



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

The belts listed are popular stock sizes, but additional sizes, specifications, and backing materials, are available made-to-order.

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.

Size Range:

1" to 10" wide, 36" to 132" long

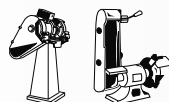
Grit Range:

24 – 320

Abrasive Grain:

Ceramic Alumina, Zirconia Alumina, Aluminum Oxide

Machine Used:



CROSS REFERENCE GUIDE

| | BEST | BEST | BETTER | BETTER | BETTER | BETTER | GOOD |
|---------------|---|-------------------------------------|-----------------------------|----------------|---|---|---|
| NORTON | Blaze R980P | Norton SG R981 | BlueFire R887P | BlueFire R821P | BlueFire R823P | BlueFire R884P | Metalite R228 |
| 3M | 987F1, 977F, 777F, 967F, 963G, 963H, 984F | 987F1, 977F, 777F, 967F, 963G, 963H | 577F, 567G, 777F 977F | 561D | 561F Y, 551E XE 741A, 741E, 761D | 561D, 561F, 563F 741A, 741E, 761D 761F | 240DZ OPK, 270DZ OPK, 241D, 248D, 251D, 341I Imperial, 351D |
| Hermes | CR456 | CR456 | RB486X, RB486Y – RB426-23MX | | RB486 X, RB346-23MX RB426-23MX, RB484TY RB486XF | RB484TY, RB486Y, RB346-23MX, RB426-23MX RB480-21MX, CB440Y, RB486XY | RB3160P RB317LX RB346MX |
| Klingspor | CS612YY, CS610YY | CS612YY, CS610YY | CS409Y | CS411Y | CS411X | CS411Y | CS311X, CS310, CS410 |
| SIA | – | – | – | – | – | 2800, 2803, 2929 | 2903XO, 2905X, 2920X |
| VSM | SK840X, SK750X | SK840X, SK750X | KK815Y, ZK744X | – | KK715X | KK716Y, ZK713X | KK511X, KK711 |

MATERIAL-TO-PRODUCT RECOMMENDATION GUIDE

| | BEST Highest Productivity. Lowest Total Cost. | BETTER Excellent Blend of Performance & Price. | GOOD Consistent Performance. Low Initial Price. |
|----------------------------|--|---|--|
| Aluminum | – | Norton BlueFire R884P/R823P | Norton R766 |
| Cast Iron | Norton Blaze R980P | Norton BlueFire R823P | Norton R766 |
| Brass / Bronze | – | Norton BlueFire R884P/R823P | Norton R766 |
| Die Castings | Norton Blaze R980P | Norton BlueFire R823P | Norton R766 |
| Carbon Steel | Norton Blaze R980P | Norton BlueFire R823P | Norton R766 |
| Glass / Ceramics | Norton Blaze R980P | Norton BlueFire R821P | Norton R766 |
| Stainless Steel and Alloys | Norton Blaze R980P | Norton BlueFire R823P/R887P | Norton R766 |
| Wood | – | Norton BlueFire R831/R884P | Norton R766 |

GRIT SELECTION RECOMMENDATION GUIDE

| STOCK REMOVAL | INTERMEDIATE | FINISHING |
|---------------|---------------|----------------|
| 24 – 50 grit | 60 – 100 grit | 120 – 320 grit |

NORTON BLAZE R980P CERAMIC ALUMINA

BEST FOR MILD AND CARBON STEEL, STAINLESS, COBALT, CHROME, INCONEL, TITANIUM

FEATURES & BENEFITS

- Cooler cutting Norton SG ceramic abrasive grain lasts 50% to 200% longer on mild and carbon steel, stainless, cobalt, chrome, Inconel and titanium versus aluminum oxide belts
- Cuts 20% faster than the current generation of grinding belts
- Longer belt life, better metal integrity, greater productivity; lowest total grinding costs
- Y-weight polyester waterproof cloth backing provides edge-fray resistance, and offers excellent body retention during use for more consistent grinding throughout belt life
- Durable resin bond system
- Significantly improved belt life due to better grain adhesion
- Advanced "supersize" grinding lubricant
- Cooler cutting during the life of the belt
- Improved part finish and integrity



NORTON SG R981 CERAMIC ALUMINA

EXCEPTIONAL PERFORMANCE, ESPECIALLY ON HARD-TO-GRIND ALLOYS

FEATURES & BENEFITS

- Norton SG ceramic abrasive provides exceptional life and value, especially on hard-to-grind alloys
- Grinding-aid enhanced for longer life, cooler cut
- Strong Y-weight polyester, waterproof cloth backing for improved grain adhesion, reduced edge-fray and better body retention, resulting in longer life and product consistency



NORTON BLUEFIRE R884P/R823P ZIRCONIA ALUMINA

BETTER CHOICE FOR HEAVIEST-PRESSURE APPLICATIONS

FEATURES & BENEFITS

- Premium self-sharpening zirconia alumina abrasive provides aggressive, rapid cut rate
- R884P – Durable Y-weight polyester, waterproof cloth backing has excellent grain adhesion, reduced edge-fray and better body retention, resulting in longer life and product consistency
- R823P – Strong X-weight waterproof polyester backing is more flexible than R884P and available in finer grit sizes
- R821P Smooth-running Y-weight cotton backing provides extended durability and even wear on coarser grit stock removal applications



NORTON R766 ALUMINUM OXIDE

GOOD CHOICE FOR DIFFICULT-TO-GRIND MATERIALS (ALUMINUM, BRASS, BRONZE, STAINLESS, CARBON STEEL, TITANIUM, ETC.)

FEATURES & BENEFITS

- Premium aluminum oxide abrasive blend is ideal when purchasing criteria is a good-performing, economically-priced, general-purpose belt
- Durable resin bond system provides good edge retention and life versus key competitors
- Y-weight waterproof polyester backing withstands light- to moderately-demanding applications and provides extended life on dry grinding applications



TECH TIP

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 |

| Problem | Correction |
|---------------|---|
| Belt breakage | Reduce belt tension |
| | Use less aggressive contact wheel |
| | Check tracking mechanism for belts tracking erratically |

1" to 6" wide, 36" to 72" long



| | | | | | |
|------------|--------------------|-----------------------|-----------------------|----------------------|----------------------|
| TIER: | BEST | BETTER | BETTER | GOOD | GOOD |
| BRAND: | Norton | Norton | Norton | Norton | Norton |
| TRADENAME: | BLAZE R980P | BLUEFIRE R821P | BLUEFIRE R823P | R766 | METALITE R228 |
| ABRASIVE: | Ceramic Alumina | Zirconia Alumina | Zirconia Alumina | Aluminum Oxide Blend | Aluminum Oxide |
| BACKING: | Y-Weight Polyester | Y-Weight Cotton | X-Weight Polyester | Y-Weight Polyester | X-Weight Cotton |
| OTHER: | Supersize | | | | |

| SIZE (W x L) | GRIT | STD. PKG. | PART # | PART # | PART # | PART # | PART # |
|--------------|------|-----------|-------------|-------------|-------------|-------------|-------------|
| 1 x 42 | 36 | 50 | 66254476825 | | | | 78072791710 |
| | 40 | 50 | 69957345887 | 78072726905 | | 66623390041 | 78072720910 |
| | 50 | 50 | 66254476826 | 78072726904 | | 66623390042 | 78072720905 |
| | 60 | 50 | 69957345486 | 78072726903 | 78072728596 | 66623334502 | 78072720900 |
| | 80 | 50 | 66261041539 | 78072726902 | 78072728594 | 66623390043 | 78072720895 |
| | 100 | 50 | 66261043462 | | 78072728592 | | 78072720890 |
| | 120 | 50 | 66261038660 | | 78072728590 | | 78072720885 |
| | 150 | 50 | | | 78072728588 | | 78072720880 |
| | 180 | 50 | | | 78072728586 | | 78072720875 |
| | 220 | 50 | | | 78072700001 | | 78072720871 |
| | 240 | 50 | | | | | 78072720870 |
| | 320 | 50 | | | | | 78072720865 |
| 1-1/2 x 60 | 36 | 10 | 69957345578 | | | | 78072721060 |
| | 40 | 10 | 63642595003 | | | | |
| | 50 | 10 | 69957345664 | | | 66623390044 | 78072787807 |
| | 60 | 10 | 69957345631 | | | 66623390045 | |
| | 80 | 10 | 69957345579 | | | 66623390046 | |
| | 100 | 10 | | 78072765077 | | | 69957351736 |
| | 120 | 10 | 66261056493 | 78072726984 | | | |
| | 180 | 10 | | 78072758464 | | | |
| 2 x 48 | 220 | 10 | | 78072708871 | | | |
| | 24 | 10 | | | | | 78072726130 |
| | 36 | 10 | 63642592057 | 78072727103 | | 66623390047 | 78072721255 |
| | 40 | 10 | 69957345193 | 78072727102 | | 66623390048 | 78072721250 |
| | 50 | 10 | 69957346716 | 78072727101 | | 66623390049 | 78072721245 |
| | 60 | 10 | 69957344423 | 78072727100 | 78072728621 | 66623390050 | 78072721240 |
| | 80 | 10 | 69957345100 | 78072727099 | 78072728619 | 66623390051 | 78072721235 |
| | 100 | 10 | 66261052522 | | 78072728617 | | 78072721230 |
| | 120 | 10 | 66261052520 | | 78072728615 | | 78072721225 |
| | 150 | 10 | | | 78072728613 | | 78072723246 |
| | 180 | 10 | | | 78072728611 | | 78072721223 |
| | 220 | 10 | | | 78072728609 | | 78072763677 |
| 2 x 60 | 320 | 10 | | | | | 78072746387 |
| | 24 | 10 | | | | | 66261054787 |
| | 36 | 10 | 69957345196 | | | 66623390052 | 78072701170 |
| | 40 | 10 | 69957394425 | 78072727124 | | 66623390053 | 78072721300 |
| | 50 | 10 | 69957346149 | | | 66623390054 | 78072762537 |
| | 60 | 10 | 69957344901 | 78072727122 | | 66623390055 | 78072721290 |
| | 80 | 10 | 63642592574 | 78072727121 | | 66623390056 | 78072721285 |
| | 100 | 10 | 66261052222 | | 66261082976 | | 78072721280 |
| | 120 | 10 | 66261042738 | | 78072761958 | | |
| | 150 | 10 | | | | | 78072744018 |
| | 180 | 10 | | | 78072702695 | | 78072720441 |
| | 220 | 10 | | | 78072706282 | | 78072744020 |
| 2 x 72 | 240 | 10 | | | | | 78072761862 |
| | 320 | 10 | | | | | 78072702825 |
| | 24 | 10 | 66254433969 | | | | |
| | 36 | 10 | 69957345460 | 78072727147 | | 66623390057 | 78072721335 |
| | 40 | 10 | 69957346729 | 78072727146 | | 66623390058 | 78072721332 |
| | 50 | 10 | 69957344966 | 78072727145 | | | 78072784894 |
| | 60 | 10 | 69957345157 | 78072727144 | 78072728645 | 66623390060 | 78072721325 |
| | 80 | 10 | 69957344961 | 78072727142 | 78072728643 | 66623334237 | 78072721320 |
| | 100 | 10 | 66261041897 | | 66261025537 | | 78072723235 |
| | 120 | 10 | 66261044095 | | 78072728639 | | 78072721318 |
| | 150 | 10 | | | 78072761770 | | 78072761973 |
| | 180 | 10 | | | 78072763853 | | 78072718488 |
| | 220 | 10 | | | 78072728633 | | 78072765601 |
| | 320 | 10 | | | | | 78072721308 |

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