

COMBIDISC®

The product line for many applications



TRUST BLUE

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

COMBIDISC® quick-change discs

General information

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

Advantages:

- Reduced down time due to quick disc changes.
- Great convenience due to simple handling and low-vibration working.
- No operational disruptions caused by sticking, slipping or disengaging.

Applications:

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

Recommendations for use:

- Use COMBIDISC® grinding discs with arbors or abrasive disc holders on flexible shaft drives with angle handpieces, compressed-air or electric angle grinders.

Compatible power tools:

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

Ordering notes:

- Please order arbors or COMBIDISC® abrasive disc holders separately. More detailed information and ordering data can be found on page 17.

Safety notes:

- The maximum permitted peripheral speed is 9,800 SFPM.
- For safety reasons, it is imperative to remain within the stated maximum permitted rotational speed at all times.



Accessories:

- Arbors for COMBIDISC® Mini-POLIFAN
- COMBIDISC® abrasive disc holders

PFERDVALUE®:

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



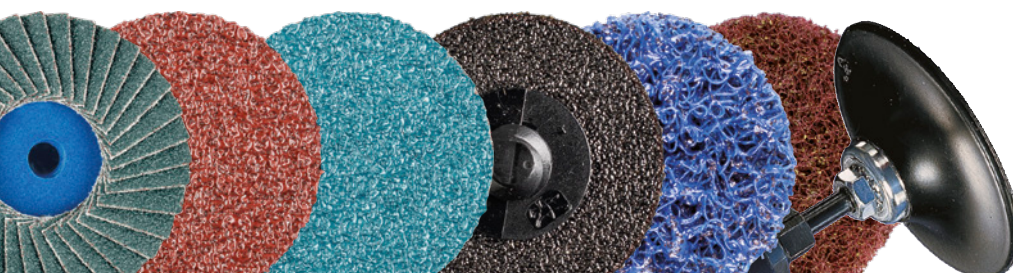
PFERDEFFICIENCY® recommends COMBIDISC® products to reduce disc change and setup times.



PFERDVIDEO:

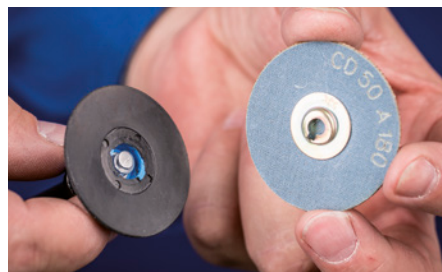


Learn more about the advantages of using COMBIDISC® products.



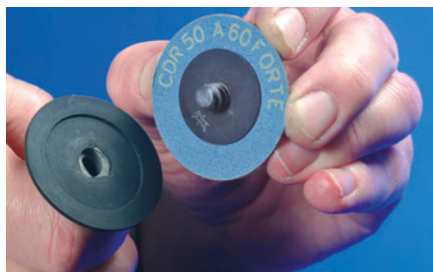
PFERD offers two alternative mounting systems:

CD system



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

CDR system



Disc side: Threaded connection with male thread (plastic)

Overview of COMBIDISC® quick-change discs

Mini-POLIFAN® CD, CDR	4	Abrasive discs – RS type	13	Felt discs	17
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VICTOGRain®	9	Unitized discs	16		

COMBIDISC® quick-change discs

General information



Recommended rotational speed range

Example:

EDP: 42292 2" CD CO-COOL

Application:

Grinding alloyed steel

Peripheral speed: 4,000–5,000 SFPM

Rotational speed: 7,600–9,600 RPM

D ₁ [Inches]	Peripheral speed [SFPM]								
	1,000	2,000	3,000	4,000	5,000	6,000	7,000	8,000	10,000
Rotational speeds [RPM]									
1	3,800	7,600	11,500	15,300	19,100	22,900	26,700	30,600	38,200
1-1/2	2,500	5,100	7,600	10,200	12,700	15,300	17,800	20,400	25,500
2	1,900	3,800	5,700	7,600	9,600	11,500	13,400	15,300	19,100
3	1,300	2,500	3,800	5,100	6,400	7,600	8,900	10,200	12,700

Quick product selection guide

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

● = highly recommended

○ = recommended

COMBIDISC® quick-change discs

Mini-POLIFAN® CD, CDR

Mini-POLIFAN® Aluminum oxide A

For universal coarse grinding work with high stock removal rates.

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

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

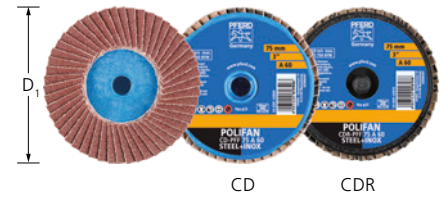
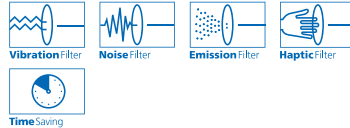
Abrasive:

Aluminum oxide A

Ordering notes:

- Please order arbors or COMBIDISC® abrasive disc holders separately. See below and page 17.

PFERDVALUE®:



D ₁ [Inches]	Grit and EDP number				Opt. RPM	
	40	60	80	120		
CD system						
2	42802	42803	42804	42805	12,000–14,000	10
3	42808	42809	42810	42811	8,000–10,000	10
CDR system						
2	42912	42913	42914	42915	12,000–14,000	10
3	42918	42919	42920	42921	8,000–10,000	10

Mini-POLIFAN® Zirconia alumina Z

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

Abrasive:

Zirconia alumina Z

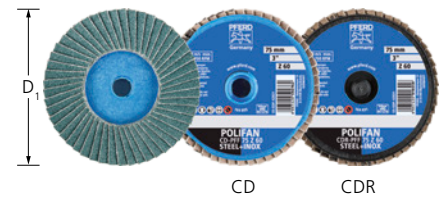
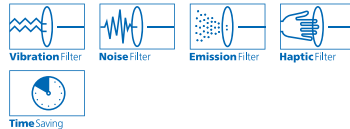
Recommendations for use:

- Use in the case of a higher contact pressure.

Ordering notes:

- Please order arbors or COMBIDISC® abrasive disc holders separately. See below and page 17.

PFERDVALUE®:

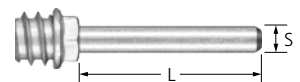


D ₁ [Inches]	Grit and EDP number				Opt. RPM	
	40	60	80	120		
CD system						
2	42814	42815	42816	42817	12,000–14,000	10
3	42820	42821	42822	42823	8,000–10,000	10
CDR system						
2	42924	42925	42926	42927	12,000–14,000	10
3	42930	42931	42932	42933	8,000–10,000	10

Drive arbors

Drive arbors for Mini-POLIFAN® discs

Matching arbor for use with COMBIDISC® Mini-POLIFAN® discs with CD thread.



S [Inches]	L [Inches]	EDP number	Recommended diameters	
1/4	1-1/2	42851	2	1
		42852	3	1

COMBIDISC® quick-change discs

Abrasive discs

Aluminum oxide A

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

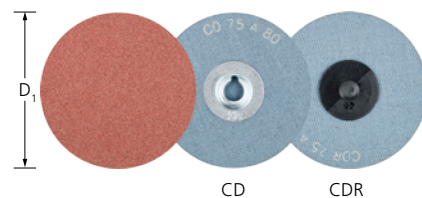
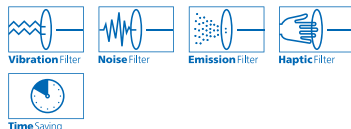
Abrasive:

Aluminum oxide A

Ordering notes:

- Please order backing pad separately.
See page 17.

PFERDVALUE®:



D ₁ [Inches]	Grit and EDP number							Opt. RPM	
	36	50	60	80	120	180	320		
CD system									
1	-	-	42136	42137	42139	42141	42143	15,000–26,000	100
1-1/2	42145	-	42148	42149	42151	42153	42155	10,000–16,000	100
2	42157	42159	42160	42161	42163	42165	42167	8,000–13,000	100
3	42169	42171	42172	42173	42175	42177	42179	5,000–9,000	50
CDR system									
1	-	-	42481	42482	42484	42486	42488	15,000–26,000	100
1-1/2	42490	-	42493	42494	42496	42498	42500	10,000–16,000	100
2	42502	42504	42505	42506	42508	42510	42512	8,000–13,000	100
3	42514	42516	42517	42518	42520	42522	42524	5,000–9,000	50

Aluminum oxide A-PLUS

For universal applications from coarse to fine grinding. Higher stock removal rate due to sturdy backing material. Recommended for use in edge grinding due to high tear strength.

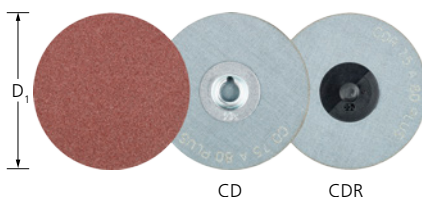
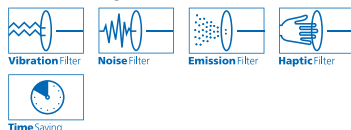
Abrasive:

Aluminum oxide A-PLUS

Ordering notes:

- Please order backing pad separately.
See page 17.

PFERDVALUE®:



D ₁ [Inches]	Grit and EDP number				Opt. RPM		
	36 PLUS	60 PLUS	80 PLUS	120 PLUS			
CD system							
2	42330	42331	42332	42333	8,000–13,000	100	
3	42335	42336	42337	42338	5,000–9,000	50	
CDR system							
2	42670	42671	42672	42673	8,000–13,000	100	
3	42675	42676	42677	42678	5,000–9,000	50	



COMBIDISC® quick-change discs

Abrasive discs

Aluminum oxide A compact grain

Extremely well suited for fine and very fine grinding, and for step-by-step preparations for polishing.

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

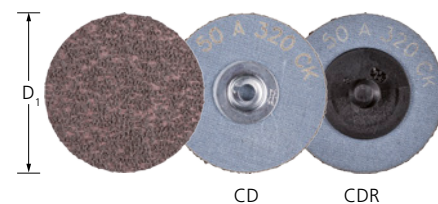
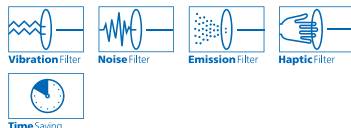
Abrasive:

Aluminum oxide A compact grain (CK)

Ordering notes:

- Please order backing pad separately.
See page 17.

PFERDVALUE®:



	D ₁ [Inches]	Grit and EDP number									Opt. RPM	
		120	180	240	320	400	600	800	1000	1200		
CD system												
	2	42936	42937	42938	42939	42940	42941	42942	42943	42944	3,800–13,000	100
	3	42945	42946	42947	42948	42949	42950	42951	42952	42953	2,500–9,000	50
CDR system												
	2	42954	42955	42956	42957	42958	42959	42960	42961	42962	3,800–13,000	100
	3	42963	42964	42965	42966	42967	42968	42969	42970	42971	2,500–9,000	50



COMBIDISC® quick-change discs

Abrasive discs

Zirconia alumina Z

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

Abrasive:

Zirconia alumina Z

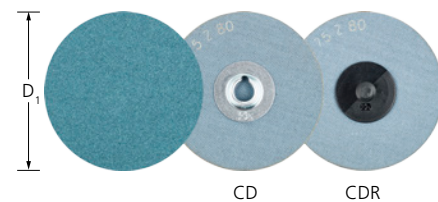
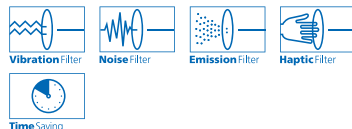
Recommendations for use:

- Use with hard or medium-hard COMBI-DISC® abrasive disc holders.

Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



	D ₁ [Inches]	Grit and EDP number				Opt. RPM	
		36	50	60	80		
CD system 							
	2	42254	42256	42257	42258	3,800–13,000	100
	3	42261	42263	42264	42265	2,500–9,000	50
CDR system 							
	2	42593	42595	42596	42597	3,800–13,000	100
	3	42600	42602	42603	42604	2,500–9,000	50



COMBIDISC® quick-change discs

Abrasive discs

Ceramic oxide CO-COOL

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

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

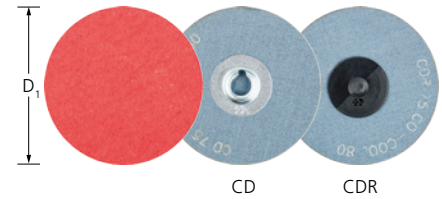
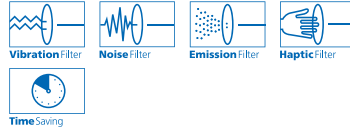
Abrasive:

Ceramic oxide CO-COOL

Ordering notes:

- Please order backing pad separately.
See page 17.

PFERDVALUE®:



	D ₁ [Inches]	Grit and EDP number					Opt. RPM	
		24	36	60	80	120		
CD system 								
	2	42280	42289	42292	42293	42295	3,800–13,000	100
	3	42281	42296	42299	42300	42302	2,500–9,000	50
CDR system 								
	2	42619	42628	42631	42632	42634	3,800–13,000	100
	3	42620	42635	42638	42639	42641	2,500–9,000	50

Ceramic oxide CO-COOL mini fibre discs

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

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

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

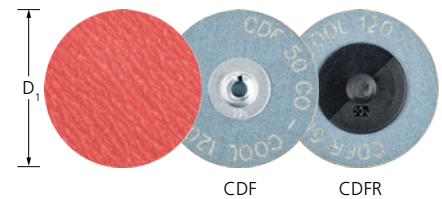
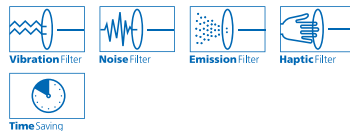
Abrasive:

Ceramic oxide CO-COOL

Ordering notes:

- Please order backing pad separately.
See page 17.

PFERDVALUE®:



	D ₁ [Inches]	Grit and EDP number				Opt. RPM	
		36	50	80	120		
CD system 							
	2	40492	40494	40496	40497	3,800–13,000	100
	3	40499	40501	40503	40504	2,500–9,000	50
CDR system 							
	2	40632	40634	40636	40637	3,800–13,000	100
	3	40639	40641	40643	40644	2,500–9,000	50

VICTOGRAIN® abrasive material is used to make some of the most effective grinding products in the world. PFERD's triangular, precision-formed grain achieves ultimate performance.



The **VICTOGRAIN®** abrasive grain triangles are identical in shape and size and their cutting edges are applied to the workpiece at the optimum angle, meaning the grain needs very little energy to penetrate the workpiece. As a result, the user experiences superior productivity due to:

- extremely high stock removal,
- a long service life,
- and reduced heat build-up in the workpiece.

Each **VICTOGRAIN®** abrasive grain triangle is firmly fixed on one of its sides to the backing material. Due to the slim design, **VICTOGRAIN®** offers an extremely large chip space for maximum cutting efficiency.

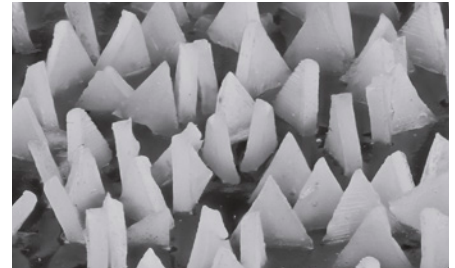
The structure of the triangular **VICTOGRAIN®** is specially engineered to maximize results. The very fine crystalline structure ensures optimal wear characteristics as sharp cutting edges are always exposed, with the minimum amount of abrasive breaking off from the triangle.

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

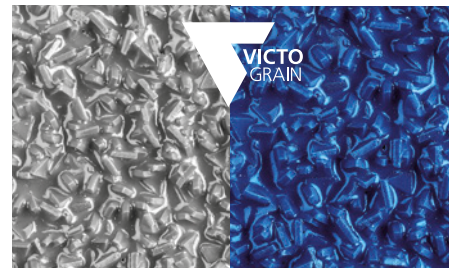


PFERDVIDEO:

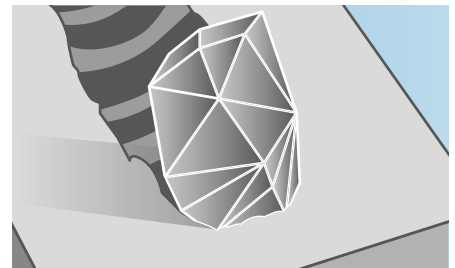
Learn more about the advantages of using **VICTOGRAIN®** products.



The **VICTOGRAIN®** abrasive grain is optimally aligned



VICTOGRAIN® coated abrasive material



Conventional abrasive grain

VICTOGRAIN® abrasive grain

Applications:

- Levelling
- Deburring
- Surface work
- Work on edges
- Work on weld seams

Compatible power tools:

- Angle grinders
- Cordless angle grinders
- Flexible shaft drives



For more detailed information about the **VICTOGRAIN®** products range, please refer to our brochure "**VICTOGRAIN®** – No surface is safe" at www.pferd.com.

COMBIDISC® quick-change discs

Abrasive discs

VICTOGRAIN®-COOL mini fibre discs

Well-suited for surface and edge grinding. The fibre backing considerably strengthens the abrasive disc and improves stock removal.

For maximum removal rates with an extremely long service life on steels and materials which are hard or have poor heat-conducting properties.

Outstanding, consistent high performance due to the **VICTOGRAIN®** abrasive grain.

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

Abrasive:

VICTOGRAIN®-COOL

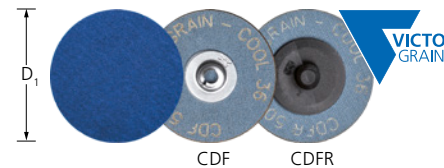
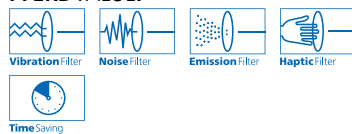
Recommendations for use:

- Use COMBIDISC® grinding products with arbors or abrasive disc holders on flexible shaft drives with angle handpieces, compressed-air or electric angle grinders.

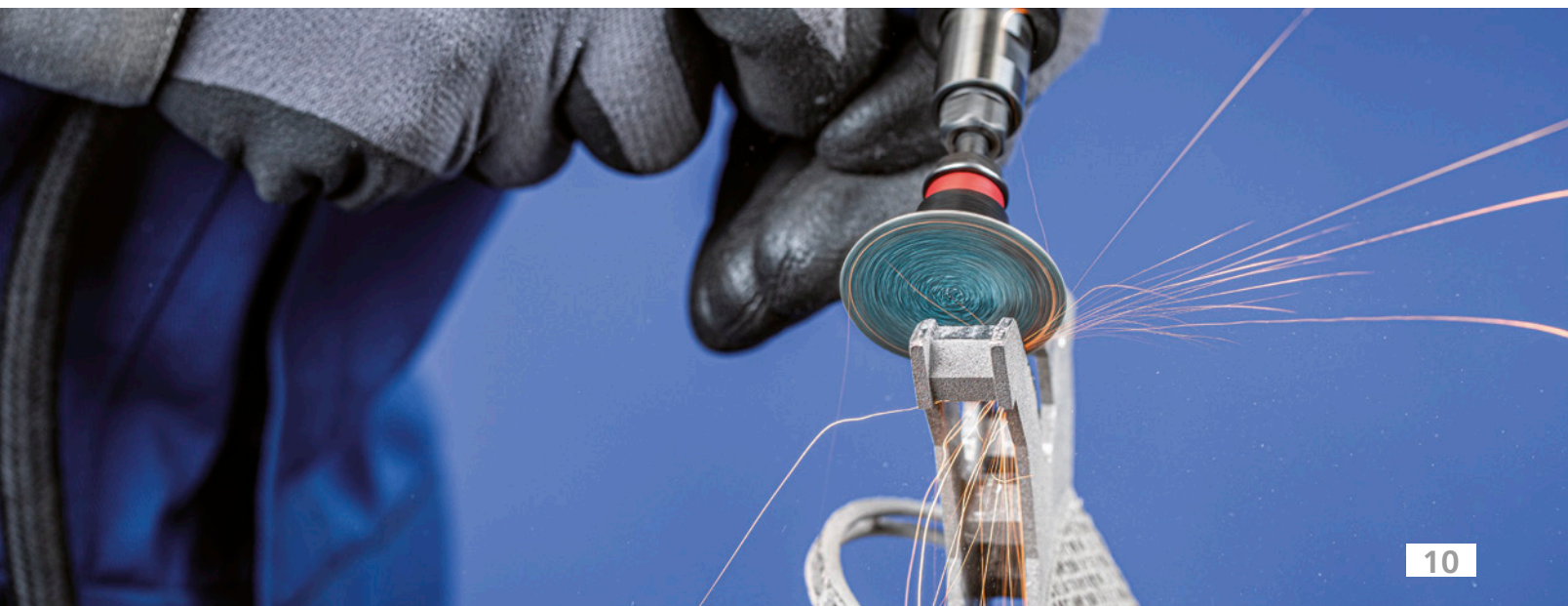
Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE:



	D ₁ [mm]	Grit and EDP number	Opt. RPM	
		36		
CD system 				
	2	42433	3,800–13,000	100
	3	42434	2,500–9,000	50
CDR system 				
	2	42441	3,800–13,000	100
	3	42442	2,500–9,000	50



COMBIDISC® quick-change discs

Abrasive discs

Silicon carbide SiC

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

Recommended for use on titanium alloys.

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

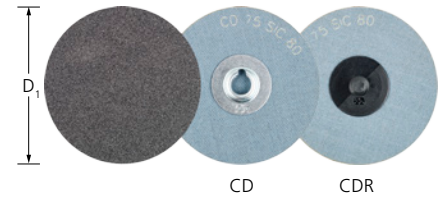
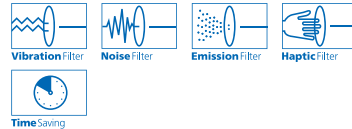
Abrasive:

Silicon carbide SiC

Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



	D ₁ [Inches]	Grit and EDP number					Opt. RPM	
		36	60	80	120	240		
CD system 								
	2	42415	42416	42417	42418	42419	3,800–13,000	100
	3	42420	42421	42422	42423	42424	2,500–9,000	50
CDR system 								
	2	42750	42751	42752	42753	42754	3,800–13,000	100
	3	42755	42756	42757	42758	42759	2,500–9,000	50

Diamond

Highly recommended for work on wear-resistant coatings and for hard facings made of tungsten carbide, chromium carbide, titanium carbide, etc. Recommended for work on materials used for aircraft engine construction, e.g. HASTELLO® and INCONEL® and titanium/titanium alloys. Also highly recommended for work on extremely hard materials such as tungsten carbide, glass, ceramics, enamel, stone and carbon-reinforced plastic (CRP)/glass reinforced plastic (GRP).

Abrasive:

Diamond (D)

D 251 = P 60

D 126 = P 120

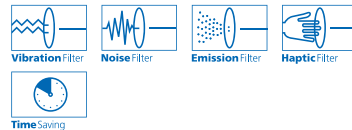
D 76 = P 220

(P = Grit size according to ISO 6344)

Ordering notes:

- Grit sizes are indicated in µm.
- Please order backing pad separately. See page 17.

PFERDVALUE®:



	D ₁ [Inches]	Grit and EDP number			Opt. RPM	
		D 251 / P 60	D 126 / P 120	D 76 / P 220		
CD system 						
	1	40515	40516	40517	7,500–15,000	10
	1-1/2	40518	40519	40520	5,000–10,000	10
	2	40521	40522	40523	3,800–7,500	10
	3	40524	40525	40526	2,500–5,000	10
CDR system 						
	1	40655	40656	40657	7,500–15,000	10
	1-1/2	40658	40659	40660	5,000–10,000	10
	2	40661	40662	40663	3,800–7,500	10
	3	40664	40665	40666	2,500–5,000	10

COMBIDISC® quick-change discs

Abrasive discs – RS type

RS type

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

Advantages:

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

Recommendations for use:

- Move the product to the location to be worked. To grind, do not push it onto the surface, pull it towards yourself.
- To ensure optimum utilization of the grinding surface using the abrasive disc holder EDP 42454.
- Always use the RS abrasive discs at the specified optimum rotational speed and do not adhere to the maximum permitted rotational speeds of the holder EDP 42454.



RS aluminium oxide A-PLUS

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

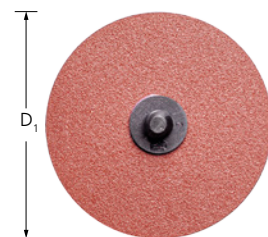
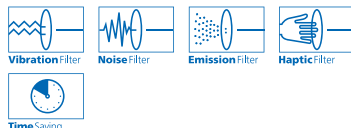
Abrasive:

Aluminium oxide A-PLUS

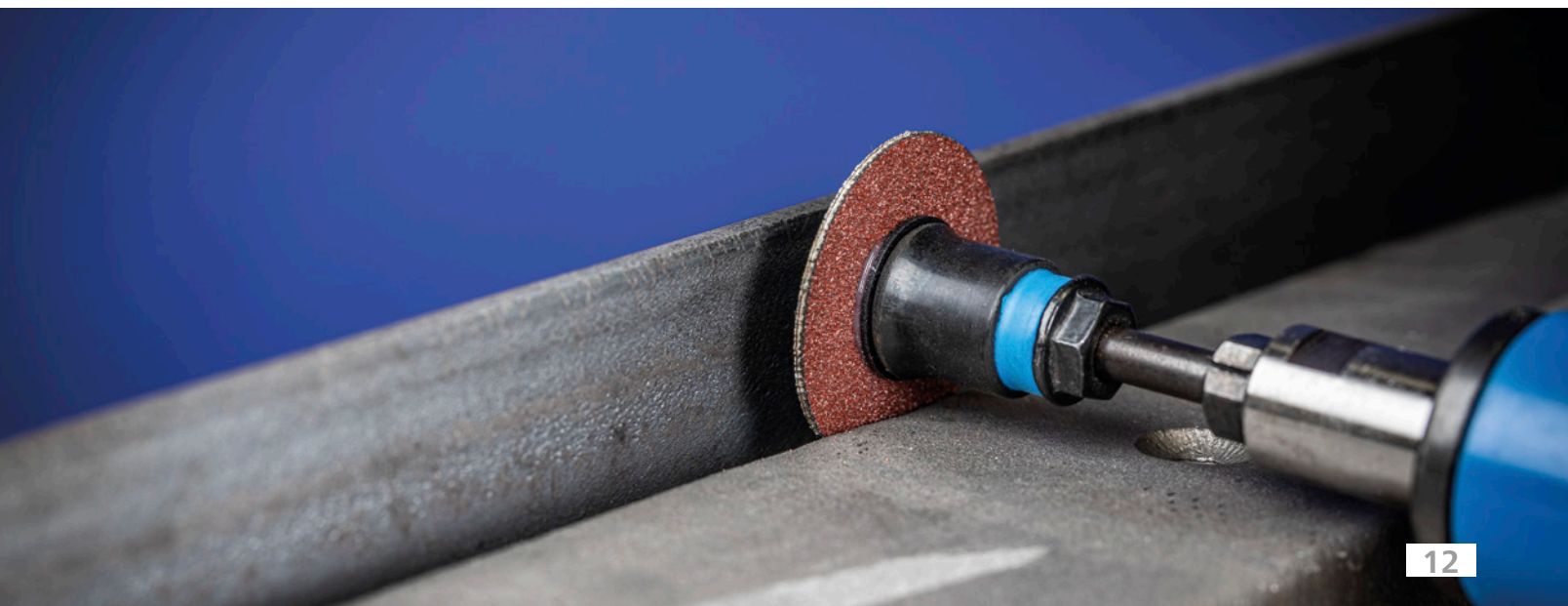
Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



D ₁ [Inches]	Grit and EDP number			Opt. RPM	
	60 PLUS	80 PLUS	120 PLUS		
CDR system 					
1-1/2	40600	40601	40602	10,000–16,000	100
2	40603	40604	40605	8,000–13,000	100
3	40606	40607	40608	5,000–9,000	50



COMBIDISC® quick-change discs

Abrasive discs – RS type

Midget fibre discs RS ceramic oxide grain CO-COOL

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

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

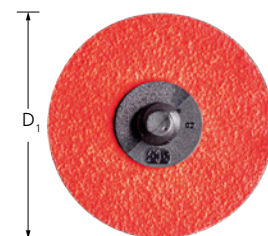
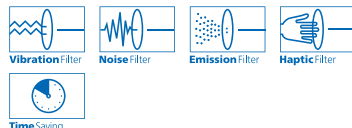
Abrasive:

Ceramic oxide grain CO-COOL

Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



D ₁ [Inches]	Grit and EDP number			Opt. RPM	
	50	80	120		
CDR system 					
1-1/2	40570	40571	40572	10,000–16,000	100
2	40573	40574	40575	3,800–13,000	100
3	40576	40577	40578	2,500–9,000	50

RS silicon carbide SiC

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

Particularly recommended for use on titanium alloys.

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

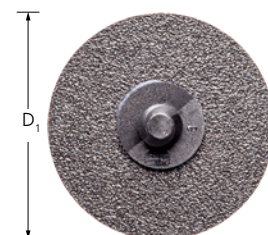
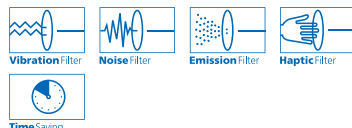
Abrasive:

Silicon carbide SiC

Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



D ₁ [Inches]	Grit and EDP number			Opt. RPM	
	60	80	120		
CDR system 					
1-1/2	40585	40586	40587	10,000–16,000	100
2	40588	40589	40590	3,800–13,000	100
3	40591	40592	40593	2,500–9,000	50



COMBIDISC® quick-change discs

Non-woven discs

POLICLEAN® PLUS discs

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

POLICLEAN® PLUS discs exhibit a higher stock removal rate with a very long service life.

Applications:

roughing, surface work, cleaning

Abrasive:

Aluminum oxide A

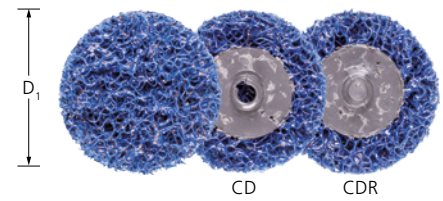
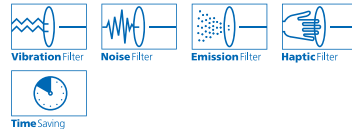
Recommendations for use:

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

Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



	D ₁ [Inches]	EDP number	Opt. RPM	
CD system 				
	2	44840	5,500–8,000	10
	3	44841	3,800–5,000	10
CDR system 				
	2	44842	5,500–8,000	10
	3	44843	3,800–5,000	10

Surface conditioning, hard type

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

Applications:

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

Abrasive:

Aluminum oxide A

Available POLIVLIES® grit sizes:

- 100 C = coarse (yellow-brown)
- 180 M = medium (red-brown)
- 240 F = fine (blue)

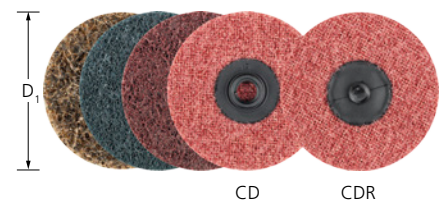
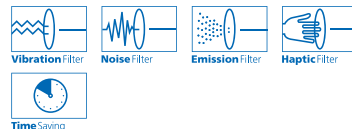
Recommendations for use:

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

Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



D ₁ [Inches]	Grit, type and EDP number			Opt. RPM	
	100 C	180 M	240 F		
CD system					
1-1/2	43176	43177	43179	7,000–10,000	50
2	43180	43181	43183	5,500–7,500	50
3	43184	43185	43187	3,800–5,000	25
CDR system					
1-1/2	43234	43235	43237	7,000–10,000	50
2	43238	43239	43241	5,500–7,500	50
3	43242	43243	43245	3,800–5,000	25
4	43246	43247	43248	2,850–4,000	25

COMBIDISC® quick-change discs

Non-woven discs

Finishing, soft type

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

Applications:

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

Abrasive:

Aluminum oxide A
Available POLINOX® grit sizes:
100 = medium
180 = fine
280 = very fine

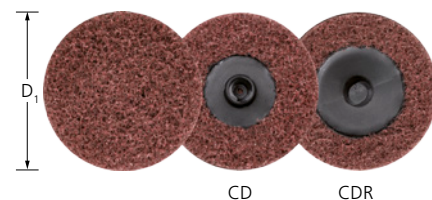
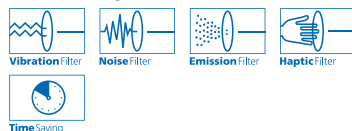
Recommendations for use:

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

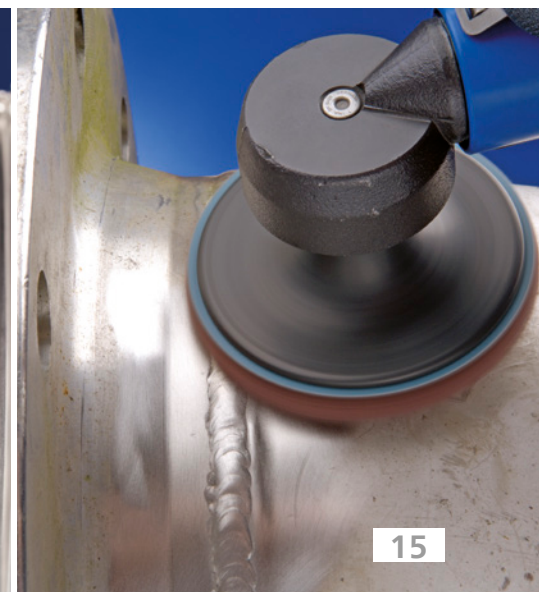
Ordering notes:

- Please order backing pad separately. See page 17.

PFERDVALUE®:



D ₁ [Inches]	Grit and EDP number			Opt. RPM	
	100	180	280		
CD system					
2	43200	43201	43203	5,500–7,500	50
3	43204	43205	43207	3,800–5,000	25
CDR system					
2	43258	43259	43261	5,500–7,500	50
3	43262	43263	43265	3,800–5,000	25



COMBIDISC® quick-change discs

Non-woven discs



Unitized discs

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

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

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

Applications:

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

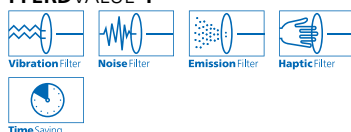
Abrasive:

Aluminum oxide A
Silicon carbide SiC

Ordering notes:

- Further information on unitized products can be found in our Tool Manual 23, catalog section 4, on page 85–86.
- Please order backing pad separately. See page 17.
- All discs have a thickness of 1/4".

PFERDVALUE®:



D [Inches]	Abrasives	Grit size	Hardness	Spec	EDP number	Opt. RPM	Max. RPM	
CD system 								
2	SiC	fine	W	2SF	48430	9,500	19,100	25
	A	coarse	W	2AM	48431	9,500	19,100	25
	SiC	fine	MH	6SF	48434	9,500	19,100	25
	A	fine	MH	6AF	48435	9,500	19,100	25
	A	fine	H	8AM	48438	9,500	19,100	25
	A	coarse	H	8AC	48439	9,500	19,100	25
3	SiC	fine	W	2SF	48440	6,400	12,500	25
	A	coarse	W	2AM	48441	6,400	12,500	25
	SiC	fine	MH	6SF	48444	6,400	12,500	25
	A	fine	MH	6AF	48445	6,400	12,500	25
	A	fine	H	8AM	48448	6,400	12,500	25
	A	coarse	H	8AC	48449	6,400	12,500	25
CDR system 								
2	SiC	fine	W	2SF	48450	9,500	19,100	25
	A	coarse	W	2AM	48451	9,500	19,100	25
	SiC	fine	MH	6SF	48454	9,500	19,100	25
	A	fine	MH	6AF	48455	9,500	19,100	25
	A	fine	H	8AM	48458	9,500	19,100	25
	A	coarse	H	8AC	48459	9,500	19,100	25
3	SiC	fine	W	2SF	48460	6,400	12,500	25
	A	coarse	W	2AM	48461	6,400	12,500	25
	SiC	fine	MH	6SF	48464	6,400	12,500	25
	A	fine	MH	6AF	48465	6,400	12,500	25
	A	fine	H	8AM	48468	6,400	12,500	25
	A	coarse	H	8AC	48469	6,400	12,500	25

COMBIDISC® quick-change discs

Felt discs



Felt discs

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

Applications:
polishing

Recommendations for use:

- For the best results, use at a recommended speed of 1,000–2,000 SFPM. This provides an ideal compromise between polishing performance, thermal load on the work-piece and disc wear.
- When applying a different polishing paste, use a new, unused felt disc.

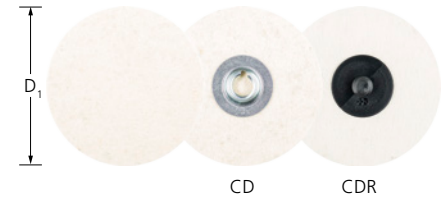
Ordering notes:

- Further information on felt products can be found in our Tool Manual 23, catalog section 4, on page 115.
- Please order backing pad and polishing paste separately. See page 17 and in our Tool Manual 23, catalog 4, page 121.

Accessories:

- Grinding and polishing pastes

PFERDVALUE®:



	D ₁ [Inches]	EDP number	Opt. RPM	
CD system 				
	2	43215	2,000–4,000	10
	3	43216	1,200–2,500	10
CDR system 				
	2	43213	2,000–4,000	10
	3	43214	1,200–2,500	10

Backing pads

Backing pads

Matching backing pads for COMBIDISC® quick-change discs. Available in three different hardness grades.

PFERDVALUE®:



D [Inches]	S [Inches]	EDP number		Max. RPM	
		Type CD 	Type CDR 		
Soft					
1-1/2	1/4	42108	42456	20,000	1
2	1/4	42111	42459	20,000	1
3	1/4	42114	42462	12,000	1
Medium					
1	1/4	42106	42454	40,000	1
1-1/2	1/4	42109	42457	25,000	1
2	1/4	42112	42460	25,000	1
3	1/4	42115	42463	20,000	1
4	1/4	-	42465	10,000	1
Hard					
1-1/2	1/4	42110	42458	30,000	1
2	1/4	42113	42461	30,000	1
3	1/4	42116	42464	20,000	1

COMBIDISC® quick-change discs

Sets



Advantages:

- Getting to know and testing the comprehensive system.

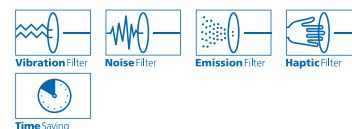
Abrasive:

- Aluminum oxide A
- Silicon carbide SiC

Recommendations for use:

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

PFERDVALUE®:



COMBIDISC® prep-to-paint set

Prep-to-paint set includes a selection of coated and non-woven abrasives for removal of surface imperfections such as rust, loose paint or cold drawn mill scale. Selected discs leave the proper surface finish for excellent wet and dry paint and coating adhesion.

Contents of 2" CDR prep-to-paint set

- | | |
|---|---|
| <p>1 pc. each of:</p> <ul style="list-style-type: none"> ■ EDP 42460 – 2" CDR backing pad – medium ■ EDP 42913 – 2" CDR Mini-POLIFAN® disc A/O 60 grit ■ EDP 44842 – 2" CDR POLICLEAN® PLUS disc | <p>4 pcs. of:</p> <ul style="list-style-type: none"> ■ EDP 42506 – 2" CDR abrasive discs A/O 80 grit ■ EDP 43239 – 2" CDR surface conditioning discs medium |
|---|---|



Type	Full set EDP number	
Prep-to-paint, 2" CDR attachment	42789	1

COMBIDISC® sanitary finish set

Sanitary finish set includes a selection of coated and non-woven abrasives designed to achieve the industry standard for a sanitary finish.

Contents of 2" CDR sanitary finish set

- | | |
|--|---|
| <p>1 pc. each of:</p> <ul style="list-style-type: none"> ■ EDP 42460 – 2" CDR backing pad – medium ■ EDP 42913 – 2" CDR Mini-POLIFAN® disc A/O 60 grit | <p>6 pcs. of:</p> <ul style="list-style-type: none"> ■ EDP 42506 – 2" CDR abrasive discs A/O 80 grit ■ EDP 43239 – 2" CDR surface conditioning discs medium |
|--|---|



Type	Full set EDP number	
Sanitary finish, 2" CDR attachment	42790	1

COMBIDISC® mirror finish set

Mirror finishing set includes the required components to proceed from raw material removal to a full reflective surface.

Contents of 2" CDR mirror finishing set

- | | |
|---|--|
| <p>1 pc. each of:</p> <ul style="list-style-type: none"> ■ EDP 42460 – 2" CDR backing pad – medium ■ EDP 42913 – 2" CDR Mini-POLIFAN® disc A/O 60 grit ■ EDP 43213 – 2" CDR felt disc ■ EDP 48765 – Small bar pre-polishing paste (green) | <p>2 pcs. of:</p> <ul style="list-style-type: none"> ■ EDP 48454 – 2" CDR unitized disc medium hard SiC fine <p>3 pcs. of:</p> <ul style="list-style-type: none"> ■ EDP 43239 – 2" CDR surface conditioning discs medium |
|---|--|



Type	Full set EDP number	
Mirror finish, 2" CDR attachment	42791	1