

PEGATEC Family Products



SUPER DIABLO Double Performance+
HIGH PERFORMANCE CERAMIC

ULTIMATE
HIGH PERFORMANCE ZIRCONIA



DEMON
EXCELLENT ZIRCONIA

PEGASTAR
COST-EFFECTIVE ZIRCONIA FLAP DISC

Featured Products



PEGATEC WIRE BRUSHES



PEGATEC DIAMOND BLADE



PEGATEC TCT SAW BLADE



PEGATEC FINE POLISHING PRODUCTS

 <p>Augenschutz benutzen Wear safety goggles or glasses porter des lunettes utilizar protección para los ojos usare visiere od ociali per proteggere gli occhi Koruyucu Gözlük Kullanın Používejte ochranu očí Pn práci chrante oči Stosować okulary ochronne</p>	 <p>Staubmaske anlegen wear a dust mask porter un masque anti-poussières utilizar mascarilla antipolvo usare una maschera antipolvere Toz maskesi takınız Noste ochrannou masku proti prachu zalożyć maskę przeciwpylową</p>
 <p>Gehörschutz benutzen use ear muffs porter un casque anti-bruit utilizar protección para oídos portare una cuffia antirumore o protezioni equivalenti Koruyucu kulaklık kullanınız Používejte ochranu sluchu Stosować środki ochrony sluchu</p>	 <p>Handschuhe tragen wear safety gloves to protect the hands porter des gants usar guantes de seguridad usare guanti di sicurezza per proteggere le mani Eldiven takınız Noste ochranné rukavice nosić rękawice</p>
 <p>Sicherheitsempfehlungen beachten read the operating instructions lire la notice observar las medidas de seguridad leggere le istruzioni Güvenliğinizi için Tavsiyelere Uyun Respektujte doporučení k zajištění bezpieczeństwa práce przestrzegać zaleceń dotyczących bezpieczeństwa</p>	 <p>nicht zulässig für Seitenschleifen do not use for side grinding ne pas utiliser pour meulage sur le côté de la meule non utilizzare per la molatura laterale No es admisible para el desbarbe lateral Yandan playalama için kullanılmaz Neni dovoleno bočni broušení Nie używać do szlifowania</p>

Safety Indications:
You have purchased a high quality product. For your own safety and for optimum use of this especially thin Cut-off Wheel, you should comply with the following safety recommendations:

- Examine wheel prior to use for any possible damages
- Do not modify the wheel in any way
- Carefully watch proper mounting
- **Wear protective clothing**
- **Do not use wheel for grinding/fettling**
- **Do not put any load to the wheel sideways**
- Do not exceed the permissible speed
- Avoid too much pressure
- Avoid strokes
- Assure dry storage
- European Norm EN 12413

Product Characteristics

- fast cutting
- long life
- economical
- low cutting pressure
- low material waste

Machines
most popular angle grinders, also suitable for low performance machines.
Maximum operating speed: 80 m/s

Applications

- Thin plate
- Thin walled profiles and tubes of stainless steel, normal steel and non-ferrous metals
- Small cross section cuts on metal rods and wires
- Composites such as glass fibre (GRP)
- Engineering and plant construction
- Car body works
- Cladding panels
- Interior installation
- General sheet metal working

Renseignements de sécurité:
Vous avez acquis un produit de haute qualité. Pour votre propre sécurité et pour l'utilisation optimale de ce disque à tronçonner extrêmement mince les renseignements de sécurité suivants sont à respecter:

- Avant l'utilisation vérifier des endommagements éventuels
- Ne pas effectuer des modifications sur le disque
- Faire attention à un montage parfait
- **Porter des vêtements de protection**
- **Jamais utiliser le disque pour travaux de meulage**
- **Ne pas soumettre le disque à des charges latérales**
- Ne pas dépasser le nombre de tours admissible
- Éviter une pression d'appui trop forte
- Ne pas soumettre le disque à des coups
- Stocker les disques au sec
- Ainsi que la norme européenne EN 12413.

Caractéristiques du produit

- bonne coupe
- longévité accrue
- économique
- nécessite peu de puissance
- pas de bavures

Machines
Meuleuses d'angle standard, également adapté pour machines de faible puissance.
Vitesse de coupe maximum: 80 m/s

Utilisation et domaines d'application

- tôles fines
- profils fins et tubes en inox, acier et métaux non ferreux
- petites coupes transversales de barres et fils métalliques
- matériaux composites et fibres de verre
- construction d'appareils et accessoires
- travaux de carrosserie
- constructions métalliques
- agencement
- tôlerie en général

Instrucciones de seguridad
Ha adquirido un producto de alta calidad. Para su propia seguridad y para un uso óptimo debe respetar las siguientes recomendaciones de seguridad referiendo a la aplicación del disco de tronzado especialmente fino:

- Antes de usarlo verificar si el disco tiene algún defecto
- No efectuar modificaciones en el disco
- Prestar atención a la sujeción correcta
- **Poner correspondientes vestidos protectores**
- **De todos modos no aplicar el disco para desbarbar**
- **No meter el disco a cargos laterales**
- No pasar de la revoluciones por minuto admisibles
- Evitar presión de aplicación demasiado fuerte
- Evitar golpes en el disco
- Almacenar en (sitios) seco(s)
- Europea EN 12413.

Caracteres del producto

- corte de alta potencia
- larga dureza de vida
- a buen precio
- ahorra esfuerzos
- poca formación de babas

Aplicaciones y campos de empleo

- Chapas finas
- Perfiles de paredes finas y tubos de acero inoxidable, de acero normal y de metales no-ferrosos
- Pequeños cortes transversales en varillas e hilos de metal
- Materiales compuestos (p. ej. plástico reforzado de vidrio de fibra)
- Construcción de aparatos y de instalaciones
- Construcción de carrocería
- Construcción de fachadas
- Obras interiores
- Trabajos en chapa en general


Máquinas
Amoladoras angulares corrientes en el comercio, también apropiados para máquinas de bajo rendimiento.
Velocidad máxima admisible: 80 m/s

RECOMMENDED PRACTICE
PORTABLE GRINDERS
GRINDING Rough Work

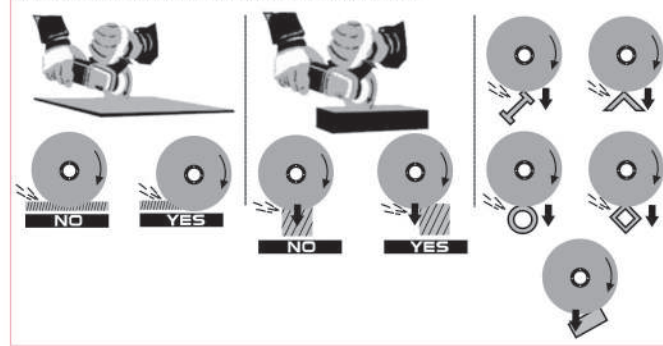
- Do not use a cutting-off wheel for snagging
- Do not work with the side of a wheel you will cut the Reinforcing cloths
- Work at an angle of 10 to 30° with a longitudinal action

GRINDING Finishing Work

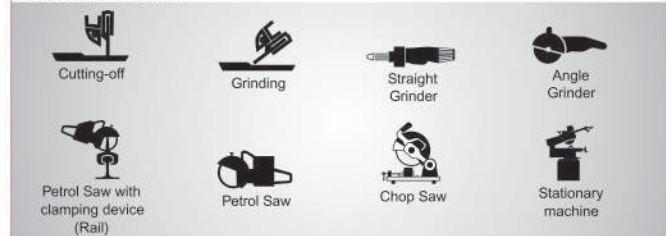
- Angle of work 15°
- Rotary action



CUTTING-OFF
■ Arrange the workpiece so that a uniform section can be cut



MACHINE PICTOGRAMS



GETTING THE BEST FROM YOUR CUTTING-OFF & GRINDING WHEELS

- Decide which material is cut most and that you select the most suitable Winking wheel in accordance with the application chart in this chapter. To use the right wheel for the right material is very important for the life and cutting/grinding behaviour of the wheel
- Check if the machine is operating correctly and that the machine does not exceed the speed that is indicated on the wheel
- Use the wheel at the recommended speed indicated on the wheel and the maximum operating speed chart that you will find later in this chapter

The trouble shooting guide can easily help you recognise and solve problems.

TROUBLE SHOOTING CUTTING OFF WHEELS

Wheel does not cut	
Cause	in case of blue cutting: wheel too hard or too thick
Solution	use softer or Winking Thin Cut wheels, check peripheral speed
Cause	peripheral speed too low
Solution	increase rpm up to max. (80m/sec)
Excessive wear	
Cause	in case of white cutting edge: wheel too soft
Solution	use harder wheel
Cause	operating speed too low
Solution	increase rpm up to max (80m/sec)

TROUBLE SHOOTING GRINDING WHEELS

Excessive wear	
Cause	decrease of rpm during cutting
Solution	use machine with more power, reduce pressure on the machine
Crumbled wheel edge	
Cause	cutting-off wheel used for grinding operations
Solution	use a grinding wheel for grinding operations
Cause	workpiece is moving
Solution	clamp the workpiece properly
Cause	too much side-pressure
Solution	add only the radial pressure to the wheel
Arborhole or centre break out	
Cause	wheel sticks in the workpiece/material
Solution	use more radial pressure and swing the wheel forwards and backwards
Cracks on the bottom of the wheel	
Cause	cutting-off wheel used for grinding operations
Solution	use a grinding wheel for grinding operations
Cause	too much side pressure
Solution	add only the radial pressure to the wheel
Cause	different diameter top/bottom flange
Solution	use flanges with the same diameter

TROUBLE SHOOTING GRINDING WHEELS

Wheel does not grind	
Cause	wheel too hard, wheelglazing
Solution	use softer wheel
Cause	not enough pressure
Solution	increase pressure
Cause	machine power too low
Solution	use machine with more power
Cause	loading and wheelglazing (non-ferrous)
Solution	use Winking Alu wheels which counteracts loading and wheelglazing
Excessive wheel wear	
Cause	wheel too soft
Solution	use harder wheel
Cause	too much pressure
Solution	reduce pressure, let the wheel do the grinding
Cause	decrease of peripheral speed
Solution	use machine with more power, reduce pressure on the machine
Cause	too low peripheral speed
Solution	max. 80m/sec is optimum speed

TROUBLE SHOOTING GRINDING WHEELS

Crumbled wheel edge	
Cause	grinding angle too flat
Solution	change angle to 30 - 40°
Cause	workpiece is moving
Solution	clamp the workpiece properly
Cause	too much pressure
Solution	reduce pressure, let the wheel do the grinding
Cracks on the bottom of the wheel	
Cause	contact area too large
Solution	reduce contact area
Cause	too much pressure
Solution	reduce pressure, let the wheel do the grinding
Unbalance	
Cause	dirty flanges
Solution	clean flanges
Cause	wheel mounting insecure
Solution	tighten flanges
Cause	flanges with different diameter
Solution	replace flanges

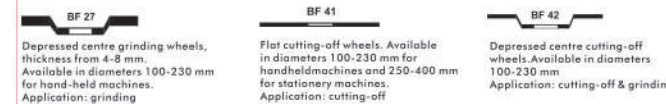
SAFETY ADVICE-DO'S

- ✓ Do always handle and store wheels carefully. Cutting-off wheels should be stacked horizontally and flat, preferably on a steel base plate. Depressed centre wheels should be placed on top of each other or stored in the original packaging.
- ✓ DO always have machine speeds checked regularly, especially after maintenance or repair. Machines fitted with speed control devices (Governors), must be properly maintained at all times.
- ✓ DO always use a portable machine in a comfortable position, where the workpiece is well balanced and the machine is well supported.
- ✓ DO keep the working area around cutting and grinding operations clear. It is very dangerous if an operator trips and falls with an operating machine in his hands.

SAFETY ADVICE-DON'TS

- ✗ DON'T EVER exceed the maximum operating speed marked on the wheel.
- ✗ DON'T use a machine which is not in good mechanical condition.
- ✗ DON'T allow the wheel to be trapped or pinched in the cut.
- ✗ DON'T grind on the side of cutting-off wheels or depressed centre wheels below 4.0 mm thickness.

SHAPE SPECIFICATION SYSTEM



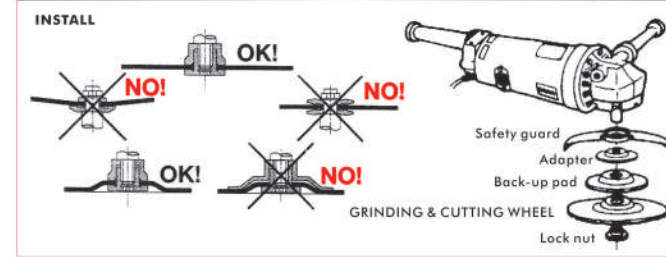
Depressed centre grinding wheels, thickness from 4-8 mm. Available in diameters 100-230 mm for hand-held machines. Application: grinding

Flat cutting-off wheels. Available in diameters 100-230 mm for handheld machines and 250-400 mm for stationary machines. Application: cutting-off

Depressed centre cutting-off wheels. Available in diameters 100-230 mm. Application: cutting-off & grinding

DIRECTION FOR ATTACHMENT AND USE

INSTALL



NO! NO! NO! NO! OK! OK!

Safety guard
Adapter
Back-up pad
GRINDING & CUTTING WHEEL
Lock nut