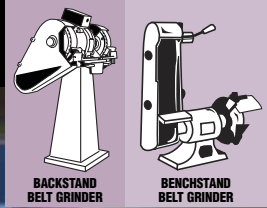


NARROW BELTS



A wide selection of sizes and grits for most dimensioning, intermediate grinding and polishing applications.

Typical Applications

Benchstand and Backstand Belts

- Grinding and deburring of all metals
- Heavy stock removal
- Blending, dimensioning and shaping
- Polishing

Centerless, Conveyor and Platen Belts

- Intermediate grinding stainless and carbon
- Moderate pressure applications
- Dimensioning and finishing



BEST Norton SG Blaze R980 Belts – For greatest productivity

FEATURES	BENEFITS
<ul style="list-style-type: none"> • Next generation cooler cutting SG ceramic abrasive grain 	<ul style="list-style-type: none"> • Lasts 50% to 200% longer on mild and carbon steel, stainless, cobalt, chrome, inconel and titanium • Cuts 20% faster than the current generation of grinding belts • Longer belt life • Better metal integrity • Greater productivity; lowest total grinding costs
<ul style="list-style-type: none"> • Improved Y-wt polyester, waterproof cloth backing 	<ul style="list-style-type: none"> • Significantly improved belt life due to better grain adhesion • Edge-fray resistance • Improved body retention during use for more consistent grinding throughout belt life
<ul style="list-style-type: none"> • Improved resin bond system 	<ul style="list-style-type: none"> • Improved grain-retention; cooler cutting during the life of the belt
<ul style="list-style-type: none"> • Advanced “supersize” grinding lubricant 	<ul style="list-style-type: none"> • Cooler cutting during the life of the belt • Improved part finish and integrity



BEST Norton SG R981 Belts – Exceptional performance

FEATURES	BENEFITS
<ul style="list-style-type: none"> • Norton SG ceramic abrasive 	<ul style="list-style-type: none"> • Exceptional life and value, especially on hard-to-grind alloys
<ul style="list-style-type: none"> • Grinding-aid enhanced 	<ul style="list-style-type: none"> • Longer life, cooler cut
<ul style="list-style-type: none"> • Strong Y-wt polyester, waterproof cloth backing 	<ul style="list-style-type: none"> • Improved grain adhesion, reduced edge-fray and better body retention, result in longer life and product consistency



BETTER NorZon Plus R821 Belts – For non-ferrous metals, glass and ceramics

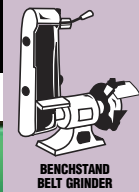
FEATURES	BENEFITS
<ul style="list-style-type: none"> • Premium self-sharpening zirconia alumina abrasive 	<ul style="list-style-type: none"> • Aggressive, rapid cut rate
<ul style="list-style-type: none"> • Durable grain coating 	<ul style="list-style-type: none"> • Excellent grain adhesion: longer life
<ul style="list-style-type: none"> • Y-wt cotton backing 	<ul style="list-style-type: none"> • Extended life on dry grinding applications



BETTER NorZon Plus R824/R823 Belts – The choice for heaviest pressure applications

FEATURES	BENEFITS
<ul style="list-style-type: none"> • Premium self-sharpening zirconia alumina abrasive 	<ul style="list-style-type: none"> • Aggressive, rapid cut rate
<ul style="list-style-type: none"> • R824 – Durable Y-wt polyester, waterproof cloth backing 	<ul style="list-style-type: none"> • Excellent grain adhesion, reduced edge-fray and better body retention, result in longer life and product consistency
<ul style="list-style-type: none"> • R823 – Strong X-wt polyester backing; waterproof 	<ul style="list-style-type: none"> • More flexible than R824 • Available in finer grit sizes





BENCHSTAND BELT GRINDER

BETTER	NorZon Plus R801 Belts – Ideal for grinding exotic alloys and forged steel
FEATURES	BENEFITS
<ul style="list-style-type: none"> • Self-sharpening NorZon Plus zirconia alumina abrasive grain • Grinding aid enhanced • Durable Y-wt polyester, waterproof cloth backing 	<ul style="list-style-type: none"> • Resists dulling, resulting in longer belt life • Cooler cut on stainless steels and titanium alloys • Improved grain adhesion, reduced edge-fray and better body retention, result in longer life and product consistency



GOOD	Metalite R228 Belts – Versatile; for all MRO applications
FEATURES	BENEFITS
<ul style="list-style-type: none"> • Aluminum oxide abrasive • Strong X-wt cotton backing 	<ul style="list-style-type: none"> • For a wide range of metalworking applications • Ideal where cutting action is more important than backing conformability • Aggressive cutting/resistant to heat

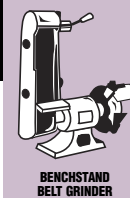


Benchstand Belts 1" to 6" Wide, 36" to 72" Long



SIZE W X L	GRIT	MIN./ STD. PKG.	BETTER NORZON PLUS R821		BETTER NORZON PLUS R823†		GOOD METALITE R228			
			UPC NO.	JOINT/ FLEX	UPC NO.	JOINT/ FLEX	UPC NO.	JOINT/ FLEX		
1 x 42	40	50/200	78072726905	Plyweld, RR	78072728596	Plyweld, RR	78072720910	Plyweld, RR		
	50		78072726904	Plyweld, RR			78072720905	Plyweld, RR		
	60		78072726903	Plyweld, RR			78072720900	Plyweld, RR		
	80		78072726902	Plyweld, RR			78072720895	Plyweld, RR		
	100			78072728592			Plyweld, RR	78072720890	Plyweld, RR	
	120			78072728590			Plyweld, RR	78072720885	Plyweld, RR	
	150							78072720880	Plyweld, RR	
	180						78072728586	Plyweld, RR	78072720875	Plyweld, RR
	220							78072720871	Plyweld, RR	
	240							78072720870	Plyweld, RR	
320				78072720865	Plyweld, RR					
1-1/2 x 60	36	10/50	78072726993	Plyweld, RR	78072726988	Norlok, RR	78072721045	Plyweld, RR		
	50		78072726991	Plyweld, RR			78072721030	Plyweld, RR		
	60		78072726990	Norlok, RR			78072722855	Plyweld, RR		
	80									
	120									
180										
2 x 48	36	10/50	78072727103	Plyweld, RR	78072728621	Norlok, RR	78072721255	Plyweld, RR		
	40		78072727102	Plyweld, RR			78072721250	Plyweld, RR		
	50		78072727101	Norlok, RR			78072721245	Plyweld, RR		
	60		78072727100	Norlok, RR			78072721240	Plyweld, RR		
	80		78072727099	Norlok, RR			78072721235	Plyweld, RR		
	100						78072721230	Plyweld, RR		
	120						78072721225	Plyweld, RR		
	180						78072721223	Plyweld, RR		
	220									
2 x 60	40	10/50	78072727124	Plyweld, RR	78072728609	Plyweld, RR	78072721300	Plyweld, RR		
	60		78072727122	Norlok, RR			78072721290	Plyweld, RR		
	80		78072727121	Norlok, RR			78072721285	Plyweld, RR		
	100						78072721280	Plyweld, RR		
	120						78072721275	Plyweld, RR		
320				78072702825	Plyweld, RR					
2 x 72	36	10/50	78072727147	Plyweld, RR	78072728645	Norlok, RR	78072721335	Plyweld, RR		
	40		78072727146	Plyweld, RR			78072721325	Norlok, RR		
	50		78072727145	Norlok, RR			78072721320	Norlok, RR		
	60		78072727144	Norlok, RR			78072723235	Norlok, RR		
	80		78072727142	Norlok, RR			78072721318	Plyweld, RR		
	100									
	120									
	220						78072728639	Plyweld, RR		
	320						78072728633	Plyweld, RR		
								78072721308	Plyweld, RR	

REFER TO PAGE 82 FOR JOINT AND FLEX DESCRIPTIONS.
† WATERPROOF



BENCHSTAND BELT GRINDER

Benchstand Belts 1" to 6" Wide, 36" to 72" Long (CONTINUED)

SIZE W X L	GRIT	MIN./ STD. PKG.	BETTER NORZON PLUS R821		BETTER NORZON PLUS R823†		GOOD METALITE R228		
			UPC NO.	JOINT/ FLEX	UPC NO.	JOINT/ FLEX	UPC NO.	JOINT/ FLEX	
2-1/2 x 48	36	10/50	78072727213	Norlok, RR			78072721540	Plyweld, RR	
	50							78072721530	Plyweld, RR
	60							78072721525	Plyweld, RR
	80							78072721520	Plyweld, RR
	120							78072721510	Plyweld, RR
2-1/2 x 60	36	10/50	78072727235	Plyweld, RR	78072728692	Norlok, RR	78072721610	Plyweld, RR	
	40		78072727234	Plyweld, RR			78072721605	Plyweld, RR	
	50		78072727233	Norlok, RR			78072721600	Plyweld, RR	
	60		78072727232	Norlok, RR			78072721595	Plyweld, RR	
	80		78072727231	Norlok, RR			78072721590	Plyweld, RR	
	100						78072721585	Plyweld, RR	
	120						78072721580	Plyweld, RR	
	180						78072721570	Plyweld, RR	
4 x 36	36	10/50	78072727475	Norlok, RR	78072728827	Norlok, RR	78072722110	Plyweld, RR	
	40						78072722105	Plyweld, RR	
	50						78072722100	Plyweld, RR	
	60						78072722095	Plyweld, RR	
	80						78072722090	Plyweld, RR	
	100						78072722085	Plyweld, RR	
	120						78072722080	Plyweld, RR	
	150						78072722079	Plyweld, RR	
	180						78072722075	Plyweld, RR	
	320						78072722071	Plyweld, RR	
4 x 54	36	10/50	78072727518	Norlok, RR			78072722185	Plyweld, RR	
	40						78072722180	Plyweld, RR	
	50						78072722175	Plyweld, RR	
	60						78072722170	Plyweld, RR	
	80						78072722165	Plyweld, RR	
	100						78072722160	Plyweld, RR	
	120						78072722155	Plyweld, RR	
6 x 48	36	10/20	78072727698	Plyweld, RR	78072728937	Norlok, RR	78072722590	Plyweld, RR	
	40	20/20	78072727697	Plyweld, RR			78072722585	Plyweld, RR	
	50		78072727696	Norlok, RR			78072722580	Plyweld, RR	
	60		78072727695	Norlok, RR			78072722575*	Plyweld, RR	
	80		78072727694	Norlok, RR			78072722570*	Plyweld, RR	
	100						78072722565*	Plyweld, RR	
	120						78072722560*	Plyweld, RR	
	150						78072722555*	Plyweld, RR	
	180						78072722550*	Plyweld, RR	
	220						78072722546*	Plyweld, RR	
	240						78072722545*	Plyweld, RR	
320				78072722543*	Plyweld, RR				
6 x 60	36	10/20	78072727762	Plyweld, RR	78072728957	Norlok, RR	78072722680	Plyweld, RR	
	40	20/20					78072722679	Plyweld, RR	
	60						78072722665	Plyweld, RR	
	80						78072722660	Plyweld, RR	

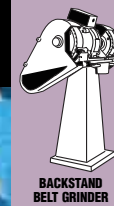
REFER TO PAGE 82 FOR JOINT AND FLEX DESCRIPTIONS. † WATERPROOF * MIN./STD. PKG IS 10/20



Narrow Belt Competitive Cross Reference

NORTON	3M	HERMES	KLINGSPOR	SIA	VSM
R980	987F1, 977F, 777F, 967F	CR456	CS612YY	-	SK840X
R981	963G, 963H		CS610YY		SK750X
R801	577F, 567G, 777F	RB486X, RB486Y	CS409Y	-	KK815Y
	977F	RB426-23MX			ZK744X
R821	561D		CS411X	-	-
R823	561F Y, 551E XE	RB486 X, RB346-23MX	CS411Y		KK715X
	741A, 741E, 761D	RB426-23MX, RB484TY			
		RB486XF			
R824	561D, 561F, 563F	RB484TY, RB486Y	CS411Y	2800, 2803	KK716Y
	741A, 741E, 761D	RB346-23MX, RB426-23MX		2929	ZK713X
	761F	RB480-21MX, CB440Y			
		RB486XY			
R228	240DZ OPK	RB3160P	CS311X	2903X0	-
	270DZ OPK	RB317LX	CS310	2905X	KK511X
	241D, 248D, 251D	RB346MX	CS410	2920X	KK711
	3411 Imperial, 351D				

BACKSTAND BELTS



NARROW BELTS

Backstand Belts 2" to 10" Wide



**BEST
NORTON SG BLAZE R980†**



**BEST
NORTON SG R981†**



**BETTER
NORZON PLUS R824†**

SIZE W X L	GRIT	MIN./ STD. PKG.	BEST NORTON SG BLAZE R980†			BEST NORTON SG R981†		BETTER NORZON PLUS R824†	
			UPC #	JOINT/ FLEX	MIN./ STD. PKG.	UPC #	JOINT/ FLEX	UPC #	JOINT/ FLEX
2 x 132	36				10/50	78072753086	Plyweld, RR	78072750016	Plyweld, RR
	40					78072740771	Norlok, RR	78072750015	Plyweld, L
	50					78072701958	Norlok, RR	78072750013	Norlok, L
	60						78072750011	Norlok, L	
	80						78072750008	Norlok, RR	
3 x 132	24	25/50	69957344962	Plyweld, RR	10/50	78072753087	Plyweld, RR	78072750140	Plyweld, RR
	36		69957344710	Plyweld, RR		78072750138	Plyweld, RR		
	36					78072750139	Plyweld, L		
	40	69957344964	Plyweld, RR	78072701614	Plyweld, RR				
	50	69957344763	Plyweld, RR	78072703709	Norlok, RR	78072750135	Norlok, L		
	60	69957344958	Plyweld, RR						
80	69957344764	Plyweld, RR							
4 x 132	36				10/50	78072739662	Plyweld, RR	78072750287	Plyweld, RR
	60							78072750281	Norlok, RR
	80							78072750279	Norlok, RR

REFER TO PAGE 82 FOR JOINT AND FLEX DESCRIPTIONS.

† WATERPROOF

L = LINEAR FLEX

RR = RUBBER ROLL FLEX

80

Belt Cleaning Stick

This solid rubber cleaning stick is designed to remove wood and other non-metallic materials that build up on narrow belts during use. Apply it to the face of the belt while running, to remove unwanted materials and increase cut rate and overall life of the belt.

DESCRIPTION	STD. PKG.	UPC NO.
1-3/8 x 1-3/8 x 6	10	07660701717



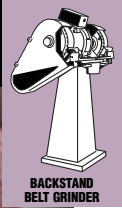
TECHtips

- A light bodied grease applied to the belt surface will reduce loading and greatly enhance the belt life and performance when grinding soft, malleable nonferrous materials such as aluminum, brass, bronze and copper.
- Norlok and Plyweld joints can be used in either direction.



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

BACKSTAND BELTS



BACKSTAND BELT GRINDER

NARROW BELTS

Backstand Belts 2" to 10" Wide



SIZE W X L	GRIT	MIN./ STD. PKG.	BETTER NORZON PLUS R823†		BETTER NORZON PLUS R801†		GOOD METALITE R228	
			UPC #	JOINT/ FLEX	UPC #	JOINT/ FLEX	UPC #	JOINT/ FLEX
2 x 132	60	10/50	78072728662	Plyweld, RR			78072721445	Norlok, RR
	80						78072721440	Norlok, RR
	120							
3 x 132	36	25/50			78072721973	Plyweld, RR	78072721900	Plyweld, RR
	50						78072721890	Norlok, RR
	60						78072721885	Norlok, RR
	80						78072721880	Norlok, RR
	100						78072721875	Norlok, RR
	120						78072721870	Plyweld, RR
	150						78072721865	Plyweld, RR
	180						78072721860	Plyweld, RR
220	78072721855	Plyweld, RR						
4 x 132	80	10/50					78072722385	Norlok, RR
	120						78072722375	Plyweld, RR
8 x 107	36	10/20					78072722795	CRG, D
	50	20/20					78072749887	CRG, D
	60						78072722780	CRG, C
	80						78072722775	CRG, D
10 x 70-1/2	36	5/10					78072722840	CRG, RR
	40						78072722835	CRG, RR
	50	10/10					78072722830	CRG, RR
	60						78072722825	CRG, RR
	80						78072722820	CRG, RR

REFER TO PAGE 82 FOR JOINT AND FLEX DESCRIPTIONS.

- † WATERPROOF
- CRG = ROLL GRINDING JOINT
- C = CROSS FLEX
- D = DOUBLE FLEX
- RR = RUBBER ROLL FLEX

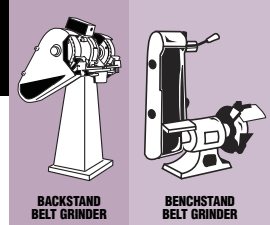


Narrow Belt Starting Recommendations

MATERIAL	HEAVY DUTY	GENERAL DUTY
Aluminum	NorZon Plus R824	NorZon Plus R823
Cast Iron	NorZon Plus R824	NorZon Plus R823
Brass/Bronze	NorZon Plus R824	
Die Castings	NorZon Plus R823	Metalite R228
Carbon Steel	Norton SG Blaze R980	Metalite R228
	NorZon Plus R824	
	Norton SG R981	
Glass/Ceramics	NorZon Plus R821	
Stainless Steel and Alloys	Norton SG Blaze R980	NorZon Plus R823
	NorZon Plus R824	Metalite R228
	NorZon Plus R801	
	Norton SG R981	
Wood		Metalite R228

Recommended Grit Selection

ROUGH/HEAVY DUTY	INTERMEDIATE	FINISHING/POLISHING
24-50	60-100	120-320



Troubleshooting Guide for Contact Wheels

SUGGESTED CORRECTION – CONTACT WHEELS

PROBLEM	HARDER WHEEL	SOFTER WHEEL	LARGER GROOVE/LAND	SMALLER GROOVE/LAND	DRESS WHEEL	HIGHER SPEED	LOWER SPEED	STANDARD SERRATION	LARGER WHEEL	SMALLER WHEEL
Dulling	•		•				•			•
Loading			•							•
Over-aggressiveness		•		•				•	•	
Slow cutting	•		•			•				•
Scratches too deep		•		•				•	•	
Burning	•						•			
Non-conformity		•	•				•		•	
Dubbing edges	•									
Shedding abrasives		•		•	•	•		•	•	
Chatter		•			•			•	•	

Troubleshooting Guide

PROBLEM	CORRECTION
Loading	Decrease infeed pressure or belt speed
Shedding	Reduce applied pressure Use a less aggressive contact wheel Dress contact wheel if worn or damaged Use entire surface of belt
Belt breakage	Reduce belt tension Use less aggressive contact wheel Check tracking mechanism for belts tracking erratically



Belt Joints

CD Joint – conventional butt joint specifically for portable belts – straight cut with tape

Channel Joint – preferred for woodworking. Available on selected F-wt wide paper belts only. The patch material is inlaid into the paper backing, making the thinnest, smoothest-running butt joint possible, which minimizes bumping and chattering, with no loss of strength.

CRG Joint – Roll Grinding Joint – special platen and roll grinding butt joint

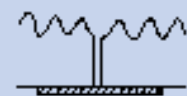
Norlok Joint – The two ends of the abrasive material are cut in an interlocking configuration that, when joined with a thinner patch material, offers resistance to hinging and joint fatigue. The special configuration permits this joint to more closely conform to contact wheels, workpiece shapes, and other difficult applications.

PG Joint – Precision Grinding Joint – a butt joint, joined with flexible tape for contour grinding.

BT / Plyweld Joint – a conventional butt joined with an extra strong patch to eliminate joint breakage. Often used for demanding operations with coarse grit belts.



NORLOK JOINT



PLYWELD JOINT

Belt Flexes

C – Cross Flex – Flex lines are at a 45° angle to the edge of the belt, making a series of diamond shaped lines.

D – Double Flex – The bond is broken at two 45° angles (to the length). This flex is desirable for sanding shapes and contours, such as moldings. It is standard on most J-wt products.

L – Linear Flex – The bond is broken in the direction of the length, providing good product conformability with long life.

S – Single Flex – The bond is broken at a 90° angle to the length, creating flex lines that are perpendicular to the edge of the belt. The abrasive is stiffer in one direction and flexible in the other. Single Flex is standard on most X-wt products.

RR – Rubber Roll Flex – Flex lines are perpendicular (90° angle) to the edge of the belt (creating a horizontal line pattern) providing flexibility in the lengthwise direction.

T – Triple Flex – A combination of Single Flex and Double Flex. It is specified on applications requiring maximum product conformability, such as sanding irregular contours.



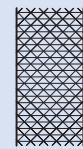
SINGLE FLEX



LINEAR



CROSS FLEX



TRIPLE FLEX