
	50 x 2000	2 x 78
	100 x 2500	4 x 98
	150 x 2500	6 x 98
	100 x 3000	4 x 118
Other sizes available on request		



AIO Coarse Low Stretch SCM Belt

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Brown
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Coarse

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

RECOMMENDATIONS

For weld blending

CX LSC CRS



MACHINE



AIO Medium Low Stretch SCM Belt

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Maroon
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Medium

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

RECOMMENDATIONS

For light deburring

CX LSC MED



MACHINE



AIO Fine Low Stretch SCM Belt

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Green
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Fine

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

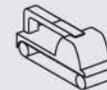
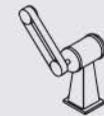
RECOMMENDATIONS

For finishing

CX LSC FIN



MACHINE



AIO Very Fine Low Stretch SCM Belt

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Blue
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Very Fine

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

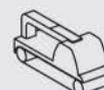
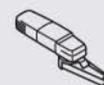
RECOMMENDATIONS

For finishing

CX LSC VFN



MACHINE



AIO Coarse SCM Belt

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Brown
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Coarse

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

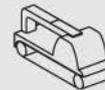
RECOMMENDATIONS

For weld blending

CX SCB CRS



MACHINE



AIO Medium SCM Belt

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Maroon
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Medium

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

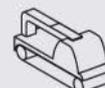
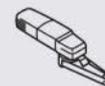
RECOMMENDATIONS

For light deburring

CX SCB MED



MACHINE



AIO Very Fine SCM Belt

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Blue
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Very Fine

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

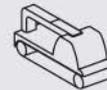
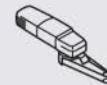
RECOMMENDATIONS

For finishing

CX SCB VFN



MACHINE



WHEELS



WHEELS

- Cumitex range of unitized, polishing & convolute wheels are an ideal choice for applications demanding surface finish
- Made by compressing layers of non woven abrasive materials, these wheels are the perfect choice for mild stock removal, deburring, blending, cleaning, finishing and polishing applications
- Cumitex range of wheels are available across various densities to suit customer needs

CUMITEX UNITIZED WHEELS 	DENSITIES	SIZES: (diameter x thickness)	
		mm	inch
	1 - AF 3 - AF 5 - AF 8 - AF	100 x 25 100 x 50 150 x 25 150 x 50 200 x 25 200 x 50	4 x 1 4 x 2 6 x 1 6 x 2 8 x 1 8 x 2

Other sizes and densities available on request

CUMITEX POLISHING WHEELS 	DENSITIES	SIZES: (diameter x thickness)	
		mm	inch
	1 - AF 3 - AF 5 - AF 8 - AF	100 x 25 100 x 50 150 x 25 150 x 50 200 x 25 200 x 50	4 x 1 4 x 2 6 x 1 6 x 2 8 x 1 8 x 2

Other sizes and densities available on request

CUMITEX CONVOLUTE WHEELS 	DENSITIES	SIZES: (diameter x thickness)	
		mm	inch
	7-SF 7-AM 8-SF 8-AM 9-SF 9-AM	150 x 25 x 25 150 x 50 x 25 200 x 13 x 75 200 x 25 x 75 200 x 50 x 75 200 x 75 x 75	6 x 1 x 1 6 x 2 x 1 8 x ½ x 3 8 x 1 x 3 8 x 2 x 3 8 x 3 x 3

Other sizes and densities available on request

AIO Unitized Wheel

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Red
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Fine

MATERIALS

Carbon Steel • Brass • Copper • Plastic

RECOMMENDATIONS

- Ideal product for Blend & Polish applications
- Removes surface defects and imparts decorative finish in single operation



MACHINE



AIO Polishing Wheel

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Grey
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Fine

MATERIALS

Carbon Steel • Stainless Steel • Brass • Copper • Aluminium

RECOMMENDATIONS

- Generates unique satin decorative finish on metals
- Right choice for kitchen, cutlery and surgical equipments polishing



MACHINE



SiC Convolute Wheel

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Grey
Coating	Multi Coat
Grain	Silicon Carbide
Grit	Fine

MATERIALS

Steel • Stainless Steel • Titanium • Plastic

RECOMMENDATIONS

• Suitable for blending and polishing hard metals & alloys like Titanium, SS and polishing of dry cell battery bottoms



MACHINE



AlO Convolute Wheel

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Grey
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Medium

MATERIALS

Steel • Stainless Steel • Titanium • Plastic

RECOMMENDATIONS

• Ideal product for heavy and light deburring of auto components and other parts



MACHINE



DISCS



CUMITEX UNITIZED DISCS

- Unitized wheels fitted with back- up pads suitable for use in angle grinders
- Perfect for blending scratch lines created by coated abrasive flap discs and fiber discs
- Ideal product for Blend and Polish applications on Brass, Copper and Carbon steel

AIO Unitized Discs

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Red
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Fine



MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

DENSITIES

1 - AF • 3 - AF • 5 - AF • 8 - AF

MACHINE



AVAILABLE SIZE	mm	inch
Diameter x Thickness x Bore	100 x 13 x 16	4 x ½ x 5/8



CUMITEX QUICK CHANGE DISCS

- Made out of a strong non woven structure to produce aggressive and consistent cutting action
- Waterproof and can be used with lubricants
- Ideal for weld blending, light deburring and removal of surface imperfections
- Color coded for easy grit identification

AVAILABLE SIZE	mm	inch
Diameter	50	2
	75	3
*Other sizes available on request		

CUMITEX range of quick change discs are available in both Type R & Type S

TYPE R

Roll on/ roll off style threaded bush

Bush made of plastic



AIO Coarse Discs

TYPE S

Turn on/ Turn off style bush

Bush made of metal



CX SCD CRS

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Brown
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Coarse



MACHINE



MATERIAL

Stainless Steel • Non Ferrous Metal

RECOMMENDATIONS

For weld blending

Alo Medium Discs

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Maroon
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Medium

MATERIALS

Stainless Steel • Non Ferrous Metal

RECOMMENDATIONS

For light deburring

CX SCD MED



MACHINE



Alo Fine Discs

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Color	Blue
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Fine

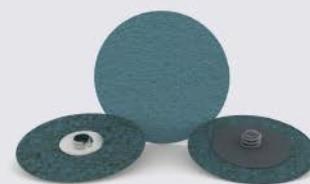
MATERIALS

Stainless Steel • Non Ferrous Metal

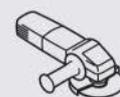
RECOMMENDATIONS

For finishing

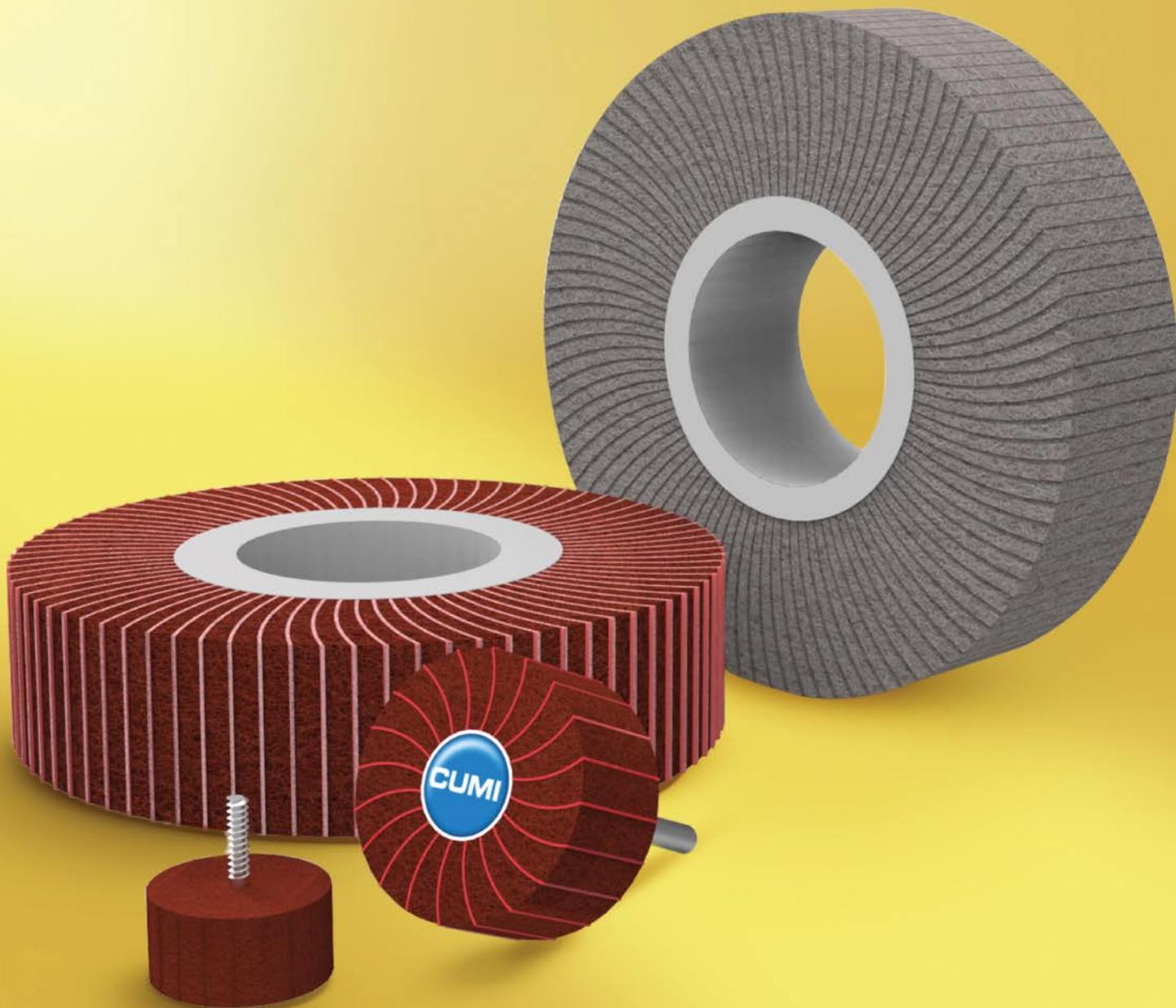
CX SCD FIN



MACHINE



FLAP WHEELS



FLAP WHEELS

•CUMITEX range of flap wheels are made by radially bonding non-woven abrasive layers over a central core. In case of combi wheels alternative layers of non woven & coated are used.

•CUMITEX flap wheels are suitable for light finishing, polishing, imparting brush, smoky and satin finish on metals.

CUMITEX SHAFT MOUNTED FLAP WHEELS	GRITS	SIZES: (diameter x thickness x spindle)	
		mm	inch
	Combi		
	1.AIO Very Fine + Grit 120 AIO coated	50 x 25 x 6	2 x 1 x ¼
	2.AIO Medium + Grit 60 AIO coated	50 x 50 x 6	2 x 2 x ¼
	Nonwoven		
1. AIO Very Fine	75 x 50 x 6	3 x 2 x ¼	
2. AIO Medium	100 x 50 x 6	4 x 2 x ¼	

* Other sizes available on request

CUMITEX FLAP WHEELS	GRITS	SIZES: (diameter x thickness x inner dia)	
		mm	inch
	Combi		
	1.AIO Very Fine + Grit 120 AIO coated	150 x 25 x 50	6 x 1 x 2
	Nonwoven		
	1.AIO Medium	150 x 50 x 50	6 x 2 x 2
2.AIO Very Fine	200 x 25 x 75	8 x 1 x 3	
3.SiC Ultra Fine	200 x 50 x 75	8 x 2 x 3	

* Other sizes available on request



AIO Medium Combi Shaft Mounted Flap Wheel

CX02 / XG 542

PROPERTIES

Backing	Nylon Fiber / Cotton - X weight backing
Bond Type	Resin
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Medium / G80



MACHINE



MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

AIO Very Fine Combi Shaft Mounted Flap

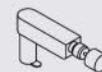
CX01 / XG 542

PROPERTIES

Backing	Nylon Fiber / Cotton - X weight backing
Bond Type	Resin
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Very Fine / G120



MACHINE



MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

AIO Very Fine Shaft Mounted Flap Wheel

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Very Fine

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

CX01



MACHINE



AIO Medium Shaft Mounted Flap Wheel

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Medium

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

CX02



MACHINE



AIO Very Fine Combi Flap Wheel

CX01 / XG542

PROPERTIES

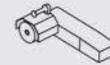
Backing	Nylon Fiber / Cotton - X weight backing
Bond Type	Resin
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Fine



MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

MACHINE



AIO Medium Flap Wheel

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Medium

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

CX 02



MACHINE



AIO Very Fine Flap Wheel

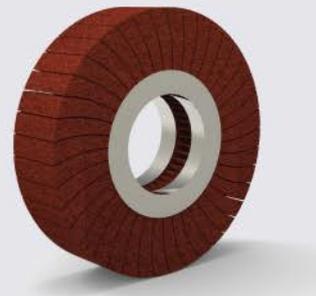
PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Coating	Multi Coat
Grain	Aluminium Oxide
Grit	Very Fine

MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

CX01



MACHINE



SiC Ultra Fine Flap Wheel

PROPERTIES

Backing	Nylon Fiber
Bond Type	Synthetic water proof resin bond
Coating	Multi Coat
Grain	Silicon Carbide
Grit	Ultra Fine

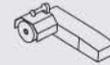
MATERIALS

Steel • Stainless Steel • Non Ferrous Metal

CX04



MACHINE



BEARING INDUSTRY

CUTTING AND GRINDING WHEELS



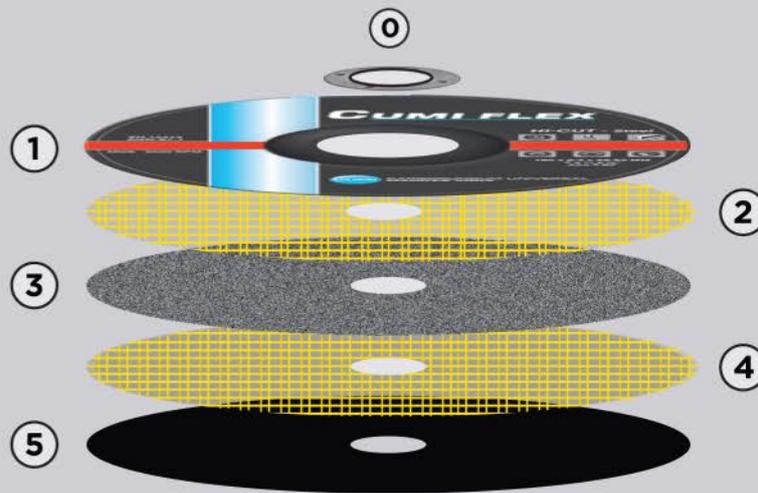
CARBORUNDUM UNIVERSAL LIMITED

CUTTING & GRINDING WHEELS

About Cutting & Grinding Wheels:

Cutting & grinding wheels comprises of abrasive grains held together by resin bonds and are reinforced by glass fibers. Ranging from 1mm to 9mm thickness, they are extensively used in various industries like construction, fabrication, foundries shipyards, aerospace and automotive.

COMPONENTS OF GRINDING WHEELS



METAL
BUSH

LABEL

GLASS FIBER
REINFORCEMENT

MIXTURE OF
ABRASIVE GRAINS,
RESINS & FILLERS

GLASS FIBER
REINFORCEMENT

BLACK
PAPER

0

1

2

3

4

5



ABOUT CUMIFLEX

CUMIFLEX cutting & grinding wheels are produced in the state of the art manufacturing facility, with stringent process controls and final product quality checks. By this, not only the best grinding performances are achieved, but also the highest level of product safety is maintained in accordance with EN 12413 and ANSI B7.1 standards.

The uniqueness of the product design allows for the most optimum grinding performance - good cutting action and excellent tool life, consistently throughout the product life. The core strength of CUMI has been the ability to customize products for specific application needs. While this application guide is just a starting point, our engineers are always there to help out with any specific applications or queries.

SPEED CONVERSION

Wheel Diameter	Maximum peripheral operating speed in m/s		
(mm)	63	80	100
100	12100	15300	19100
115	10500	13300	16650
125	9650	12250	15300
150	8050	10200	12700
180	6700	8500	10650
200	6050	7650	9550
230	5250	6650	8350
300/305	4050	5100	6400
350/356	3450	4400	5500
400/406	3050	3850	4800



PRODUCT LABEL EXPLANATION



PRODUCT CODE EXPLANATION

27	HCT	100	63	T
WHEEL TYPE	APPLICATION CATEGORY	WHEEL DIAMETER	WHEEL THICKNESS	GRADE HARDNESS
TYPE27	HCT Hicut - Steel	100 = 100 mm	63 = 6.3 mm	R Soft
TYPE41	ZRC Zirconia			T Medium
TYPE42	INO SS Inox			U Hard
	HCB Hicarb - Stone			
	ALU Aluminium			
	CHA Chop Saw Steel			
	CHC Chop Saw Stone			

PICTOGRAMS



CUMIFLEX RANGE

Cumiflex cutting & grinding wheels are available in three different variants classified based on performance and life



CUMIFLEX GOLD

Premium products for high performance and longer life with lower operating costs satisfying customer demands



CUMIFLEX PERFORMANCE

Product range optimised for an excellent combination of life and performance for various applications



CUMIFLEX UNIVERSAL

Universal products designed for price - performance ratio offering good performance levels

COLOR CODE RELATIONSHIP



 CERAMIC

 STEEL

 ZIRCONIA

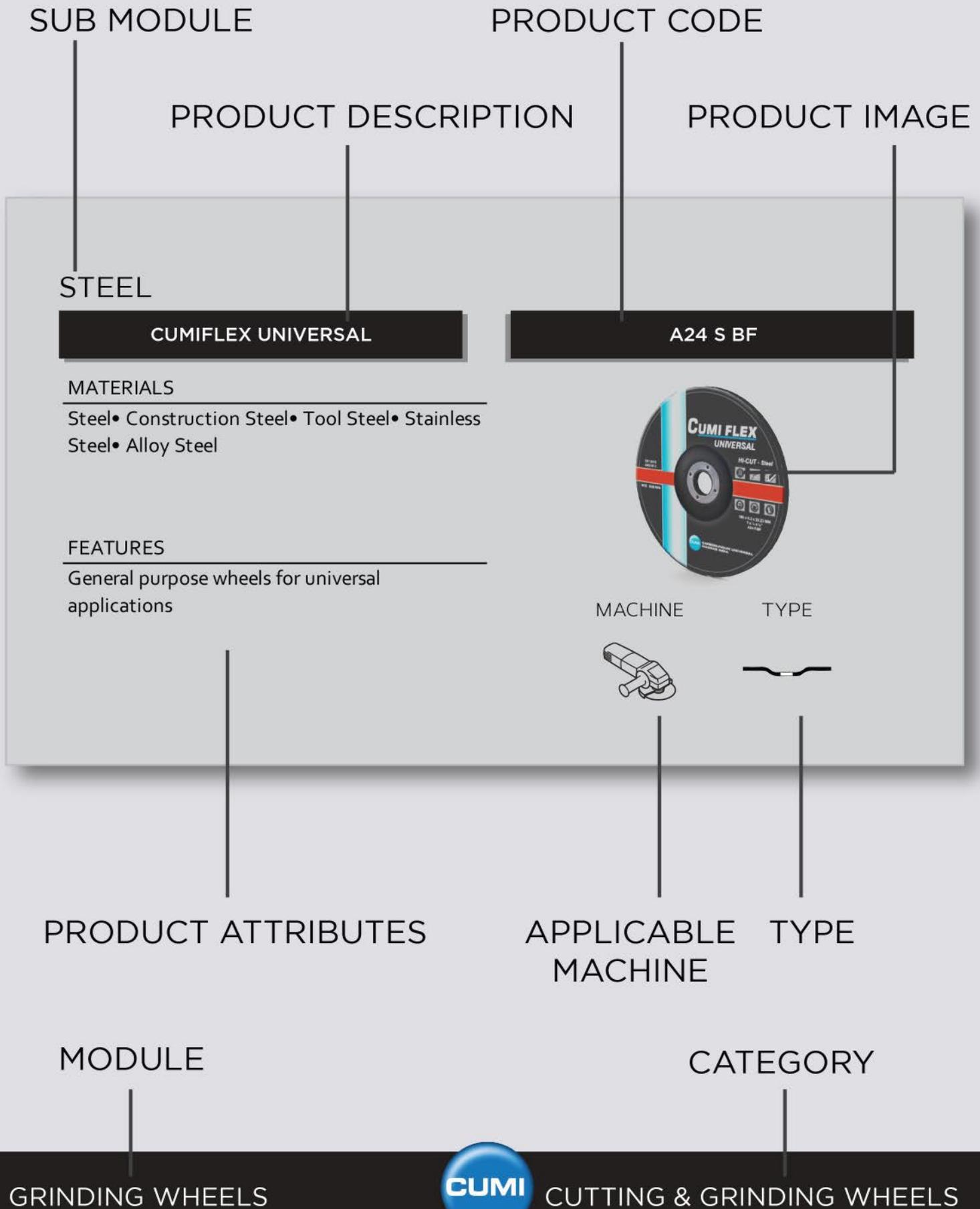


 SS- INOX

 STONE

 ALUMINIUM

HOW TO READ THE BROCHURE



GRINDING WHEELS

CUTTING & GRINDING WHEELS

GRINDING WHEELS



STEEL

High performance wheels suited for weld and edge grinding

CUMIFLEX GOLD

MATERIALS

Steel • Construction Steel • Tool Steel
• Stainless Steel • Alloy Steel

FEATURES

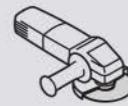
High Performance abrasive grains with specially designed bond for best in class performance

SA24 T BF



MACHINE

TYPE



CUMIFLEX PERFORMANCE

MATERIALS

Steel • Construction Steel • Tool Steel •
Stainless Steel • Alloy Steel

FEATURES

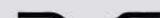
Premium blend of abrasive grains for optimum life and grinding action

A24 T BF



MACHINE

TYPE



STEEL

CUMIFLEX UNIVERSAL

MATERIALS

- Steel • Construction Steel • Tool Steel
 • Stainless Steel • Alloy Steel

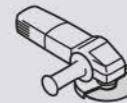
FEATURES

General purpose wheels for universal applications

A24 S BF



MACHINE



TYPE



TYPE	DIMENSIONS (D x T x B)		CUMI CODE			SPEED rpm	PACK qty
	mm	inch	GOLD	PERFORMANCE	UNIVERSAL		
	100 x 4 x 16	4 x 5/32 x 5/8	27HCT10040U	27HCT10040T	27HCT10040S	15300	100
	100 x 6.3 x 16	4 x 1/4 x 5/8	27HCT10063U	27HCT10063T	27HCT10063S	15300	100
	115 x 4 x 22.23	4-1/2 x 5/32 x 7/8	27HCT11540U	27HCT11540T	27HCT11540S	13300	100
	115 x 6.3 x 22.23	4-1/2 x 1/4 x 7/8	27HCT11563U	27HCT11563T	27HCT11563S	13300	100
	125 x 6.3 x 22.23	5 x 1/4 x 7/8	27HCT12563U	27HCT12563T	27HCT12563S	12250	100
	150 x 6.3 x 22.23	6 x 1/4 x 7/8	27HCT15063U	27HCT15063T	27HCT15063S	10200	100
	180 x 4 x 22.23	7 x 5/32 x 7/8	27HCT18040U	27HCT18040T	27HCT18040S	8500	25
	180 x 6.3 x 22.23	7 x 1/4 x 7/8	27HCT18063U	27HCT18063T	27HCT18063S	8500	25
	230 x 6.3 x 22.23	9 x 1/4 x 7/8	27HCT23063U	27HCT23063T	27HCT23063S	6650	25

5/8-11" mounting hub available on request

STEEL

CUMIFLEX UNIVERSAL PLUS

MATERIALS

- Steel • Construction Steel • Tool Steel
• Stainless Steel • Alloy Steel

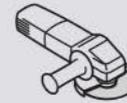
FEATURES

Grooved pattern for high metal removal rate and smoother cutting with less load on operator

A24 S BF



MACHINE



TYPE



TYPE	DIMENSIONS (D x T x B)		CUMI CODE	SPEED	PACK
	mm	inch			
	100 x 4 x 16	4 x 5/32 x 5/8	27HCT10040SP	15300	100
	100 x 6.3 x 16	4 x 1/4 x 5/8	27HCT10063SP	15300	100
	115 x 4 x 22.23	4-1/2 x 5/32 x 7/8	27HCT11540SP	13300	100
	115 x 6.3 x 22.23	4-1/2 x 1/4 x 7/8	27HCT11563SP	13300	100
	125 x 6.3 x 22.23	5 x 1/4 x 7/8	27HCT12563SP	12250	100
	150 x 6.3 x 22.23	6 x 1/4 x 7/8	27HCT15063SP	10200	100
	180 x 4 x 22.23	7 x 5/32 x 7/8	27HCT18040SP	8500	25
	180 x 6.3 x 22.23	7 x 1/4 x 7/8	27HCT18063SP	8500	25
	230 x 6.3 x 22.23	9 x 1/4 x 7/8	27HCT23063SP	6650	25

5/8-11" mounting hub available on request



ZIRCONIA

Premium grinding wheels for Stainless Steel with excellent cutting action and long wheel life.

CUMIFLEX PERFORMANCE

MATERIALS

Steel • Construction Steel • Tool Steel
• Stainless Steel • Alloy Steel

FEATURES

Premium zirconia grains for superior grinding experience

ZA24 T BF



MACHINE

TYPE



CUMIFLEX UNIVERSAL

MATERIALS

Steel • Construction Steel • Tool Steel
• Stainless Steel • Alloy Steel

FEATURES

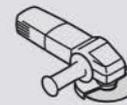
Zirconia grain combination for faster and aggressive grinding

AZA24 T BF



MACHINE

TYPE



TYPE	DIMENSIONS (D x T x B)		CUMI CODE		SPEED	PACK
	mm	inch	PERFORMANCE	UNIVERSAL	rpm	qty
	100 x 6.3 x 16	4 x 1/4 x 5/8	27ZIR10063T	27ZIR10063S	15300	100
	115 x 6.3 x 22.23	4-1/2 x 1/4 x 7/8	27ZIR11563T	27ZIR11563S	13330	100
	125 x 6.3 x 22.23	5 x 1/4 x 7/8	27ZIR12563T	27ZIR12563S	12250	100
	150 x 6.3 x 22.23	6 x 1/4 x 7/8	27ZIR15063T	27ZIR15063S	10200	100
	180 x 6.3 x 22.23	7 x 1/4 x 7/8	27ZIR18063T	27ZIR18063S	8500	25
	230 x 6.3 x 22.23	9 x 1/4 x 7/8	27ZIR23063T	27ZIR23063S	6650	25

5/8-11" mounting hub available on request

SS - INOX

Special wheel for use in nuclear power plants, free from Iron, Chlorine and Sulphur.

CUMIFLEX GOLD

MATERIALS

Nuclear Industry • Stainless Steel • Alloy Steel

FEATURES

- Premium blend of abrasive grains for burr-free grinding
- Fe, S, Cl < 0.1%

DA24 T BF



MACHINE

TYPE



CUMIFLEX PERFORMANCE

MATERIALS

Nuclear Industry • Stainless Steel • Alloy Steel

FEATURES

- Optimised grain - bond system for easy grinding action
- Fe, S, Cl < 0.1%

DA24 S BF



MACHINE

TYPE



TYPE	DIMENSIONS (D x T x B)		CUMI CODE		SPEED rpm	PACK qty
	mm	inch	GOLD	PERFORMANCE		
	100 x 4 x 16	4 x 5/32 x 5/8	27INO10040U	27INO10040T	15300	100
	100 x 6.3 x 16	4 x 1/4 x 5/8	27INO10063U	27INO10063T	15300	100
	115 x 4 x 22.23	4-1/2 x 5/32 x 7/8	27INO11540U	27INO11540T	13330	100
	115 x 6.3 x 22.23	4-1/2 x 1/4 x 7/8	27INO11563U	27INO11563T	13330	100
	125 x 6.3 x 22.23	5 x 1/4 x 7/8	27INO12563U	27INO12563T	12250	100
	180 x 4 x 22.23	7 x 5/32 x 7/8	27INO18040U	27INO18040T	8500	25
	180 x 6.3 x 22.23	7 x 1/4 x 7/8	27INO18063U	27INO18063T	8500	25
	230 x 6.3 x 22.23	9 x 1/4 x 7/8	27INO23063U	27INO23063T	6650	25

5/8-11" mounting hub available on request

ALUMINIUM

Standard wheel for working on Aluminium and other non-ferrous metals.

CUMIFLEX PERFORMANCE

A24 P BF

MATERIALS

Aluminium • Copper • Brass • Bronze

FEATURES

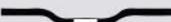
Superior grain - bond combination that prevents glazing & loading problems



MACHINE

TYPE



TYPE	DIMENSIONS (D x T x B)		CUMI CODE	SPEED	PACK
	mm	inch	PERFORMANCE	rpm	qty
	100 x 6.3 x 16	4 x 1/4 x 5/8	27ALU10063T	15300	100
	115 x 6.3 x 22.23	4-1/2 x 1/4 x 7/8	27ALU11563T	13330	100
	125 x 6.3 x 22.23	5 x 1/4 x 7/8	27ALU12563T	12250	100
	150 x 6.3 x 22.23	6 x 1/4 x 7/8	27ALU15063T	10200	100
	180 x 6.3 x 22.23	7 x 1/4 x 7/8	27ALU18063T	8500	25
	230 x 6.3 x 22.23	9 x 1/4 x 7/8	27ALU23063T	6650	25

5/8-11" mounting hub available on request



CUTTING WHEELS



STEEL

Cutting wheels suitable for all metal cutting applications.

CUMIFLEX GOLD

MATERIALS

Steel • Construction Steel • Tool Steel
• Stainless Steel • Alloy Steel

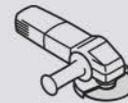
FEATURES

High Performance abrasive grains with specially designed bond for best in class performance

SA30 T BF



MACHINE



TYPE



CUMIFLEX PERFORMANCE

MATERIALS

Steel • Construction Steel • Tool Steel
• Stainless Steel • Alloy Steel

FEATURES

Premium blend of abrasive grains for optimum life and cutting action

A30 T BF



MACHINE



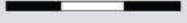
TYPE



STEEL

TYPE	DIMENSIONS (D x T x B)		CUMI CODE		SPEED	PACK SIZE
	mm	inch	GOLD	PERFORMANCE	rpm	qty
	100 x 3.2 x 16	4 x 1/8 x 5/8	42HCT10032U	42HCT10032T	15300	100
	115 x 3.2 x 22.23	4-1/2 x 1/8 x 7/8	42HCT11532U	42HCT11532T	13300	100
	125 x 3.2 x 22.23	5 x 1/8 x 7/8	42HCT12532U	42HCT12532T	12250	100
	180 x 3.2 x 22.23	7 x 1/8 x 7/8	42HCT18032U	42HCT18032T	8500	50
	230 x 3.2 x 22.23	9 x 1/8 x 7/8	42HCT23032U	42HCT23032T	6650	50

5/8-11" safety hub available on request

TYPE	DIMENSIONS (D x T x B)		CUMI CODE		SPEED	PACK SIZE
	mm	inch	GOLD	PERFORMANCE	rpm	qty
	100 x 2.5 x 16	4 x 3/32 x 5/8	41HCT10025U	41HCT10025T	15300	100
	100 x 3.2 x 16	4 x 1/8 x 5/8	41HCT10032U	41HCT10032T	15300	100
	115 x 2.5 x 22.23	4-1/2 x 3/32 x 7/8	41HCT11525U	41HCT11525T	13300	100
	115 x 3.2 x 22.23	4-1/2 x 1/8 x 7/8	41HCT11532U	41HCT11532T	13300	100
	125 x 2.5 x 22.23	5 x 3/32 x 7/8	41HCT12525U	41HCT12525T	12250	100
	125 x 3.2 x 22.23	5 x 1/8 x 7/8	41HCT12532U	41HCT12532T	12250	100
	180 x 2.5 x 22.23	7 x 3/32 x 7/8	41HCT18025U	41HCT18025T	8500	50
	180 x 3.2 x 22.23	7 x 1/8 x 7/8	41HCT18032U	41HCT18032T	8500	50
	230 x 2.5 x 22.23	9 x 3/32 x 7/8	41HCT23025U	41HCT23025T	8500	50
	230 x 3.2 x 22.23	9 x 1/8 x 7/8	41HCT23032U	41HCT23032T	8500	50

5/8-11" mounting hub available on request



ZIRCONIA

Premium cutting wheel for Stainless Steel and other metals with excellent cutting action and longer wheel life.

CUMIFLEX GOLD

MATERIALS

Steel • Construction Steel • Tool Steel
• Stainless Steel • Alloy Steel

FEATURES

Premium zirconia grains for superior cutting experience



MACHINE



TYPE



CUMIFLEX PERFORMANCE

MATERIALS

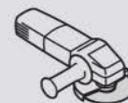
Steel • Construction Steel • Tool Steel
• Stainless Steel • Alloy Steel

FEATURES

Zirconia grain combination for faster and aggressive cutting



MACHINE



TYPE



ZIRCONIA

TYPE	DIMENSIONS (D x T x B)		CUMI CODE		SPEED	PACK SIZE
	mm	inch	GOLD	PERFORMANCE	rpm	qty
	100 x 3.2 x 16	4 x 1/8 x 5/8	42ZRC10032U	42ZRC10032T	15300	100
	115 x 3.2 x 22.23	4-1/2 x 1/8 x 7/8	42ZRC11532U	42ZRC11532T	13300	100
	125 x 3.2 x 22.23	5 x 1/8 x 7/8	42ZRC12532U	42ZRC12532T	12250	100
	180 x 3.2 x 22.23	7 x 1/8 x 7/8	42ZRC18032U	42ZRC18032T	8500	50
	230 x 3.2 x 22.23	9 x 1/8 x 7/8	42ZRC23032U	42ZRC23032T	6650	50

5/8-11" mounting hub available on request

TYPE	DIMENSIONS (D x T x B)		CUMI CODE		SPEED	PACK SIZE
	mm	inch	GOLD	PERFORMANCE	rpm	qty
	100 x 3.2 x 16	4 x 1/8 x 5/8	41ZRC10032U	41ZRC10032T	15300	100
	115 x 3.2 x 22.23	4-1/2 x 1/8 x 7/8	41ZRC11532U	41ZRC11532T	13300	100
	125 x 3.2 x 22.23	5 x 1/8 x 7/8	41ZRC12532U	41ZRC12532T	12250	100
	180 x 3.2 x 22.23	7 x 1/8 x 7/8	41ZRC18032U	41ZRC18032T	8500	50
	230 x 3.2 x 22.23	9 x 1/8 x 7/8	41ZRC23032U	41ZRC23032T	6650	50

5/8-11" mounting hub available on request



SS - INOX

Special cutting wheel for use in nuclear power plants, free from Iron, Chlorine and Sulphur.

CUMIFLEX GOLD

DA30 S BF

MATERIALS

Stainless Steel • Alloy Steel • Nuclear Industry

FEATURES

- Premium blend of abrasive grains for burr-free cutting
- Fe, S, Cl < 0.1%



MACHINE

TYPE



TYPE	DIMENSIONS (D x T x B)		CUMI CODE	SPEED	PACK SIZE
	mm	inch			
	100 x 2.5 x 16	4 x 3/32 x 5/8	42INO10025T	15300	100
	100 x 3.2 x 16	4 x 1/8 x 5/8	42INO10032T	15300	100
	115 x 2.5 x 22.23	4-1/2 x 3/32 x 7/8	41INO11525T	13300	100
	115 x 3.2 x 22.23	4-1/2 x 1/8 x 7/8	41INO11532T	13300	100
	125 x 2.5 x 22.23	5 x 3/32 x 7/8	42INO12525T	12250	100
	125 x 3.2 x 22.23	5 x 1/8 x 7/8	42INO12532T	12250	100
	180 x 2.5 x 22.23	7 x 3/32 x 7/8	42INO12532T	8500	50
	180 x 3.2 x 22.23	7 x 1/8 x 7/8	42INO12532T	8500	50
	230 x 2.5 x 22.23	9 x 3/32 x 7/8	42INO12532T	6650	50
	230 x 3.2 x 22.23	9 x 1/8 x 7/8	42INO12532T	6650	50

TYPE	DIMENSIONS (D x T x B)		CUMI CODE	SPEED	PACK SIZE
	mm	inch			
	100 x 2.5 x 16	4 x 3/32 x 5/8	41INO10025T	15300	100
	100 x 3.2 x 16	4 x 1/8 x 5/8	41INO10032T	15300	100
	115 x 2.5 x 22.23	4-1/2 x 3/32 x 7/8	41INO11525T	13300	100
	115 x 3.2 x 22.23	4-1/2 x 1/8 x 7/8	41INO11532T	13300	100
	125 x 2.5 x 22.23	5 x 3/32 x 7/8	41INO12525T	12250	100
	125 x 3.2 x 22.23	5 x 1/8 x 7/8	41INO12532T	12250	100
	180 x 2.5 x 22.23	7 x 3/32 x 7/8	41INO12532T	8500	50
	180 x 3.2 x 22.23	7 x 1/8 x 7/8	41INO12532T	8500	50
	230 x 2.5 x 22.23	9 x 3/32 x 7/8	41INO12532T	6650	50
	230 x 3.2 x 22.23	9 x 1/8 x 7/8	41INO12532T	6650	50

5/8-11" mounting hub available on request

ALUMINIUM

Quick cutting wheel for Aluminium, non-ferrous and sticky metals.

CUMIFLEX PERFORMANCE

A30 Q BF

MATERIALS

Aluminium • Copper • Brass • Bronze

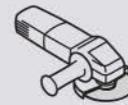
FEATURES

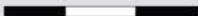
Superior grain - bond combination that prevents glazing & loading problems



MACHINE

TYPE



TYPE	DIMENSIONS (D x T x B)		CUMI CODE	SPEED	PACK SIZE
	mm	inch	PERFORMANCE	rpm	qty
	100X 3.2 X 16	4 x 1/8 x 5/8	41ALU10032T	15300	100
	115X3.2X22.23	4-1/2 x 1/8 x 7/8	41ALU11532T	13300	100
	123X3.2X22.23	5 x 1/8 x 7/8	41ALU12532T	12250	100
	180 x 3.2 x 22.23	7 x 1/8 x 7/8	41ALU18032T	8500	50
	230 x 3.2 x 22.23	9 x 1/8 x 7/8	41ALU23032T	6650	50

5/8-11" mounting hub available on request

THIN CUTTING WHEELS



SS - INOX

Special cutting wheel for use in nuclear power plants, free from Iron, Chlorine and Sulphur.

CUMIFLEX GOLD

MATERIALS

Nuclear Industry • Stainless Steel • Alloy Steel

FEATURES

- Superior grain - bond system for best in class results
- Fe, S, Cl < 0.1%

SA46 S BF / SA60 S BF



MACHINE



TYPE



CUMIFLEX PERFORMANCE

MATERIALS

Nuclear Industry • Stainless Steel • Alloy Steel

FEATURES

- Premium blend of abrasive grains for burr-free cutting
- Fe, S, Cl < 0.1%

DA46 S BF / DA60 S BF



MACHINE



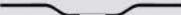
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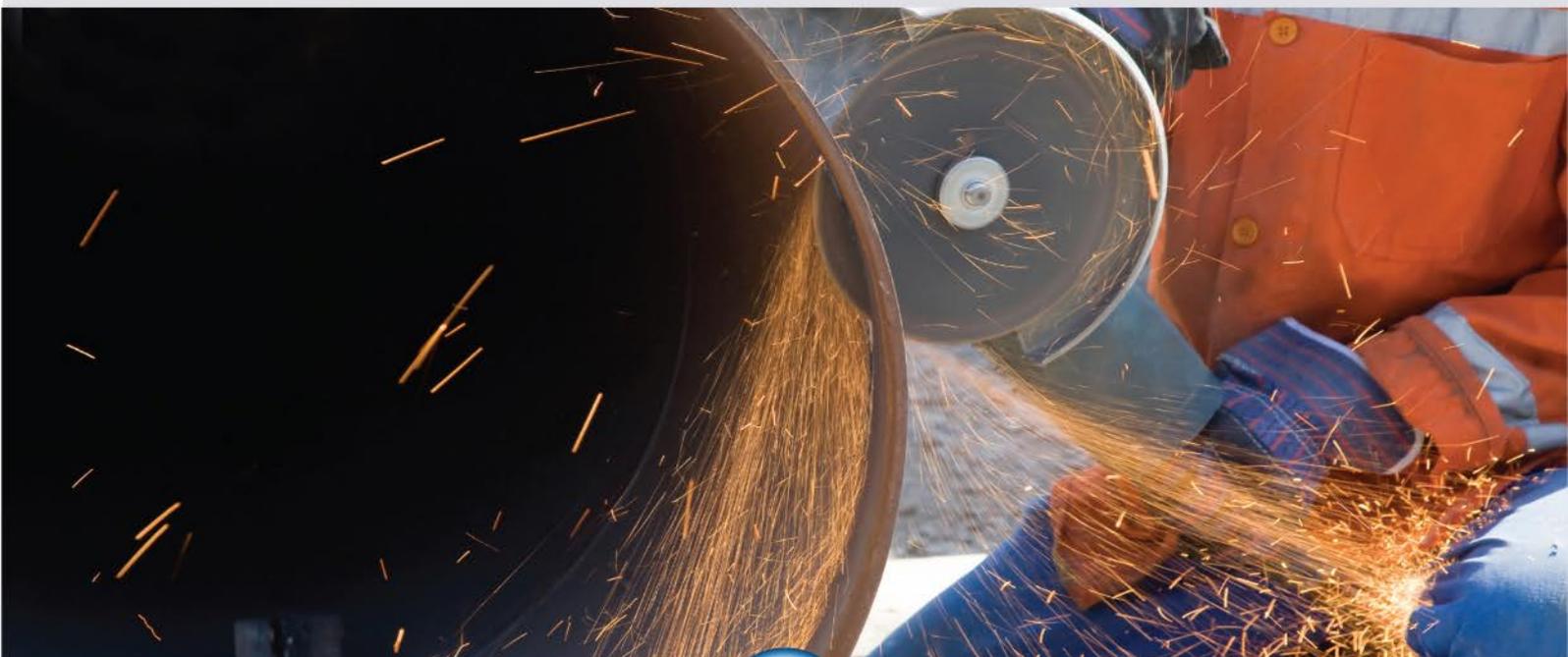
SS - INOX

TYPE	DIMENSIONS (D x T x B)		CUMI CODE		SPEED	PACK SIZE
	mm	inch	GOLD	PERFORMANCE	rpm	qty
	100 x 1 x 16	4 x 0.04 x 5/8	41INO10010U	41INO10010T	15300	100
	100 x 1.2 x 16	4 x 3/64 x 5/8	41INO10012U	41INO10012T	15300	100
	100 x 1.6 x 16	4 x 1/16 x 5/8	41INO10016U	41INO10016T	15300	100
	100 x 2 x 16	4 x 5/64 x 5/8	41INO10020U	41INO10020T	15300	100
	115 x 1 x 22.23	4-1/2 x 0.04 x 7/8	41INO11510U	41INO11510T	13300	100
	115 x 1.2 x 22.23	4-1/2 x 3/64 x 7/8	41INO11512U	41INO11512T	13300	100
	115 x 1.6 x 22.23	4-1/2 x 1/16 x 7/8	41INO11516U	41INO11516T	13300	100
	115 x 2 x 22.23	4-1/2 x 5/64 x 7/8	41INO11520U	41INO11520T	13300	100
	125 x 1 x 22.23	5 x 0.04 x 7/8	41INO12510U	41INO12510T	12250	100
	125 x 1.2 x 22.23	5 x 3/64 x 7/8	41INO12512U	41INO12512T	12250	100
	125 x 1.6 x 22.23	5 x 1/16 x 7/8	41INO12516U	41INO12516T	12250	100
	125 x 2 x 22.23	5 x 5/64 x 7/8	41INO12520U	41INO12520T	12250	100
	180x1.6x22.23	7 x 1/16 x 7/8	41INO18016U	41INO18016T	8500	100
	180x1.9x22.23	7 x 5/64 x 7/8	41INO18019U	41INO18019T	6650	100
	230x1.9x22.23	9 x 5/64 x 7/8	41INO23019U	41INO23019T	6650	100

5/8-11" mounting hub available on request

TYPE	DIMENSIONS (D x T x B)		CUMI CODE		SPEED	PACK SIZE
	mm	inch	GOLD	PERFORMANCE	rpm	qty
	115 x 1.6 x 22.23	4-1/2 x 1/16 x 7/8	42INO11516U	42INO11516T	13300	100
	115 x 2 x 22.23	4-1/2 x 5/64 x 7/8	42INO11520U	42INO11520T	13300	100
	125 x 1.6 x 22.23	5 x 1/16 x 7/8	42INO12516U	42INO12516T	12250	100
	125 x 2 x 22.23	5 x 5/64 x 7/8	42INO12520U	42INO12520T	12250	100
	180 x 1.6 x 22.23	7 x 1/16 x 7/8	42INO18016U	42INO18016T	8500	100
	180 x 1.9 x 22.23	7 x 5/64 x 7/8	42INO18019U	42INO18019T	6650	100
	230 x 1.9 x 22.23	9 x 5/64 x 7/8	42INO23019U	42INO23019T	6650	100

5/8-11" mounting hub available on request



CERAMIC

Thin cutting wheels with premium Ceramic Aluminium Oxide grains fractures under pressure thereby giving high cut rate.

CUMIFLEX GOLD

SG46 S BF / SG60 S BF

MATERIALS

Stainless Steel • Nuclear Industry

FEATURES

Micro crystalline fracture of ceramic grains yield quick cutting action with longer life



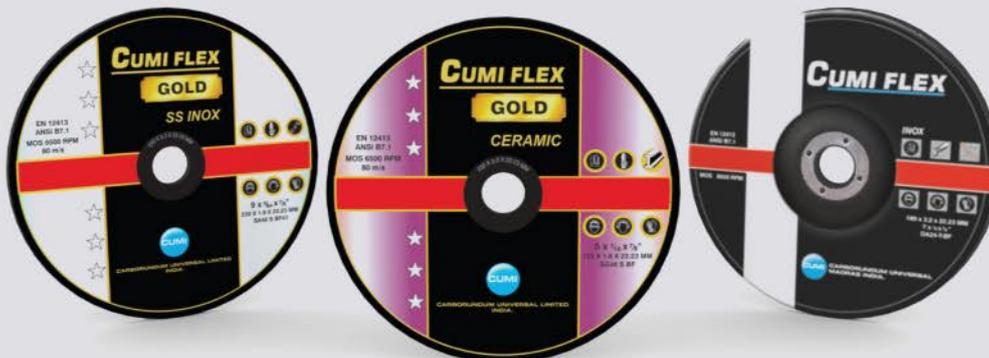
MACHINE

TYPE



TYPE	DIMENSIONS (D x T x B)		CUMI CODE	SPEED	PACK SIZE
	mm	inch			
	100 x 1 x 16	4 x 0.04 x 5/8	41CER10010U	15300	100
	100 x 1.2 x 16	4 x 3/64 x 5/8	41CER10012U	15300	100
	100 x 1.6 x 16	4 x 1/16 x 5/8	41CER10016U	15300	100
	115 x 1 x 22.23	4-1/2 x 3/64 x 7/8	41CER11510U	13300	100
	115 x 1.2 x 22.23	4-1/2 x 3/64 x 7/8	41CER11512U	13300	100
	115 x 1.6 x 22.23	4-1/2 x 1/16 x 7/8	41CER11516U	13300	100
	125 x 1 x 22.23	5 x 3/64 x 7/8	41CER12510U	12250	100
	125 x 1.2 x 22.23	5 x 3/64 x 7/8	41CER12512U	12250	100
	125 x 1.6 x 22.23	5 x 1/16 x 7/8	41CER12516U	12250	100

5/8-11" mounting hub available on request



LARGE DIA CUTTING WHEELS



STEEL / STAINLESS STEEL (Centre reinforced cutting wheel)

Centre reinforced cutting wheels suitable for fast cutting of metal on chop saw machines.

CUMIFLEX PERFORMANCE

A30 S BF41

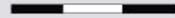
MATERIALS

- Steel
- Construction Steel
- Tool Steel
- Stainless Steel
- Alloy Steel



MACHINE

TYPE



CRITERIA	TYPE	DIMENSIONS (D x T x B)		CUMI CODE	SPEED	PACK SIZE
		mm	inch			
Centre reinforced		300 x 3.2 x 25.4	12 x 1/8 x 1	41CHA30032R	5100 rpm	25 qty
		350 x 3.2 x 25.4	14 x 1/8 x 1	41CHA35032R	4400 rpm	25 qty
		400 x 3.2 x 25.4	16 x 1/8 x 1	41CHA40032R	3850 rpm	25 qty



STEEL / STAINLESS STEEL (Double Side reinforced cutting wheel)

Double side reinforced cutting wheels suitable for metal cutting on stationary saw machines

CUMIFLEX PERFORMANCE

A30 T BF41

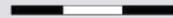
MATERIALS

- Steel
- Construction Steel
- Tool Steel
- Stainless Steel
- Alloy Steel



MACHINE

TYPE



CRITERIA	TYPE	DIMENSIONS (D x T x B)		CUMI CODE	SPEED	PACK SIZE
		mm	inch			
Double Side Reinforced		300 x 3.2 x 25.4	12 x 1/8 x 1	41HCT30032S	5100	25
		350 x 3.2 x 25.4	14 x 1/8 x 1	41HCT35032S	4400	25
		400 x 3.2 x 25.4	16 x 1/8 x 1	41HCT40032S	3850	25

STEEL / STAINLESS STEEL (For Petrol saw Machine)

CUMIFLEX PERFORMANCE

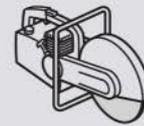
A30 S BF41

MATERIALS

- Steel
- Construction Steel
- Tool Steel
- Stainless Steel
- Alloy Steel



MACHINE



TYPE



CRITERIA	TYPE	DIMENSIONS (D x T x B)		CUMI CODE	SPEED	PACK SIZE
		mm	inch	PERFORMANCE	rpm	qty
Petrol saws		300 x 3.2 x 20	12 x 1/8 x 20 mm	41HPS30032S	5100	25
		350 x 3.2 x 20	14 x 1/8 x 20 mm	41HPS35032S	4400	25
		400 x 3.2 x 20	16 x 1/8 x 20 mm	41HPS40032S	3850	25

* Also available in 25.4 mm (1") bore

** Also available in 100 m/sec



ZIRCONIA (Double Side reinforced cutting wheel)

Double side reinforced cutting wheels suitable for metal cutting on stationary saw machines

CUMIFLEX PERFORMANCE

ZA30 T BF41

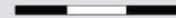
MATERIALS

- Steel
- Construction Steel
- Tool Steel
- Stainless Steel
- Alloy Steel
- Grey Cast iron
- SG Cast Iron



MACHINE

TYPE



CRITERIA	TYPE	DIMENSIONS (D x T x B)		CUMI CODE	SPEED	PACK SIZE
		mm	inch			
Double Side Reinforced		300 x 3.2 x 25.4	12 x 1/8 x 1	41ZRC30032S	5100	25
		350 x 3.2 x 25.4	14 x 1/8 x 1	41ZRC35032S	4400	25
		400 x 3.2 x 25.4	16 x 1/8 x 1	41ZRC40032S	3850	25