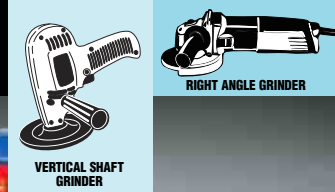


# FLAP DISCS



Our flap discs are engineered for light stock removal, blending and finishing all in one application. They grind like a depressed center wheel and finish like a fiber disc to reduce process time and lower total grinding costs.

## Typical Applications

- Stock removal
- Deburring
- Blending welds
- Edge chamfering
- Rust removal
- Cleaning and finishing



### BEST Norton SG Blaze R980 – Longest life, coolest cut rate

FEATURES	BENEFITS
• Next generation SG ceramic abrasive grain	• Last 50% – 200% longer than any flap discs on stainless steel, cobalt, chrome, Inconel, titanium and other hard-to-grind materials
• Improved Y-wt polyester cloth	• Significantly improves life, grain retention and fray resistance
• Supersized grinding aid	• Cool, noticeably fast cut rate
• Durable fiberglass back	• Quick stock removal and long life
• Type 29 conical shape	• Maximum contact with workpiece without loading
• Type 27 flat face	• Fine finishing primarily on flat surfaces



### BEST TwinFiber – Aggressive stock removal

FEATURES	BENEFITS
• Premium ceramic and zirconia alumina abrasive blend	• Excellent performance and efficiencies on stainless steel applications
• Durable, fiberglass back	• Less pressure for aggressive stock removal; long life
• Type 29 angled face, conical shape	• Maximum contact with work surface without loading
• 4-1/2" and 7" with 5/8"-11 hub	• Less downtime for disc changes
• 6" with 7/8" hole	• Support increasing volume of 6" tools



### BEST TwinStar – Fine finishes

FEATURES	BENEFITS
• Premium ceramic and zirconia alumina abrasive blend	• Excellent performance and efficiencies on stainless steel applications
• Type 27 – flat face; plastic back	• Plastic wears away with abrasive – for longer life • More forgiving than Type 29 – producing smooth finishes
• 4-1/2" and 7" with 5/8"-11 hub	• Less downtime for disc changes
• 4" with 5/8" hole	• Support increasing volume of smaller tools



### BETTER Charger R822 – Versatile; high performance

FEATURES	BENEFITS
• High performance zirconia alumina abrasive	• Aggressive cut and long life • Up to 30% longer life than aluminum oxide products
• Durable, fiberglass back	• Less pressure for aggressive stock removal and long life





**GOOD** Merit Zirconia – Ideal, general purpose flap disc

**FEATURES**

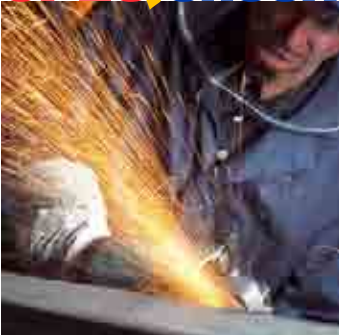
- Quality zirconia alumina grain with a phenolic resin back

**BENEFITS**

- Fast cutting; fine finishes
- Great value for MRO operations



## SPECcheck



### Flap Disc Starting Recommendations by Material

MATERIAL	HEAVY-DUTY / AGGRESSIVE STOCK REMOVAL	FINE FINISHING
Stainless steel and other tough applications	Type 29 SG Blaze R980, TwinFiber	Type 27 Norton SG Blaze R980 TwinStar
Other ferrous and nonferrous materials	Charger R822 Type 29	Charger R822 Type 27

### Flap Disc Competitive Cross Reference

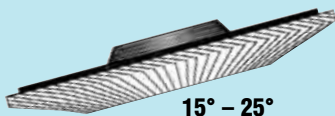
NORTON	DEWALT	GARRYSON	GEMTEX	KLINGSPOR	PFERD	SAIT	3M	WALTER	WEILER
SG Blaze R980							947D		
TwinStar								Enduroflex	
TwinFiber		Zirc +					747D Regalite		
Charger R822	Zirc	Zirc	Zirc	SMT626	Polifan	Saitlam F ZH	563D	Quick Step	Tiger, Big Cat
Merit		Zirc							Vortec

## Two Basic Flap Disc Designs

### Norton Type 29 Conical / Merit Type 27C Conical

#### THE MOST AGGRESSIVE CHOICE

- Conical flap discs have flaps angled at 10 degrees and may be used on both conical and flat surfaces
- The angle provides greater surface contact and as a result, tends to be the most aggressive choice
- The best choice when speed and stock removal are primary considerations

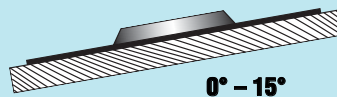


GRIND AT  
STEEPER ANGLES

### Norton and Merit Type 27 Flat

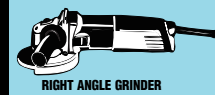
#### THE CHOICE FOR THE BEST FINISH

- The Type 27 flap discs have a flat design and are used primarily on flat surfaces
- The best choice for smooth finishing
- Also available in Norton Jumbo / Merit High Density sizes with extra large flaps lasting up to 40% longer than standard flap discs
- Choice will also depend on user preference of grinding angle (severe angle will weaken the edges)



GRIND AT  
FLATTER ANGLES

# FLAP DISCS



FLAP DISCS

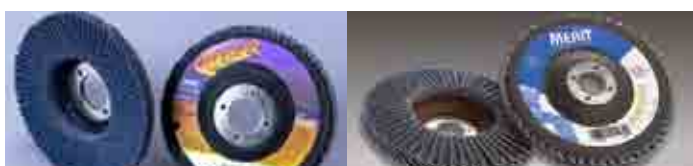


**BEST** T29 – SG BLAZE R980    **BEST** T29 – TWINFIBER    **BETTER** T29 – CHARGER R822    **GOOD** T27C – MERIT ZA

SIZE D X H	GRIT	MAX. RPM	T29 – SG BLAZE R980		T29 – TWINFIBER		T29 – CHARGER R822		T27C – MERIT ZA	
			STD. PKG.	UPC NO.	STD. PKG.	UPC NO.	STD. PKG.	UPC NO.	STD. PKG.	UPC NO.

## TYPE 29 / TYPE 27C CONICAL

4 x 5/8	36	13,000					5	66261119265		
	40							66261119264		
	60							66261119263		
	80							66261119262		
	120							66261119261		
4-1/2 x 5/8-11	24	13,000	10		5		5	66261121291	10	
	36		66261183490		63642536156		66261121290		08834194803	
	40		66261183491		63642536157		66261121289		08834194804	
	60		66261183492		63642536158		66261121288		08834194805	
	80		66261183493		63642597115		66261121287			
4-1/2 x 7/8	24	13,000	10		10		5	66261119271	10	
	36		66261183486		63642504329		66261119270		08834194296	
	40		66261183487		63642504330		66261119269		08834194766	
	60		66261183488		63642504331		66261119268		08834194767	
	80		66261183489		63642504332		66261119267		08834194768	
5 x 7/8	24	12,000	10				5	66261119277	10	
	36		66261190001				66261119276		08834193649	
	40		66261190002				66261119275		08834193650	
	60		66261190003				66261119274		08834193651	
	80		66261190004				66261119273		08834193652	
6 x 7/8	40	10,200			10	63642541406				
	60				63642541407					
	80				63642541408					
7 x 5/8-11	24	8,500	10		5		5	66261119289	10	
	36		66261183498		63642536159		66261119288		08834197210	
	40		66261183499		63642536160		66261119287		08834197212	
	60		66261183500		63642536161		66261119286		08834197213	
	80		66261183501				66261119285			
7 x 7/8	24	8,500	10		10		5	66261119283	10	08834197194
	36		66261183494		63642504334		66261119282		08834197195	
	40		66261183495		63642504335		66261119281		08834194777	
	60		66261183496		63642504336		66261119280		08834197199	
	80		66261183497		63642504337		66261119279		08834197204	



**BETTER** T27 – JUMBO CHARGER R822    **GOOD** T27 – HIGH DENSITY MERIT ZA


SIZE D X H	GRIT	MAX. RPM	T27 – JUMBO CHARGER R822		T27 – HIGH DENSITY MERIT ZA	
			STD. PKG.	UPC NO.	STD. PKG.	UPC NO.

## TYPE 27 JUMBO / HIGH DENSITY

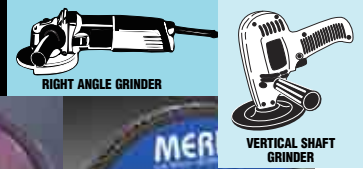
4-1/2 x 5/8-11	40	13,000	5	63642503527		
	60		63642503528			
	80		63642503529			
4-1/2 x 7/8	40	13,000	5	63642503531	10	08834190172
	60		63642503532		08834190767	
	80		63642503533		08834194360	
7 x 5/8-11	40	8,500	5	63642503539		
	60		63642503540			
7 x 7/8	40	8,500	5	63642503535	10	08834190933
	60		63642503536		08834194514	
	80		63642503537		08834194362	

## TECHtip

Use flap discs one grit size coarser than fiber discs, except in 36 grit.

 It is the user's responsibility to refer to and comply with ANSI B7.7

# FLAP DISCS



FLAP DISCS



<b>BEST</b> T27 – SG BLAZE R980	<b>BEST</b> T27 – TWINSTAR	<b>BETTER</b> T27 – CHARGER R822	<b>GOOD</b> T27 – MERIT ZA
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SIZE D X H	GRIT	MAX. RPM	BEST T27 – SG BLAZE R980		BEST T27 – TWINSTAR		BETTER T27 – CHARGER R822		GOOD T27 – MERIT ZA	
			STD. PKG.	UPC NO.	STD. PKG.	UPC NO.	STD. PKG.	UPC NO.	STD. PKG.	UPC NO.
<b>TYPE 27 FLAT</b>										
2" Type II Turn-on	36	24,000							10	08834195020
	40									08834195021
	60									08834195022
	80									08834195023
	120									08834195024
3" Type II Turn-on	36	20,000							10	08834195035
	40									08834195036
	60									08834195037
	80									08834195038
	120									08834195039
4 x 5/8	40	13,000			10	63642536153				
	60					63642536154				
	80					63642536155				
4-1/2 x 5/8-11	36	13,000	10	66261100005	5	63642536147	5	63642503510		
	40		66261100006		63642536148		63642503511			
	60		66261100007		63642536149		63642503512			
	80		66261100008				63642503513			
4-1/2 x 7/8	36	13,000	10	66261100001	10	63642504876	5			
	40		66261100002		63642504877		66261134069			
	60		66261100003		63642504878		66261134070			
	80		66261100004		63642504879		66261134071			
	120				63642505279					
5 x 7/8	36	12,000	10	66261100009	10	63642505281	5			
	40		66261100010		63642505282		63642503515			
	60		66261100011		63642505283		63642503516			
	80		66261100012		63642505284					
	120				63642505285					
7 x 5/8-11	36	8,500	10	66261100017	5		5	63642503518		
	40		66261100018		63642536150		63642503519			
	60		66261100019		63642536151		63642503520			
	80		66261100020		63642536152		63642503521			
7 x 7/8	36	8,500	10	66261100013	10	63642504880				
	40		66261100014		63642504881					
	60		66261100015		63642504882					
	80		66261100016		63642504883					



## Mini Powerflex Holder

DESCRIPTION	STD. PKG.	UPC NO.
Mini PowerFlex Type II Holder (Norton Speed-Lok TS)	1	08834168539
Mini Powerflex Type III Holder (Norton Speed-Lok TR)	1	08834160172

FIT 2" AND 3" MERIT FLAP DISCS



## TECHtips

- Operate Type 29/27C flap discs at a 15° – 25° angle; operate Type 27 (Regular and Jumbo / High Density) flap discs at an angle less than 15°; more severe angles will weaken flap edges.
- Use one grit size coarser than fiber discs, except in 36 grit.

**!** It is the user's responsibility to refer to and comply with ANSI B7.7



**NORTON**

# NORTON SG BLAZE R920 CERAMIC FLAP DISCS FOR BLENDING AND FINISHING

Cleaning and finishing

Edge chamfering

Blending welds

Rust removal



## The Ceramic Choice for Hard Metal Right Angle Grinder Blending Applications

Cotton flaps and a supersize grinding aid make these the first choice for blending and finishing stainless steel and other hard-to-grind materials and components.

Next-generation Norton SG ceramic grain provides the greatest productivity and lowest total abrasive cost vs. any other flap disc in the marketplace today.

**NORTON SG**  
**BLAZE**

### FEATURES

- Next-generation Norton SG ceramic abrasive and versatile fiberglass back
- X-wt cotton flaps and Type 27 flat face
- Improved supersized coating with grinding aid
- Includes 4" and 6" diameters
- Unique grain-side color (Blaze orange)

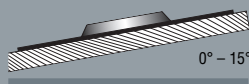
### BENEFITS

- Resists wear during use, offering significantly faster cut rates and longer life
- Engineered for stainless steel and other hard-to-grind materials
- The resulting softer action makes these the choice for smooth blending and finishing applications (primarily on flat surfaces)
- Cooler cut, less heat-generation, especially on harder-to-grind materials, throughout the life of the flap disc
- Ideal for the popular lighter weight right angle grinders
- Differentiates Norton SG Blaze R920 from all other products in the market today

## TECHtip

Type 27 flap discs have a flat face and are used primarily on flat surfaces for smooth finishing. Use one grit coarser than fiber discs.

Operate at an angle less than 15°. More severe angles will weaken flap edges.



# NORTON SG BLAZE R920 CERAMIC FLAP DISCS

## The Greatest Productivity and Lowest Total Blending and Finishing Costs

Norton SG Blaze R920 flap discs resist wear during use, resulting in faster cut rates and significantly longer life versus all competitive flap disc products in the marketplace. The cotton back provides a softer blending action and a "supersize" grinding aid promotes cooler cutting throughout the life of the disc.

### Ceramic Type 27 Flat-Faced Flap Disc Stock Availability



ALL NORTON SG BLAZE R920 FLAP DISCS ARE PACKAGED 10/BOX.

ASK YOUR NORTON DISTRIBUTOR ABOUT OUR COMPLEMENTARY NORTON SG BLAZE R980 FLAP DISCS WITH DURABLE, HEAVY POLYESTER FLAPS – THE CHOICE FOR DEBURRING AND STOCK REMOVAL.

SIZE	GRIT	QTY/PACK	UPC NUMBER
4" x 5/8"	40	13,000	66254400249
	60	13,000	66254400250
	80	13,000	66254400251
	120	13,000	66254400252
4-1/2" x 5/8"-11	40	13,000	66254400257
	60	13,000	66254400258
	80	13,000	66254400259
	120	13,000	66254400261
4-1/2" x 7/8"	40	13,000	66254400253
	60	13,000	66254400254
	80	13,000	66254400255
	120	13,000	66254400256
5" x 7/8"	40	12,000	66254400262
	60	12,000	66254400264
	80	12,000	66254400265
	120	12,000	66254400519
6" x 7/8"	36	10,200	66254400843
	40	10,200	66254400844
	60	10,200	66254400845
	80	10,200	66254400846



**BLAZE YOUR WAY TO GREATER PRODUCTIVITY!**

### BEST

For most abrasive applications, Norton offers up to three product performance levels – GOOD, BETTER and BEST. Norton SG Blaze R920 flap discs are in the BEST tier. They represent products that are unmatched in the industry and provide the lowest total cost for the application.

To put Norton abrasives to work for you, call your local Norton distributor or visit our website at [www.nortonabrasives.com](http://www.nortonabrasives.com) to view our online catalog and learn about our latest products and applications.

**NORTON**

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Worcester, MA 01615-0008  
[www.nortonabrasives.com](http://www.nortonabrasives.com)

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Fax Toll Free: 1 800 551-4416  
Local Phone: (254) 918-2313  
Local Fax: (254) 918-2314

CANADA CUSTOMER SERVICE:  
Phone Toll Free: 1 800 268-2262  
Fax Toll Free: 1 800 561-9490

*engineering for gold*



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**FORM #8117**

