

**SMALL DIAMETER
REINFORCED CUT-OFF**



NORTON
SAINT-GOBAIN
NORZON
PLUS

NORTON
SAINT-GOBAIN
BLUEfire™

NORTON
SAINT-GOBAIN
GEMINI®



CATEGORY DEFINITION

The Norton small diameter cut-off wheel line consists of Type 01/41 straight and Type 27/42 depressed center cut-off wheels from 1-1/2" to 9" diameters. These wheels come in ultra thin .035" for quick burn-free and burr-free cutting to .125" for more durable applications. All are reinforced for the demanding nature of portable cut-off.

- APPLICATIONS:** Cutting sheet metal, cutting pipe, and metal plate dimensioning (metal fabrication)
- SIZE RANGE:** 1-1/2" - 9" diameter
- THICKNESS RANGE:** .035, .040, .045, .060, .090, and .125
- ABRASIVE GRAIN:** Ceramic Alumina/Zirconia Alumina, Zirconia Alumina/Aluminum Oxide, Aluminum Oxide, Silicon Carbide
- SHAPE:** Type 01/41 Straight and Type 27/42 Depressed Center

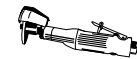
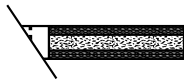


TYPE-TO-APPLICATION RECOMMENDATION GUIDE

WHEEL TYPE/THICKNESS APPLICATIONS

TYPE 01/41

Type 01/41 cut-off wheels are designed for traditional cut-off applications. All are supplied with full fiberglass reinforcing.



90° ANGLE

.035, .040, .045, .060

Where fast cutting and low kerf loss are desired



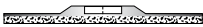
.090, .125

For tough cutting and notching applications where stability is important



TYPE 27/42

Type 27/42 cut-off wheels are designed with a depressed center to provide a recess for the hub, which allows flush cutting



90° ANGLE

.040, .045, .060

Where fast cutting and low kerf loss are desired



.090, .125

For tough cutting and notching applications where stability is important



HOW TO PICK THE RIGHT BOND TYPE

Bond Type	Code	Application
All Purpose	Unmarked	Where an excellent blend of cut rate and life is needed
Free Cut	FC	Where fast stock removal is needed, or the application only allows for low-pressure or under-horsepowered grinders
Long Life	LL	Where durability is needed due to severe application, and when horsepower of the grinder allows for heavy pressure
Contaminate Free	INOX	Contain <0.1% iron, sulfur or chlorine for rust-free and corrosion-free results; will not contaminate stainless steel
Aluminum	ALU	Specially formulated bond for reduced loading/surface contamination cutting aluminum/soft materials
EVO	EVO	For severe cutting applications

MATERIAL-TO-PRODUCT RECOMMENDATION GUIDE

	BEST HIGHEST PRODUCTIVITY LOWEST TOTAL COST	BETTER EXCELLENT BLEND OF PERFORMANCE & PRICE	GOOD CONSISTENT PERFORMANCE LOW INITIAL PRICE
Cutting			
Mild Carbon / High Tensile Steel	Norton NorZon Plus	Norton BlueFire	Norton Metal
Stainless Steel / Alloys	Norton NorZon Plus	Norton BlueFire	Norton Gemini
Contaminate Free		Norton BlueFire INOX	Norton Gemini INOX
Cast Iron	Norton NorZon Plus	Norton BlueFire	Norton Gemini
Aluminum / Bronze / Brass			Norton Gemini ALU
Asphalt / Brick / Concrete			Norton Masonry



CROSS REFERENCE GUIDES

TYPE 01/41 .035 - .125 CUT-OFF WHEELS FOR DIE GRINDERS

	TOTAL PERFORMANCE			INITIAL PRICE		SPECIALTY	
	BEST NorZon Plus	BETTER BlueFire	GOOD Gemini Free Cut	Gemini	Metal	GOOD Gemini INOX	
Brilliant	—	Brill-Max ZA	—	—	Safe-Tex FC, LL	—	
Bullard	—	ZA46T, ZA60T	TA36T	TA46T, TA60T	A36T, A60T Comp.	—	
Camel	—	ZA60-TBF	A36 RBF	A60 RBF	Fast Cut RBF	—	
Flexovit	Flexon Fast Cut A46, 60	—	High Perf Fast Grind A36	High Perf Fast Cut A36, 46, 60	—	—	
Pearl	—	SRT, Zirconia	—	Premium	Silver Line	—	
Pferd	—	—	—	—	PSF-A	SG-A-R-INOX	
Sait	Saittech	—	A60S	A24R, A36T, A60T	—	—	
Spedecut	—	—	—	—	A46, 60 TBXX	—	
Walter	—	—	A24 ZIP	A60 ZIP	—	—	

TYPE 01/41 AND TYPE 27/42 .040 - .125 CUT-OFF WHEELS FOR RIGHT ANGLE GRINDERS

	TOTAL PERFORMANCE				INITIAL PRICE			SPECIALTY		
	BEST NorZon Plus Free Cut		BETTER BlueFire Free Cut		GOOD Gemini Free Cut	Gemini	Metal	GOOD Gemini ALU	Gemini INOX	Masonry
Brilliant	—	—	—	—	Brill-Blade Extra FC	Brill-Blade Heavy Duty	Hornet Stinger	—	—	—
Bullard	—	—	—	ZA60T	SGA60U	TA46T, TA60T, TA60U	A46T, A60T Comp.	AL46N	—	C24R
Camel	—	—	—	ZA Quickie Cut	A36-S-BF	Super Quickie Cut	Quickie Cut	A46 Quickie Cut	A60-T-BF, WA60R Quickie Cut	—
Flexovit	—	—	—	—	Razorblade A60SST	Razorblade A24T, 30V, 36T	—	Razorblade A30Q	—	C30U
Metabo	—	—	—	A 60 XP Super Slicer	—	A 60 TX Slicer-Plus	A 60 TZ Slicer	—	—	—
Pearl	—	—	—	Redline Max Slimcut	—	Slimcut	Slimcut Pro-V, Sliverline	—	—	—
Pferd	—	—	—	SGP-ZA-Q-INOX	—	SG-A-S, SGP-A-T	PSF-A-P	S-G-N-ALU	SG-A-R-INOX, SGP-A-S-INOX	SG-C-R
Sait	—	Saittech	—	Z-tech	SAIT.M.X	A60S	—	A46N	XA46R	—
SpedeCut	—	—	—	—	—	—	A46, 60 TBXX	—	—	—
Walter	—	—	—	—	A-30-ZIP	A-60-ZIP	—	A-60-ZIP-ALU	A60-SS-ZIP	C-30-ZIP

FEATURED PRODUCTS



NORTON NORZON PLUS CUT-OFF / RIGHTCUT

BEST CHOICE FOR HIGHEST PRODUCTIVITY FOR STEEL, STAINLESS STEEL AND ALL OTHER FERROUS METALS

FEATURES

- Patented Norton SG (ceramic alumina) / NorZon (zirconia alumina) grain combination
- Highly advanced bond system

BENEFITS

- Fastest cutting wheel available on the market, up to 3X faster cutting versus aluminum oxide
- 3X – 10X life versus aluminum oxide wheels on carbon steel, stainless and cast iron



NORTON BLUEFIRE CUT-OFF / RIGHTCUT

BETTER CHOICE FOR STAINLESS STEEL, CARBON STEEL, ALLOYS AND GRAY IRON

FEATURES

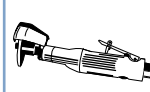
- A blend of R&D advanced chemistry and shape zirconia alumina abrasive with premium aluminum oxide grain
- Contaminate-free BlueFire FC (FreeCut/Inox)

BENEFITS

- 2-3 times the life of aluminum oxide wheels
- Broad utility from light-to heavy-pressure applications
- Excellent performance-to-price ratio for lower total grinding costs
- Contain <0.1% iron, sulfur, or chlorine for rust-free and corrosion-free results; will not contaminate stainless steel

SMALL DIAMETER REINFORCED CUT-OFF

MACHINES USED



AVAILABILITY

TIER:	BEST	BETTER	BETTER	GOOD	GOOD	GOOD
TRADENAME:	NORTON NORZON PLUS	NORTON BLUEFIRE	NORTON A60-OBNA2	NORTON GEMINI	NORTON GEMINI LONG LIFE	NORTON METAL
SHAPE:	Type 01/41	Type 01/41	Type 01/41	Type 01/41	Type 01/41	Type 01/41
ABRASIVE:	Ceramic Alumina/ Zirconia Alumina	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
MATERIAL:	STAINLESS	STAINLESS	STAINLESS	STAINLESS	STAINLESS	STAINLESS
	STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.
Type 01/41 – Cut-off								
1-1/2 x .035 x 1/16	40,745	25			66243427764			
1-1/2 x .035 x 1/8	40,745	25			66243427831			
1-1/2 x .035 x 1/4	40,745	25			66243427875			
2 x .035 x 1/8	30,560	25				66243411392	FC	
2 x .035 x 1/4	30,560	25			66243428014	66243411393	FC	
2 x .035 x 3/8	30,560	25				66243411394	FC	
2 x .060 x 1/8	30,560	25			66243428041			
2 x .060 x 1/4	30,560	25			66243427993	66243411395	FC	
2 x .060 x 3/8	30,560	25				66243411396	FC	
2 x .125 x 1/4	30,560	25				66243411402	FC	
2 x .125 x 3/8	30,560	25				66243411403	FC	
2-1/2 x .035 x 1/8	30,560	25			66243528476			
2-1/2 x .035 x 1/4	30,560	25			66243528425			
2-1/2 x .060 x 1/4	30,560	25				66243510640	FC	
2-1/2 x .060 x 3/8	30,560	25				66243510641	FC	
2-7/8 x .035 x 1/4	25,465	25						07660789019
3 x .035 x 1/4	25,465	25	66243510668		66243528573	66243510627	FC	
	25,465	5	66243531753	<i>5-Pk</i>				
3 x .035 x 3/8	25,465	25	66243510669	66252843174	66243528574	66243510628	FC	66243537271
	25,465	5	66243534828	<i>5-Pk</i>	66243534821	<i>5-Pk</i>		
3 x .060 x 1/4	25,465	25	66243510670		66243528471	66243510645	FC	66243510649
3 x .060 x 3/8	25,465	25	66243510671	66252843175	66243528552	66243510647	FC	66243510648
	25,465	25	66243510835	LL		66252835553		
	25,465	5						07660747767
	25,465	5						66252843624
								<i>5-Pk with Mandrel</i>
3 x .125 x 1/4	25,465	25				66243510650	FC	66243510652
3 x .125 x 3/8	25,465	25	66243510673			66243510651	FC	66243510653
4 x .035 x 1/4	19,100	25			66243529606	66243510629	FC	
4 x .035 x 3/8	19,100	25	66243510675	66252843173	66243529621	66243510630	FC	66243537273
	19,100	25				66252836496		07660789453
4 x .035 x 1/2	19,100	25			66243529622			
4 x .035 x 3/4	19,100	25			66243529609			
4 x .040 x 3/8	15,280	25			66243529516			
4 x .040 x 5/8	15,280	25						07660701616
4 x .045 x 5/8	15,280	25				66243527956		07660705249
4 x .060 x 1/4	19,100	25	66243510676			66243510654	FC	
4 x .060 x 3/8	19,100	25	66243510677	66252843171		66243510655	FC	66243510657
4 x .060 x 5/8	19,100	25				66243527827		66243527826
4 x .090 x 5/8	15,280	25				66243527955		
4 x .125 x 1/4	19,100	25				66243510658	FC	
4 x .125 x 3/8	19,100	25	66243510841	66252843172		66243510659	FC	66243510661
	19,100	25	66243510680	LL				
5 x .035 x 3/8	12,225	25			66252830653			
6 x .035 x 3/8	10,185	25			66252835064			
6 x .035 x 1/2	10,185	25			66252835053			
6 x .035 x 5/8	10,185	25			66252835054	66252809714		
6 x .040 x 3/8	12,225	25						66252840608
6 x .060 x 5/8	10,185	25				66252809718		
7 x .060 x 5/8	8,600	25				66252905957		
8 x .060 x 5/8	7,640	25		66253017771	LL	66253007025		
		10				66253017795		
Drill Mount Mandrel		5						07660747769*

* FOR MOUNTING 2" AND 3" X 3/8" HOLE CUT-OFF WHEELS ON TO A DRILL

WHEEL DESCRIPTION CODES				
EVO = SEVERE CUTTING	FC = FREE CUT	INOX = CONTAMINANT FREE	LL = LONG LIFE	BLANK = ALL PURPOSE
M = MASONRY	S = STAINLESS	ST = STEEL / METAL		



AVAILABILITY



TIER:	BEST	BETTER	GOOD	GOOD
TRADENAME:	NORTON NORZON PLUS RIGHTCUT	NORTON BLUEFIRE RIGHTCUT	NORTON GEMINI RIGHTCUT	NORTON METAL RIGHTCUT
SHAPE:	Type 01/41	Type 01/41	Type 01/41	Type 01/41
ABRASIVE:	Ceramic Alumina/ Zirconia Alumina	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
MATERIAL:	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.
Type 01/41 – RightCut Cut-off						
4 x .040 x 5/8	15,280	25				07660701616
4 x .045 x 5/8	15,280	25			66243527956	
4 x .090 x 5/8	15,280	25			66243527955	
4-1/2 x .040 x 7/8	13,580	25		66252843225		07660701617
	13,580	250●				66252840001 <i>Bulk</i>
	13,580	25*				66252842158 <i>5-Pk</i>
4-1/2 x .045 x 7/8	13,580	25	66252830730	66252843208	66252823602	
	13,580	25			66252841994 ALU	
	13,580	25			66252841997 INOX	
	13,580	25			66252832906 EVO	
	13,580	250●			66252841213 <i>Bulk</i>	
	13,580	250●			66252841216 EVO Bulk	
	13,580	25*		66252842159 <i>5-Pk</i>	66252842160 <i>5-Pk</i>	
4-1/2 x .090 x 7/8	13,580	25			66252823599	
5 x .040 x 7/8	12,225	25		66252843226		07660701618
	12,225	25*				66252842168 <i>5-Pk</i>
5 x .045 x 7/8	12,225	25	66252830731	66252843209	66252823603	
	12,225	25			66252841995 ALU	
	12,225	25			66252841998 INOX	
	12,225	25			66252832907 EVO	
	12,225	250●			66252841214 <i>Bulk</i>	
	12,225	250●			66252841217 EVO Bulk	
	12,225	25*		66252842169 <i>5-Pk</i>	66252842170 <i>5-Pk</i>	
5 x .050 x 7/8	12,225	25	66252809829			
5 x .090 x 7/8	12,225	25			66252823600	
6 x .040 x 3/8	12,225	25				66252840608
6 x .040 x 7/8	10,185	25				07660702757
	10,185	250●				66252841212 <i>Bulk</i>
	10,185	25*				66252842173 <i>5-Pk</i>
6 x .045 x 7/8	10,185	25	66252842008	66252843210	66252823604	
	10,185	25			66252841996 ALU	
	10,185	25			66252841999 INOX	
	10,185	25			66252832908 EVO	
	10,185	250●			66252841215 <i>Bulk</i>	
	10,185	25*		66252842174 <i>5-Pk</i>	66252842175 <i>5-Pk</i>	
6 x .090 x 7/8	10,185	25			66252823601	
7 x .045 x 7/8	8,600	25			66252842000 INOX	
7 x .060 x 5/8	8,600	25			66252905957	
7 x .060 x 7/8	8,600	25	66252900652		66252832323	

RIGHTCUT WHEELS ARE TO BE USED FOR CUTTING ONLY

* 5-WHEEL JOB PACKS: WHEELS ARE PACKED 5 WHEELS/PACK, WITH 5 JOB PACKS/CARTON. ORDER PER EACH WHEEL IN STANDARD PACKAGE QUANTITIES OF 25. ORDER IN MULTIPLES OF 25.
● BULK PACKED 250/CARTON; 5 INNER BOXES OF 50 WHEELS EACH. ORDER IN MULTIPLES OF 250 WHEELS.

Bulk Pack Quantities



Ideal for the larger end-user that needs stock on hand at all times or for the distributor who wants more wheels with lower initial purchase costs. Each master carton contains 5 inner boxes of 50 wheels per box.



AVAILABILITY



TIER:	BEST	BETTER	GOOD	GOOD
TRADENAME:	NORTON NORZON PLUS RIGHTCUT	NORTON BLUEFIRE RIGHTCUT	NORTON GEMINI RIGHTCUT	NORTON METAL RIGHTCUT
SHAPE:	Type 27/42	Type 27/42	Type 27/42	Type 27/42
ABRASIVE:	Ceramic Alumina/ Zirconia Alumina	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
MATERIAL:	STAINLESS	STAINLESS	STAINLESS	STAINLESS
	STEEL/METAL	STEEL/METAL	STEEL/METAL	STEEL/METAL

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.
Type 27/42 – RightCut Cut-off						
4 x .045 x 5/8	15,280	25			66252842180	07660705249
4 x .125 x 3/8	15,280	25	66252842001			
4-1/2 x .040 x 5/8-11	13,580	10		66252843227		
4-1/2 x .045 x 5/8-11	13,580	10	66252842006	66252843223	66252842025	
	13,580	10			66252841913 INOX	
4-1/2 x .045 x 7/8	13,580	25	66252843320	66252843219	66252842026	66252843604
	13,580	25			66252841912 INOX	
	13,580	25			66252841909 ALU	
	13,580	25*			66252842161 5-Pk	
4-1/2 x .090 x 5/8-11	13,580	10			66252841903	
	13,580	10			66252842027 INOX	
4-1/2 x .090 x 7/8	13,580	25			66252841940	
	13,580	25			66252842028 INOX	
4-1/2 x .125 x 5/8-11	13,580	10	66252843321		66252843588	
4-1/2 x .125 x 7/8	13,580	25	66252843322		66252843589	
5 x .040 x 5/8-11	12,225	10		66252843228		
5 x .045 x 5/8-11	12,225	10			66252841939	
	12,225	10			66252841915 INOX	
5 x .045 x 7/8	12,225	25	66252843329	66252843220	66252842036	
	12,225	25			66252841914 INOX	
	12,225	25			66252841910 ALU	
	12,225	25*			66252842171 5-Pk	
5 x .090 x 5/8-11	12,225	10			66252841904	
5 x .090 x 7/8	12,225	25			66252842037 INOX	
	12,225	25			66252843587	
5 x .125 x 7/8	12,225	25			66252843595	
6 x .045 x 5/8-11	10,185	10	66252842007		66252830587	
	10,185	10			66252841917 INOX	
6 x .045 x 7/8	10,185	25	66252842009	66252843221	66252842202	66252842015
	10,185	25			66252841916 INOX	
	10,185	25			66252841911 ALU	
	10,185	25*			66252842176 5-Pk	
6 x .090 x 5/8-11	10,185	10			66252841905	
6 x .090 x 7/8	10,185	20			66252841906	
	10,185	20			66252832487 INOX	
6 x .125 x 5/8-11	10,185	10			66252841192	
6 x .125 x 7/8	10,185	25			66252842021	
7 x .045 x 5/8-11	8,600	10			66252841919 INOX	
7 x .045 x 7/8	8,600	20			66252841918 INOX	
7 x .060 x 7/8	8,600	20			66252912626	07660705251
	8,600	10				
7 x .090 x 5/8-11	8,600	10			66252841907	
7 x .090 x 7/8	8,600	20			66252841908	
	8,600	20			66252914638 INOX	
7 x .125 x 5/8-11	8,600	10	66252912625			
7 x .125 x 7/8	8,600	20	66252912624		66252900619	
9 x .060 x 5/8-11	6,600	10			66253019115	
9 x .090 x 5/8-11	6,600	10		66252842378		
9 x .090 x 7/8	6,600	20		66252842343		

RIGHTCUT WHEELS ARE TO BE USED FOR CUTTING ONLY

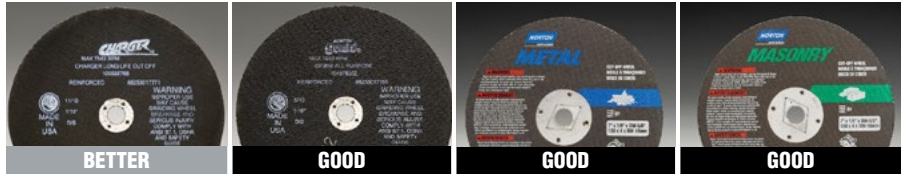
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WHEEL DESCRIPTION CODES

EVO = SEVERE CUTTING	FC = FREE CUT	INOX = CONTAMINANT FREE	LL = LONG LIFE	BLANK = ALL PURPOSE
■ = MASONRY	■ = STAINLESS	■ = STEEL / METAL		



AVAILABILITY



TIER:	BETTER	GOOD	GOOD	GOOD
TRADENAME:	NORTON CHARGER	NORTON GEMINI	NORTON METAL	NORTON MASONRY
SHAPE:	Type 01/41	Type 01/41	Type 01/41	Type 01/41
ABRASIVE:	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Silicon Carbide
MATERIAL:	STEEL/METAL	STEEL/METAL	STEEL/METAL	MASONRY

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.
Type 01/41 – Circular Saw						
6 x .035 x 5/8	10,185	25		66252809714		
6 x .060 x 5/8	10,185	25		66252809718		
6-1/2 x .125 x DM-5/8	9,405	10			07660789098	07660789089
7 x .060 x 5/8	8,730	25		66252905957		
7 x .125 x DM-5/8	8,730	25			07660789097	07660789088
8 x .060 x 5/8	7,640	25	66253017771 LL	66253007025		
				66253017795		
8 x 1/8 x DM-5/8	7,640	10			07660789096	07660789086

DM DENOTES DIAMOND MOUNT; 5/8" HOLE BUSHINGS INCLUDED

WHEEL DESCRIPTION CODES

EVO = SEVERE CUTTING	FC = FREE CUT	INOX = CONTAMINANT FREE	LL = LONG LIFE	BLANK = ALL PURPOSE
■ = MASONRY	■ = STAINLESS	■ = STEEL / METAL		





CATEGORY DEFINITION

Norton high speed cut-off abrasive wheels provide the industry's leading performance in all high speed gas and electric-powered applications.

- APPLICATIONS:** Metalworking: steel, stainless, ductile, cast iron, rail steel and metal decking
 Non-Metal Building Materials: concrete, brick, masonry, asphalt aggregate, stone and schedule 40 and 80 PVC pipe
 Rescue and Demolition: steel, acrylic, fiberglass, rubber, glass, wood, concrete, brick and asphalt
- SIZE RANGE:** 12" – 16" diameter
- THICKNESS RANGE:** 1/8"
- ABRASIVE GRAIN:** Aluminum Oxide, Silicon Carbide
- SHAPE:** Type O1 Straight
- REINFORCEMENT:** Wheels are offered in standard two layer reinforcement as well as three layer reinforcement for higher speed saws and heavy-duty applications
- ARBOR:** Wheels are offered with a patent-pending universal arbor that accommodates both 20mm (Stihl®) and all other machines with 1" arbors

MATERIAL / APPLICATION-TO-PRODUCT RECOMMENDATION GUIDE

ICON		APPLICATION
	Metal	High-performance aluminum oxide grain wheels designed for general purpose cutting of all steel and stainless parts including rebar, steel pipe, structural steel, sheet metal, cable and small to medium diameter solid pieces.
	Metal Decking	High-performance aluminum oxide abrasive combined with a thicker wheel that stands up to the sharp edges of sheet metal and roof decking.
	Rail Steel	A finer grit, harder grade aluminum oxide wheel designed for straight, fast cuts on all sizes of rail track. Additional high-performance lines of rail cut wheels are available for production applications.
	Ductile/Cast Iron	A special blend of silicon carbide abrasive for cutting and aluminum oxide abrasive for life, designed to cut ductile and cast iron pipe, concrete-lined water pipes, sewer construction and heavy duty PVC.
	Rescue	For ventilation, forcible entry, rescue and demolition. A versatile abrasive formula that can be used on a wide range of materials including all types of metals and masonry.
	Concrete	Coarse grit silicon carbide abrasive provides a low initial cost solution for cutting brick, block, concrete or other masonry materials. For higher-production applications that require optimum speed of cut and product life, please see our complete selection of high speed diamond wheels in our Norton Construction diamond product line.
	Asphalt	A special blend of extra coarse silicon carbide abrasive grains provides a low initial cost solution for cutting asphalt, green concrete, asphalt over concrete, a wide range of aggregates and abrasive materials. For higher-production applications that require optimum speed of cut and product life, please see our Norton Construction diamond product line.

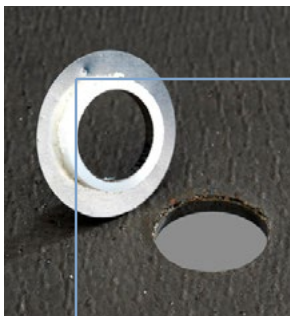
HOW TO PICK THE RIGHT REINFORCEMENT



Two full layers of reinforcing are offered for lower power machines, and light to medium applications where speed of cut is the primary selection criterion.



Three full layers of reinforcing are recommended for high speed, high horsepower machines where the application is heavy-duty, and durability is the primary selection criterion.



Universal Arbor

Two Blade Sizes in One

Our Norton patent-pending 1"/20mm knock-out arbor fits all gas and electric high speed saws. A 20mm bushing is pre-mounted into the 1" molded arbor hole. The wheel, with the 20mm bushing, can be mounted directly on any 20mm arbor high speed saw. With the bushing removed, exposing the 1" arbor hole, the wheel can be mounted on any 1" arbor high speed saw. Combining this arbor, with heavy-duty triple reinforcing results in a higher performing, extra strong, longer lasting cutting wheel. Once the 20mm bushing is removed, it cannot be replaced.



CROSS REFERENCE GUIDE

SPECIALTY

NORTON

	GOOD					
	Gemini Metal	Gemini Metal Decking	Rail Steel	Gemini Ductile	Gemini Concrete	Gemini Asphalt
Abmast	A 24 R, Kompetitor Metal	A 24 T	Rail-Kut A 24 Z	AC 24 R, Kompetitor Ductile Iron	C 24 R, Kompetitor Concrete	C 16 T, Kompetitor Asphalt
Brilliant	Metal/Stainless	—	A24PB	—	Concrete/Masonry	—
Bullard Blaze & Road Warrior	A24R, ZA24Q, The Competitor	TA24R	A30R	AC24R	C24R, The Competitor	CC20R
Camel	A24-R	A24-T	—	AC24-R	C24-R	C16-U
Flexovit	A24/30SB	A24TB	A30PB	AC24SB	C30UB	C16UB
Husqvarna	Blue XHS, Blue QMS-CM, Blue EHS	Grey QMS-CM	Yellow QMS-CM	Green QMS-CM, Green EHS	Red XHS, Red QHS-CM, Red EHS	Black QMS-AS
Pearl	SRT, Premium A36S, Silver Line A30R	—	—	AC30S	Premium C36S, Silver Line C24R	—
Pferd	A 24 R SG	A 24 Q SG-RAIL	A 24 Q SG-RAIL	AC 24 Q SG	C 24 R SG	—
Sait	A24R, A30S, XFC	Brute	Hobo	Ductile	C24R	Big M.A.C, XFC
Tyrolit	A30P, A30BF	—	—	AC24, AC30BF	1C24, C30BF	—
Virginia Abrasives	Metal	—	—	Ductile	Concrete	Asphalt
Walter	A-24	—	—	—	—	—

AVAILABILITY

TIER:					
BRAND:	Norton	Norton	Norton	Norton	Norton
TRADENAME:	GEMINI METAL HD	GEMINI METAL	GEMINI METAL DECKING	RAIL STEEL	GEMINI RESCUE
SHAPE:	Type 01	Type 01	Type 01	Type 01	Type 01
ABRASIVE:	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide
REINFORCING:	3 Layers	2 Layers	2 Layers	2 Layers	2 Layers
MATERIAL:					

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.
Type 01 Cut-off – for Gas & Electric-Powered Saws							
12 x 1/8 x 1" / 20mm	6,360	10	66252836708	66252837838			
14 x 1/8 x 1" / 20mm	5,400	10	66252835386	66252837841	66252832521		66243578262
14 x 1/8 x 1"	5,400	10				66253260462	
16 x 1/8 x 1" / 20mm	4,800	10		66252830886			
16 x 1/8 x 1"	4,800	10				66253259935	

AVAILABILITY

TIER:					
BRAND:	Norton	Norton	Norton	Norton	Norton
TRADENAME:	GEMINI DUCTILE HD	GEMINI DUCTILE	GEMINI CONCRETE HD	GEMINI CONCRETE	GEMINI ASPHALT
SHAPE:	Type 01	Type 01	Type 01	Type 01	Type 01
ABRASIVE:	Silicon Carbide	Silicon Carbide	Silicon Carbide	Silicon Carbide	Silicon Carbide
REINFORCING:	3 Layers	2 Layers	2 Layers	2 Layers	2 Layers
MATERIAL:					

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.
Type 01 Cut-off – for Gas & Electric-Powered Saws							
12 x 1/8 x 1" / 20mm	6,360	10		66252837840	66252836709	66252837839	70184670243
14 x 1/8 x 1" / 20mm	5,400	10	66252835388	66252837843	66252835387	66252837842	70184672877
16 x 1/8 x 1" / 20mm	4,800	10				70184623029	



CATEGORY DEFINITION

The Norton RailCut line is designed for high-speed fixtured hydraulic or gas-powered rail saws.

APPLICATIONS:	Fixed rail track cutting
SIZE RANGE:	14" and 16" diameter
THICKNESS RANGE:	1/8"
GRIT RANGE:	24 – 36
ABRASIVE GRAIN:	Zirconia Alumina and Aluminum Oxide
SHAPE:	Type 01 Straight
REINFORCEMENT:	Side reinforced with R sides
SPEED RATING:	All wheels are rated for 20,000 SFPM applications

CROSS REFERENCE GUIDE AND MACHINE-TO-PRODUCT RECOMMENDATION GUIDE

NORTON	BEST	GOOD	Hydraulic Saw	BEST	BETTER	GOOD
	NorZon IV Rail FastCut and BETTER NorZon III	A30X		HIGHEST PRODUCTIVITY LOWEST TOTAL COST	EXCELLENT BLEND OF PERFORMANCE & PRICE	CONSISTENT PERFORMANCE LOW INITIAL PRICE
Bullard Abrasive	Trackmaster Pro ZA24 Q-BF (Blue)	Trackmaster A30 R-BF (Red)		NorZon IV Rail FastCut		A30X
Flexovit USA	-	A30-PB	Gas Saw			
Giesmar	AM303-R	NR242-Q	High Horsepower / Newer Machine		NorZon III RailCut	A30X
Klingspor	A 24 SX Special	-	Low Horsepower / Older Machine		NorZon III FastCut	A30X
Portaco	A30 R-BF	-				
Racine Kwik Kut	A24R	-				

FEATURED PRODUCTS



NORTON NORZON IV RAIL FASTCUT

BEST CHOICE FOR HIGH PERFORMANCE CUTTING OF RAILS ON APPLICATIONS WHERE THE HYDRAULIC OR GAS SAW IS FIXTURED AND HAS ADEQUATE POWER

FEATURES

- Zirconia alumina abrasive blend
- New, free cutting bond

BENEFITS

- Ideal for high powered, well-maintained machines
- Maximized cut rate, while maintaining straight cuts

AVAILABILITY

						
TIER:			BEST	BETTER	BETTER	GOOD
TRADENAME:			NORTON NORZON IV RAIL FASTCUT	NORTON NORZON III RAILCUT	NORTON NORZON III RAIL FASTCUT	NORTON A30X RAILCUT
ABRASIVE:			Zirconia Alumina	Zirconia Alumina	Zirconia Alumina	Zirconia Alumina
SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.
Type 01 Cut-off						
14 x 1/8 x 1	5,400	10	66253048511	66253360493	66253363694	66253260462
16 x 1/8 x 1	4,800	10	69936614383	66253464607	66253464415	66253259935



CATEGORY DEFINITION

These powerful, self-propelled machines are designed to cut concrete slabs and asphalt and are normally fitted with diamond blades. For inexperienced operators or small jobs, the machines can accommodate low initial cost, conventional abrasives wheels.

APPLICATIONS:	Cutting straight sections of concrete surfaces
SIZE RANGE:	14" and 18" diameter
THICKNESS RANGE:	3/16" – 3/8"
ABRASIVE GRAIN:	Silicon Carbide
SHAPE:	Type 01 Straight
BOND:	Hot Pressed (HP) – for higher horsepower machine applications where additional durability is needed, may be used wet or dry Cold Pressed (CP) – for lower horsepower machines, which need a free-cutting wheel
ARBOR:	All are 1" with a drive pin

CROSS REFERENCE GUIDE

SPECIALTY

NORTON

Abmast

Bullard Blaze & Road Warrior

Camel

Flexovit

Husqvarna

Pearl

Pferd

Sait

Tyrolit

Virginia Abrasives

Walter

	BETTER Gemini Asphalt / Green Concrete – HP	GOOD Gemini Asphalt	GOOD Gemini Concrete
Abmast	—	C 16 T, Kompetitor Asphalt/Concrete	C 24 R
Bullard Blaze & Road Warrior	—	C16R & T, C16R3	—
Camel	—	C16-U	C24-R
Flexovit	HPC16AG	C16 G.P. C16UB	C20SB/C16TB
Husqvarna	Red GC-7A	Black EWC	Gold RTC, Blue RTC, Blue EWC
Pearl	—	—	Premium C36S, Silver Line C24R
Pferd	—	C 24 R SG ASP	C 24 R SG GP
Sait	Street Runner	C16	C24R, Street Walker
Tyrolit	Concrete/Asphalt CHP	Asphalt CP	Concrete CP
Virginia Abrasives	—	GC/Asphalt	Concrete
Walter	—	—	C-24

AVAILABILITY



TIER:	BETTER	GOOD	GOOD
BRAND:	Norton	Norton	Norton
TRADENAME:	GEMINI ASPHALT - HP	GEMINI ASPHALT - CP	GEMINI CONCRETE
SHAPE:	Type 01	Type 01	Type 01
ABRASIVE:	Silicon Carbide	Silicon Carbide	Silicon Carbide
BOND:	Hot Pressed	Cold Pressed	Cold Pressed
MATERIAL:			

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART NO.	PART NO.	PART NO.
Type 01 Cut-off – For Walk-Behind Saws					
14 x 3/16 x 1 Pin Hole	4,365	10	70184670100	70184680324	70184680323
14 x 1/4 x 1 Pin Hole	4,365	5	70184670099	70184670535	70184670533
18 x 1/4 x 1 Pin Hole	4,250	5	70184670103	70184670098	
18 x 3/8 x 1 Pin Hole	4,250	5	70184648998		



For higher-production applications, optimum speed of cut and product life, please see our complete selection of walk-behind diamond blades in our Diamond, Abrasives and Equipment for the Construction Market Catalog #7719 found on www.nortonconstructionproducts.com.

**CHOP SAW
REINFORCED CUT-OFF**



NORTON
SAINT-GOBAIN
NORZON
PLUS

NORTON
SAINT-GOBAIN
BLUefire™

NORTON
SAINT-GOBAIN
GEMINI®



CATEGORY DEFINITION

A chop saw is a light, low horsepower portable machine. Although very similar to a compound miter saw, it is designed for cutting denser materials, like metal bar, tubing or pipe. Chop saw cut-off wheels are designed specifically for this machine with finer grit, softer grades, and reinforcement layers that match the application.

APPLICATIONS:	Cutting small diameter metal pieces, bar stock, metal pipe, tubing, decking, cable, drywall studs, and metal plate dimensioning
SIZE RANGE:	10" - 16" diameter
THICKNESS RANGE:	7/64"
ABRASIVE GRAIN:	Zirconia Alumina/Aluminum Oxide Blend, Aluminum Oxide, Silicon Carbide
SHAPE:	Type O1 Straight
REINFORCEMENT TYPE:	Side reinforced, centrally reinforced

CROSS REFERENCE GUIDE

	TOTAL PERFORMANCE			INITIAL PRICE			SPECIALTY		
NORTON	BETTER			GOOD			GOOD		
	BlueFire Free Cut	BlueFire Rapid Cut	BlueFire Long Life	Gemini Free Cut	Gemini Rapid Cut	Gemini Long Life	Stud Cutter	Gemini Aluminum	Masonry
Brilliant	—	—	—	Super-G	Tube/Pipe	—	Drywall Stud	Aluminum	—
Bullard	ZA36T	—	—	TA36T A46T The Competitor	A36R The Competitor	A36R Ironmaster	A46T Studmaster	AL36R	—
Camel	—	—	ZA24-S	A36-P, WA36-P	—	A36-S	A30-R Mr. Stud	A30-N	—
Dewalt	—	—	XP	GP, Stainless Fabrication	—	—	Stud Cutting	—	—
Flexovit	—	—	—	A30R Fast Cut A30-Q Free Cut	—	A30S Long Life	A30T Drywall Stud	—	—
Makita	—	—	—	—	General Purpose	—	—	—	—
Pearl	SRT36	—	—	A36P Premium	A30P Silver Line	—	A46S Stud Cutting	—	—
Pferd	—	—	—	A 36 K SG CHOP	PSF CHOP	—	A 36 K SG-STUD	—	C 36 K SG-CHOP
Sait	Saitech Steel Worker	Z-tech	—	EZ-Chop	EZ-Chop Attacker	Iron Worker	Stud King	Aluminum	—
Walter	—	—	—	—	A-30	A-30-HC+	—	A30-ALU	—

APPLICATION-TO-PRODUCT RECOMMENDATION GUIDE

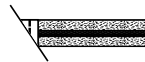
WHEEL TYPE/REINFORCEMENT

TYPE O1 STRAIGHT SIDE REINFORCED CUT-OFF WHEEL



Side reinforced wheels have two full layers of reinforcing and are designed for a fast cut and the most aggressive applications. All Purpose, Free Cut, and Long Life are side reinforced.

TYPE O1 STRAIGHT CENTRALLY REINFORCED CUT-OFF WHEEL



Centrally reinforced wheels have a single layer of reinforcing with exposed rough sides for free-cutting, non-binding applications where minimal burr and burn are the key requirements. Rapid Cut wheels are centrally reinforced.

HOW TO PICK THE RIGHT BOND TYPE

All Purpose	Unmarked	Where an excellent blend of cut rate and life is needed
Free Cut	FC	Used when fast, burn-free cutting is desired or when cutting pieces with larger cross sections
Long Life	LL	Where durability is needed due to severe application, and when cutting parts with small cross sections
Rapid Cut	RC	Where a free cutting, non-binding wheel is needed for burn-free and burr-free cuts
High-Performance	STUD	High-performance aluminum oxide/resin bond combination designed for cleaner cuts and longer life when cutting steel studs
Aluminum	ALU	Specially formulated bond for reduced loading/surface contamination when cutting aluminum/soft materials



FEATURED PRODUCTS



NEW

NORTON BLUEFIRE CHOP SAW REINFORCED CUT-OFF WHEELS

BETTER CHOICE FOR STEEL, STAINLESS STEEL AND ALL OTHER FERROUS METALS

FEATURES

- Upgraded zirconia alumina / premium aluminum oxide abrasive blend
- Free Cut: side reinforced
- Long Life: side reinforced
- Rapid Cut: centrally reinforced, rough sides

BENEFITS

- 2X the life and cut rate of aluminum oxide
- Engineered for larger cross-sections and/or hard-to-cut materials
- Ideal for small cross-section workpieces
- Free cutting, non-binding; burr- and burn-free cuts



NORTON GEMINI CHOP SAW REINFORCED CUT-OFF WHEELS

GOOD CHOICE FOR ALL STEEL AND FERROUS METALS AS WELL AS SPECIALTY APPLICATIONS IN ALUMINUM

FEATURES

- Free Cut: side reinforced
- Long Life: side reinforced
- Rapid Cut: centrally reinforced, rough sides
- Aluminum: specially formulated bond for aluminum and other soft, nonferrous metals; no wax or rubber fillers

BENEFITS

- Engineered for larger cross-sections and/or hard-to-cut materials
- Ideal for small cross-section workpieces
- Free cutting, non-binding; burr- and burn-free cuts
- Free cutting; resist loading
- No surface contamination



NORTON METAL STUD CUTTER CHOP SAW REINFORCED CUT-OFF WHEELS

GOOD CHOICE FOR DRYWALL STUDS



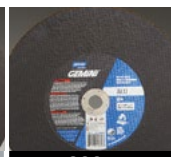
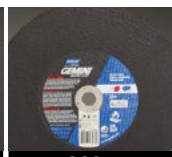

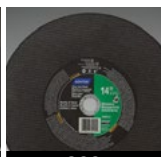
FEATURES

- Stud Cutter: thin, side-reinforced; with high-performance aluminum oxide abrasive

BENEFITS

- Designed specifically for cutting steel studs

AVAILABILITY

	 BETTER	 BETTER	 GOOD	 GOOD	 GOOD	 GOOD
TIER:	BETTER	BETTER	GOOD	GOOD	GOOD	GOOD
TRADENAME:	NORTON BLUEFIRE	NORTON BLUEFIRE	NORTON GEMINI	NORTON GEMINI	NORTON METAL	NORTON MASONRY
SHAPE:	Type 01	Type 01	Type 01	Type 01	Type 01	Type 01
ABRASIVE:	Zirconia Alumina/ Aluminum Oxide	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Silicon Carbide
REINFORCING:	Side	Central	Side	Central	Side	Side
MATERIAL:	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	MASONRY
SIZE (D x T x H)						
MAX. RPM						
STD. PKG.						
PART NO.						

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.
Type 01 Straight Cut-off								
10 x 7/64 x 1	6,110	10			66253106109 LL			
12 x 7/64 x 1	5,095	10	66252843250		66253207554 LL	66253214561 RC		
14 x 7/64 x 1	4,365	10	66252843252 FC	66252843254 RC	66252835554	66253313588 RC	07660789400	
		10	66252843253 LL		66253306627 FC		07660789405 STUD	
		10			66253306626 LL			
		10			66253314816 ALU			
		25						07660703970 5 Pk
5						07660789399	07660789402	
16 x 7/64 x 1	3,820	10	66252843256 FC		66253410198 LL			
		10	66252843257 LL					

CUT-OFF WHEEL DESCRIPTION CODES				
ALU = ALUMINUM	FC = FREE CUT	LL = LONG LIFE	RC = RAPID CUT	STUD = STUD CUTTER
■ = MASONRY	■ = STAINLESS	■ = STEEL / METAL		



CATEGORY DEFINITION

The Norton stationary saw reinforced cut-off wheel line consists of Type 01 straight 10" - 24" wheels, designed to fit on fixed-base stationary saws that are free-standing or mounted on a workbench.

APPLICATIONS:	Primary applications are cutting of all metal parts (flat stock, bars, studs, pipes, tubes, angle iron, cable), wire rope and hydraulic hose used in fabrication, construction and plant maintenance.
SIZE RANGE:	10" – 24" diameter
THICKNESS RANGE:	3/32", 1/8", 5/32", 3/16"
ABRASIVE GRAIN:	Zirconia Alumina/Aluminium Oxide Blend, Aluminum Oxide, Silicon Carbide
SHAPE:	Type 01 Straight

CROSS REFERENCE GUIDE

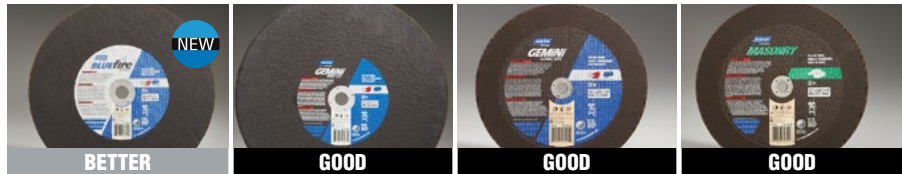


NORTON	BETTER	GOOD			Norton	GOOD
	BlueFire	Gemini Free Cut	Gemini Long Life	Gemini Rapid Cut*		Masonry
Abmast	Z 24 R3	A 30 R	—	—	—	AC 24 R3
Brilliant	—	GP Fast Cut	GPX Long Life	XL , XLX	—	—
Bullard	—	A30-R	A30-T	A300	C20R	—
Camel	ZA24-R	A24-R, A46-T	—	—	C24-R	WA24-S
Flexovit	—	A30RB Multi Purpose	A30SB Long Life, A24TB Long Life	—	C24RB	AC24PB Heavy Duty
Metabo	—	A30N, A30R	A30S, A30V	—	C30S	—
Pearl	SRT36	A30P Premium, A30Q Silver Line	A30S Premium, A36R Premium	—	C24 Silver Line	—
Pferd	ZA 24 Q/R SG-HD	A 24 N/P SG-HD	A 24 Q/S SG-HD	—	C 24 0 SG	—
Sait	—	A24N, A36R	A24R	—	C24R	—
Tyrolit	—	A30BF	—	—	C30BF	—
Walter	—	A-24-FC	A-24-RIP	—	—	—

* FOR BURR-FREE APPLICATIONS, PLEASE REFER TO GEMINI RAPID CUT WHEELS IN CHOP SAW CUT-OFF WHEEL SECTION OR AT WWW.NORTONABRASIVES.COM

** FOR FOUNDRY AND OTHER PRODUCTION CUT-OFF WHEELS, PLEASE REFER TO THAT SECTION OF THE NORTON FULL LINE CATALOG #7362 OR AT WWW.NORTONABRASIVES.COM

AVAILABILITY



TIER:	BETTER	GOOD	GOOD	GOOD
TRADENAME:	NORTON BLUEFIRE	NORTON GEMINI FREE CUT	NORTON GEMINI LONG LIFE	NORTON MASONRY
SHAPE:	Type 01	Type 01	Type 01	Type 01
ABRASIVE:	Zirconia Alumina/ Aluminum Oxide	Aluminum Oxide	Aluminum Oxide	Silicon Carbide
MATERIAL:	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	STAINLESS STEEL/METAL	MASONRY

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PART NO.	PART NO.	PART NO.	PART NO.
Type 01 Straight Cut-off						
10 x 3/32 x 5/8	6,110	10 5	66252843248	66253106101 FC	66253106102 LL	07660789391
12 x 1/8 x 1	5,095	10 5	66252843249	66253207547 FC	66253207548 LL	07660789350
14 x 1/8 x 1	4,365	10 5	66252843251	66253306609 FC	66253306611 LL	07660789353 70184623029
16 x 1/8 x 1	3,820	10		66253422942		
16 x 5/32 x 1	3,820	10	66252843255	66253410183 FC	66253410184 LL	
18 x 5/32 x 1	3,015	10		66253410185 FC		
20 x 5/32 x 1	2,710	5 5	66252843258 FC 66252843259 LL	69078609031 FC	69078609032 LL	
20 x 3/16 x 1	2,710	5		69078609033 FC	69078609034 LL	
24 x 3/16 x 1-3/4	2,260	5		61463650196 FC		

CUT-OFF WHEEL DESCRIPTION CODES

FC = FREE CUT **LL** = LONG LIFE **BLANK** = ALL PURPOSE **■** = STAINLESS **■** = STEEL / METAL **■** = MASONRY

CATEGORY DEFINITION

Foundry cut-off wheels are designed with abrasives, bonds and reinforcement types specific to machine parameters and materials. Most of the specifications are non-stock for this section and the stock listing is designed to provide popular size and starting specifications.

- SIZE RANGE:** Reinforced: 12" – 30" diameter; Non-reinforced: 12" – 20" diameter
- GRIT RANGE:** 20 – 46 grit
- ABRASIVE GRAIN:** Ceramic Alumina, Zirconia Alumina, Aluminum Oxide
- REINFORCEMENT:** Strengthening fabric or filaments, which make wheels resistant to cross-bending breakage. All portable cut-off, swingframe, locked-head push-through and foundry chop stroke operations require reinforced cut-off wheels.
 - B:** One or more full diameter pieces of filament molded inside each wheel. This construction leaves the abrasive exposed on the side of the wheel, improving freeness of cut. Used for fixed work operations with low probability of side pressure.
 - N:** Full diameter pieces of reinforcement on the side of the wheel. Offers greatest possible resistance to side pressure and bending.
 - W:** Reinforcement around the center hole only. These wheels are not considered to be truly reinforced.
 - Non-Reinforced:** Designed for use on fixed-base types of machines where the work is securely clamped and guarded, and where the wheel operates on a controlled cutting plane.
- SIDE PATTERNS:**
 - Smooth sides:** Used for precision cutting applications
 - Rough (R) sides:** Abrasive particles protrude from sides of wheel. Used wet or dry on most metals



MATERIAL-TO-PRODUCT RECOMMENDATION GUIDE

	BEST HIGHEST PRODUCTIVITY LOWEST TOTAL COST	BETTER EXCELLENT BLEND OF PERFORMANCE & PRICE	GOOD CONSISTENT PERFORMANCE LOW INITIAL PRICE
Investment Cast Alloys			
Nickel and Cobalt Based (Hastalloy, Inconel, Waspalloy)	Quantum B97		
Stainless Steel	Quantum Foundry X	BlueFire Foundry X	Foundry X
Titanium	Quantum Foundry X	BlueFire Foundry X	Foundry X
Cast Iron	Quantum Foundry X	BlueFire Foundry X	Foundry X
Cast Steel			
Carbon & Low Alloy	Quantum Foundry X	BlueFire Foundry X	Foundry X
Stainless Steel & High Alloy	Quantum Foundry X	BlueFire Foundry X	Foundry X
Aluminum Alloy	Quantum Foundry X	BlueFire Foundry X	Foundry X
Copper Alloys, Brass, Bronze	Quantum Foundry X	BlueFire Foundry X	Foundry X

CROSS REFERENCE GUIDE

	BEST Quantum B97	BETTER BlueFire Foundry X	GOOD Foundry X
NORTON			
Allison	TA362 R6 8045HA, YW462MRB2HA	TA302-T6-B6HA, A46-T6-BX5T6A, HF 1247 K – CHALLENGER	
Avery		TA30-V680	A 3226 C7A, C11922 W071
Buckeye		Steel Shark	
Dia-Tool	BV1734R 710	BV 1397-5284-C	
Flexovit		A24PB, A30RB	
Klingpor	20A24-QBF		
NATAB			T 1584 HA
Rappoid		6Z30U-B3F2	

FEATURED PRODUCTS



NORTON QUANTUM B97 REINFORCED

BEST CHOICE ON AEROSPACE ALLOYS

FEATURES

- New engineered ceramic alumina grain shape and chemistry

BENEFITS

- Superior performance on aerospace alloys with B97 bond technology
- More aggressive; can withstand demanding applications
- Longer wheel life; shorter cycle times



NEW!

NORTON FOUNDRY X REINFORCED

BETTER CHOICE ON STAINLESS STEEL, CAST IRONS, AND STEEL

FEATURES

- NEW! Xtended-life Foundry X bond technology

BENEFITS

- Improved durability and heat resistance result in longer abrasive life, showing up to 80% better G-ratios (material removed/wheel wear); the most cost effective wheels
- Reduced cycle times

AVAILABILITY REINFORCED



TIER:

BRAND:

TRADENAME:

ABRASIVE:

SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC.	PART NO.	SPEC.	PART NO.	SPEC.	PART NO.
Type O1 Flat Cut-off – Foundry Reinforced								
14 x 1/8 x 1	4,365	10			5NVA24-VB75N	66253179193	U57A24-VB75N	66253179191
16 x 5/32 x 1	3,820	10	FC	61463619480	5NVA24-VB75N	66253179147	U57A24-VB75N	66253179148
			LL	61463619481				
20 x 5/32 x 1	2,710	10	FC	61463619482	5NVA24-VB75N	66253179363	U57A24-VB75N	66253179364
			LL	61463619484				
20 x 3/16 x 1	2,710	10	FC	61463619486	5NVA24-VB75B	66253179366	U57A24-VB75B	66253179367
			LL	61463619487				
24 x 7/32 x 1-3/4	2,260	10	FC	61463619488	5NVA24-VB75N	66253179374	U57A24-VB75B	66253179375
			LL	61463619489				
30 x 1/4 x 1-3/4	1,810	10	FC	61463619492				
			LL	61463619493				

AVAILABILITY NON-REINFORCED



TIER:

BRAND:

TRADENAME:

ABRASIVE:

SIZE (D x T x H)	MAX. RPM	STD. PKG.	SPEC.	PART NO.	SPEC.	PART NO.
Type O1 Flat Cut-off – Foundry Non-Reinforced R-Sides						
12 x 3/32 x 1	5,095	10	U57A461-PB25	66253261887		
16 x 1/8 x 1	3,820	10			AP	66253422942
20 x 1/8 x 1	2,710	10	U57A304-VB25W	69078665497		

CUT-OFF DESCRIPTION CODES

AP = ALL PURPOSE

Where an excellent blend of cut rate and life is needed

FC = FREE CUT

Where fast stock removal is needed, or the application only allows for low-pressure or under-horsepowered grinders

LL = LONG LIFE

Where durability is needed due to severe application, and when horsepower of the grinder allows for heavy pressure



CATEGORY DEFINITION

Reinforced and non-reinforced engineered cut-off wheels for cutting all types of tool steel with fixed-based cut-off machines.

APPLICATIONS: Reinforced cut-off wheels are designed to resist breakage caused by severe cross-bending and are required on any operation where the work is not securely clamped.

Non-Reinforced cut-off wheels are designed for use on fixed-based machines where the work is securely clamped, guarded, and where the wheel operates on a controlled cutting plane.

SIZE RANGE: 6" – 12" diameter

GRIT RANGE: 36 – 90 grit

ABRASIVE GRAIN: Aluminum Oxide

BOND: Resinoid, Rubber, and Shellac

SHAPE: Type 01 Straight

CROSS REFERENCE GUIDE

NORTON	BETTER		
	Reinforced A60-OBNA2	Reinforced 57A364-TB25N	Non-Reinforced 57A60-M8B
Bates	A602-T-BF	A36-R-BF	-
Buffalo	A60-R-BF2	-	-
Dia. Tool	A80-SP	A46-SP	-
Radiac	A54-N6-B20	-	A54-N6-B20
Tyrolit	A60-QBF38A2	-	-

TECHtip

- Smooth side pattern – Used when a precise thickness tolerance is needed.
- Rough (R) sides pattern – Abrasive particles protrude from sides of wheel; used wet or dry on most metals.

TROUBLESHOOTING GUIDE

PROBLEM	POSSIBLE CAUSES	SUGGESTED CORRECTION
Poor cut rate	Insufficient power used Wheel too hard Contact area too large Wheel too coarse Wheel side out of truth	Increase feed or pressure to full power Use softer grade, or thinner wheel Reduce contact area Use finer grit Check spindle runout
Non-square cuts	Work not clamped properly Misaligned spindle bearings Poor coolant distribution Wheel is too hard	Check clamp and clean to remove swarf Check for bearing truth and alignment Ensure equal volume of coolant to each wheel side Use softer acting wheel: softer grade, or finer grit
Workpiece burn	Insufficient feed rate Poor coolant flow Wheel is too coarse Wheel is too hard Wheel is running out Wheel speed is too slow	Work machine to maximum power available Increase volume and direct at cutting point Use finer grit or more machine power Use softer grade wheel Check spindle and flanges Ensure tight flanges and maximum safe operating speed being used
Poor finish	Too much burr Wheel too coarse	Use finer grit, or softer grade Use finer grit

TECHtip

- Wheels with a "W" reinforcement (reinforcement around the hole) are not considered to be truly reinforced.
- Clamp or fixture the workpiece for straightest cuts.
- Run wheels at the highest possible speed marked on the wheel and make cuts as quickly as possible. Do not overspeed wheels.
- It is recommended that a cut-off machine should have 1 horsepower for every inch of wheel diameter. For less than this, we recommend using a softer specification.
- Using a harder grade wheel increases wheel life, but it also increases burn, power required and decreases cut rate.
- Using a coarser grit wheel increases wheel life and cut rate, but it also increases burr and power required.

FEATURED PRODUCTS



TOOLROOM REINFORCED CUT-OFF WHEELS

BETTER CHOICE FOR CUTTING TOOL STEEL ON FIXED-BASED MACHINES WHEN WORK IS NOT SECURELY CLAMPED

FEATURES

- OBNA2 – side reinforced, resin bond
- B25N – constructed with full diameter fiberglass reinforcement

BENEFITS

- Yields maximum cut rate and minimum kerf loss; ideal when thin cut is desired
- Versatile; durable, free cutting; offer greatest stiffness

AVAILABILITY

SIZE (D x T x H)	MAX. RPM	STD. PKG.	TIER: BETTER	
			SPEC.	PART NO.
Type O1 Flat Cut-off – Reinforced				
6 x .035 x 1/2	10,190	25	A60-OBNA2	66252835053
6 x .035 x 1-1/4	10,190	25	A60-OBNA2	66252835055
6 x .060 x 1/2	10,190	25	A60-OBNA2	66252835164
6 x .060 x 1/2	10,190	25	57A364-TB25N	66252822969
6 x .060 x 1-1/4	10,190	25	A60-OBNA2	66252835165
7 x .035 x 1/2	8,730	25	A60-OBNA2	66252938786
7 x .035 x 1-1/4	8,730	25	A60-OBNA2	66252938788
7 x .060 x 1/2	8,730	25	A60-OBNA2	66252938816
7 x .060 x 1-1/4	8,730	25	A60-OBNA2	66252938796
7 x .060 x 1-1/4	8,730	25	57A364-TB25N	66252922676

SIZE (D x T x H)	MAX. RPM	STD. PKG.	TIER: BETTER	
			SPEC.	PART NO.
Type O1 Flat Cut-off – Reinforced				
8 x .035 x 1/2	7,640	25	A60-OBNA2	66253043014
8 x .035 x 1-1/4	7,640	25	A60-OBNA2	66253042980
8 x .060 x 1/2	7,640	25	A60-OBNA2	66253043009
8 x .060 x 1-1/4	7,640	25	A60-OBNA2	66253042983
8 x .060 x 1-1/4	7,640	25	57A364-TB25N	66253022705
10 x .060 x 5/8	6,110	25	A60-OBNA2	66253149317
10 x .060 x 1-1/4	6,110	25	A60-OBNA2	66253149186
12 x .060 x 1	5,095	10	A60-OBNA2	66253261811
12 x .075 x 1	5,095	10	A60-OBNA2	66253261910
12 x .075 x 1-1/4	5,095	10	A60-OBNA2	66253261858



TOOLROOM NON-REINFORCED CUT-OFF WHEELS

BETTER CHOICE FOR CUTTING TOOL STEEL ON FIXED-BASED MACHINES WHEN THE WORK IS SECURELY CLAMPED

FEATURES

- B bond (smooth sides)
- B25 bond (smooth sides)
- E7 bond (smooth sides)
- R30 bond (smooth sides)
- R55 bond (rough sides)

BENEFITS

- A mild acting resin bond for light cut-off applications
- A versatile, free-cutting, more durable resin bond
- Ideal for dry cutting metal in high production runs
- A shellac bond with very mild cutting action, recommended for highly critical applications where no burr, heat checks, or discoloration is permitted
- Mild acting rubber bond primarily for wet, ultra-thin cutting
- Versatile, free cutting, rubber bond used primarily for wet cut-off

AVAILABILITY

SIZE (D x T x H)	MAX. RPM	STD. PKG.	TIER: BETTER	
			SPEC.	PART NO.
Type O1 Flat Cut-off – Non-Reinforced				
6 x .015 x 1-1/4	6,370	25	57A90-R0R30	66252822953
6 x .020 x 1-1/4	6,370	25	57A90-R0R30	66252822954
6 x .035 x 1-1/4	6,370	25	57A60-M8B	66252822958
6 x .060 x 1/2	7,640	25	57A541-RB25	66252822970
6 x .060 x 1-1/4	7,640	25	57A60-M8B	66252822975
7 x .035 x 1-1/4	5,460	25	57A60-M8B	66252922983
			57A60-O8B	66252922986
			57A60-Q8B	66252922987
7 x .035 x 1-1/4	5,460	25	57A601-PB25	66252922988
			57A601-RB25	66252922989
7 x .035 x 1-1/4	5,185	25	57A60-OE7	66252922985
7 x .035 x 1-1/4	5,460	25	23A601-PB25	66252938701
7 x .050 x 1-1/4	5,460	25	23A601-PB25	66252938724*
7 x .060 x 1/2	6,550	25	57A60-O8B	66252922672
7 x .060 x 1-1/4	6,550	25	57A46-M8B	66252922677
			57A60-M8B	66252922681
			57A60-O8B	66252922684

SIZE (D x T x H)	MAX. RPM	STD. PKG.	TIER: BETTER	
			SPEC.	PART NO.
Type O1 Flat Cut-off – Non-Reinforced				
7 x .060 x 1-1/4	5,185	25	57A60-OE7	66252922683
7 x .090 x 1-1/4	6,550	25	57A60-M8B	66252922690
7 x .125 x 1-1/4	6,550	25	57A60-M8B	66252922692
8 x .035 x 1-1/4	4,775	25	57A60-N8B	66253022694
8 x .060 x 1/2	5,730	25	57A60-M8B	66253022702
8 x .060 x 1-1/4	5,730	25	57A60-M8B	66253022708
8 x .060 x 1-1/4	4,540	25	57A60-OE7	66253022709
10 x .060 x 5/8	4,585	25	57A46-Q8BW	66253122816
			57A60-M8BW	66253122818
10 x .060 x 5/8	4,585	25	57A46-P4R55	66253122815
			57A80-P6R55	66253122819
10 x .090 x 5/8	4,585	25	57A60-M8BW	66253122824

*EXCEPTION: ROUGH SIDES



CATEGORY DEFINITION

The Norton metallurgical line of Type O1 straight cut-off wheels was developed specifically for sectioning of metal samples; burr-free cutting, minimal burn and distortion.

APPLICATIONS: Designed specifically for cutting off metal samples ranging from mild steel to super alloys on fixed-based machinery by scientists, engineers, and lab technicians

SIZE RANGE: 9" – 14" diameter

MATERIALS CUT: Steels, Nonferrous Materials, and Titanium / Titanium Alloys

CROSS REFERENCE GUIDE

Size	Material	NORTON		BUEHLER		LECO		STRUERS	
		Spec.	Part No.	Metabrase Part No.	BuehlerMet II Part No.	Part No.	Part No.	Part No.	Axitom/-5 Part No.
9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	Very Hard Steels (Rc 55 - 68)	ML-109	66253117874	10-4110-010					60A24*
	Hard Steels (Rc 40 - 55)	ML-209	66253117875	10-4112-010	10-5110-010	811-035-010			50A24*
	Medium Steels (Rc 30 - 40)	ML-309	66253117877	10-4116-010	10-5112-010	811-043-010			40A24*
	Soft Steels (Rc 20 - 30)	ML-409	66253117828	10-4120-010	10-5116-010	811-049-010			30A24*
	Nonferrous Materials	ML-509	66253117829	10-4145-010		811-053-010			10S24*
10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	Titanium / Titanium Alloys	ML-609	66253117878	10-4150-010		811-053-010			20S24*
	Very Hard Steels (Rc 55 - 68)	ML-110	66253117879	10-4210-010		808-673	812-231		60A25•
	Hard Steels (Rc 40 - 55)	ML-210	66253117880	10-4212-010	10-5210-010	811-059-010	810-310-010		54A25•
	Medium Steels (Rc 30 - 40)	ML-310	66253117881	10-4216-010	10-5212-010	811-067-010	810-310-010		40A25•
	Soft Steels (Rc 20 - 30)	ML-410	66253117830	10-4220-010	10-5216-010	811-073-010			30A25•
12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	Nonferrous Materials	ML-510	66253117831	10-4245-010	10-5245-010	810-313-010			10S25•
	Titanium / Titanium Alloys	ML-610	66253117882	10-4246-010		810-313-010	811-077-010		20S25•
	Very Hard Steels (Rc 55 - 68)	ML-112	66253322151	10-4410-010		808-674	811-065-010		60A30†
	Hard Steels (Rc 40 - 55)	ML-212	66253322152	10-4412-010	10-5410-010	811-081-010	810-311-010		50A30†
	Medium Steels (Rc 30 - 40)	ML-312	66253322153	10-4416-010	10-5412-010	811-089-010	810-311-010		40A30†
13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	Soft Steels (Rc 20 - 30)	ML-412	66253322099	10-4420-010	10-5416-010	811-095-010	810-311-010		30A30†
	Nonferrous Materials	ML-512	66253322100	10-4445-010	10-5445-010	810-314-010			10S30†
	Titanium / Titanium Alloys	ML-612	66253322154	10-4450-010		810-314-010			20S30†
	Very Hard Steels (Rc 55 - 68)	ML-114	66253322863	10-4310-010		808-675	812-232		60A35▲ 50A35
	Hard Steels (Rc 40 - 55)	ML-214	66253322156	10-4312-010	10-5310-010	809-346	811-977-010		40A35▲ 40A35
13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	Medium Steels (Rc 30 - 40)	ML-314	66253322157	10-4316-010	10-5312-010	811-976-010	811-977-010		40A35▲ 30A35
	Soft Steels (Rc 20 - 30)	ML-414	66253322158	10-4320-010		811-978-010			30A35▲ 20A35
	Nonferrous Materials	ML-514	66253322159	10-4345-010	10-5345-010	811-980-010			10S35▲ 10S35
	Titanium / Titanium Alloys	ML-614	66253322160	10-4350-010		811-980-010			30S35▲ 20S35

* DISCOTOM/LABOTOM • DISCOTOM-5/-6/LABOTOM-3 † UNITOM/DISCOTOM-50/-60/-65 ▲ EXOTOM/UNITOM-2/-5/-50

AVAILABILITY

SIZE (D x T x H)	MAX. RPM	STD. PKG.	PRODUCT NO.	APPLICATION	TIER:	BEST
						PART NO.
Type O1 Cut-off – Non-Reinforced						
9 x .063 x 1-1/4 (229mm x 1.6mm x 32mm)	4,025	10	ML-109	Very Hard Steels (Rc 55 - 68)		66253117874
			ML-209	Hard Steels (Rc 40 - 55)		66253117875
			ML-309	Medium Steels (Rc 30 - 40)		66253117877
			ML-409	Soft Steels (Rc 20 - 30)		66253117828
			ML-509	Nonferrous Materials		66253117829
10 x .063 x 1-1/4 (254mm x 1.6mm x 32mm)	3,500	10	ML-609	Titanium / Titanium Alloys		66253117878
			ML-110	Very Hard Steels (Rc 55 - 68)		66253117879
			ML-210	Hard Steels (Rc 40 - 55)		66253117880
			ML-310	Medium Steels (Rc 30 - 40)		66253117881
			ML-410	Soft Steels (Rc 20 - 30)		66253117830
12 x .078 x 1-1/4 (305mm x 2.0mm x 32mm)	3,820	10	ML-510	Nonferrous Materials		66253117831
			ML-610	Titanium / Titanium Alloys		66253117882
			ML-112	Very Hard Steels (Rc 55 - 68)		66253322151
			ML-212	Hard Steels (Rc 40 - 55)		66253322152
			ML-312	Medium Steels (Rc 30 - 40)		66253322153
13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	2,770	10	ML-412	Soft Steels (Rc 20 - 30)		66253322099
			ML-512	Nonferrous Materials		66253322100
			ML-612	Titanium / Titanium Alloys		66253322154
			ML-114	Very Hard Steels (Rc 55 - 68)		66253322863
			ML-214	Hard Steels (Rc 40 - 55)		66253322156
13.75 x .098 x 1-1/4 (350mm x 2.5mm x 32mm)	2,770	10	ML-314	Medium Steels (Rc 30 - 40)		66253322157
			ML-414	Soft Steels (Rc 20 - 30)		66253322158
			ML-514	Nonferrous Materials		66253322159
			ML-614	Titanium / Titanium Alloys		66253322160