



## Precision Mounted Points





# Master MOUNTED POINTS

## Quality Assured

- Perfectly concentric and uniform
- Securely fixed to shank
- Versatile application
- Comprehensive range

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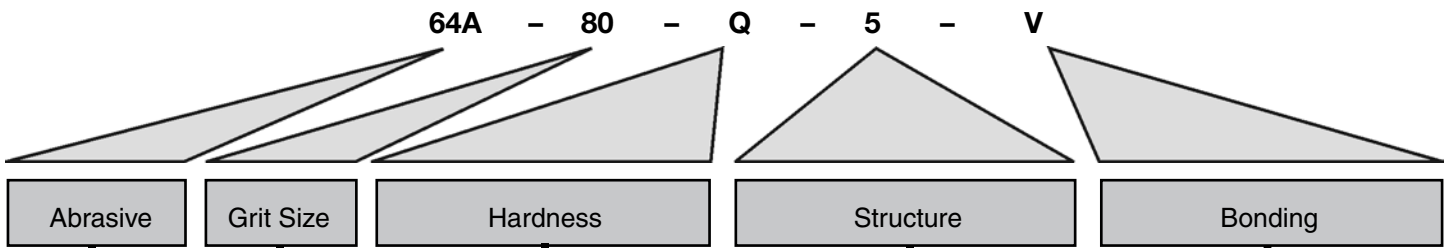
### STANDARD SPECIFICATIONS

- 61A Aluminous Oxide with low to medium Chromium Oxide content (pink colour)
- 63A Mixture of 64A and 61A (ruby pink colour)
- 64A Aluminous Oxide with high Chromium Oxide content (ruby colour)
- 72A Blue Aluminous Oxide
- 33C Black Silicon Carbide

SPECIFICATION	SHAPE	APPLICATION
61A-80S5-V	W shapes (small & medium)	General die work when only slight stock removal is required.
64A-60Q5-V	A shapes and W shapes (medium)	Excellent Stock removal on die work, precision castings, general grinding operations and deburring.
64A-80Q5-V	B shapes and W shapes (small)	
64A-120Q5-V	B shapes	
64A-46S5-V	A shapes and W shapes (large)	Autobody dies, miscellaneous larger dies, cast iron and manganese steel.
72A-60Q5-V	A shapes	General Die work with low to medium stock removal to produce an excellent finish.
72A-80Q5-V	A shapes and W shapes (medium)	
72A-100Q5-V	W shapes (small)	
72A-120Q5-V	B shapes	
72A-46R5-V	W shapes (large)	
		Steel castings, large die work and general grinding operations.



# FORMULATION CHART FOR Master MOUNTED POINTS



Abrasive      Grit Size      Hardness      Structure      Bonding

Grit sizes are stated by numbers from coarse to fine

<i>coarse</i>	<i>med.</i>	<i>fine</i>	<i>very fine</i>
16	46	80	220
20	60	100	240
24		120	
36		150	
		180	

Grit sizes are equivalent to number of mesh per linear inch of screen.

The porosity of a wheel is given by the relation between the volume of pores and bonding plus grit volume.

Current porosity designation:  
3 (dense), 5 (medium).

Hardness grade is the measurement of bonding strength holding the abrasive grain within the bond matrix. Hardness is expressed by letters and increases by alphabetical order:

<i>Soft</i>	<i>Medium</i>	<i>Hard</i>	<i>Very Hard</i>
J	L	P	S
K	M	Q	T
	N	R	U
	O		





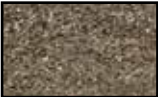



The bonding is the matrix holding together the abrasive grit.

**Bonding types**



Vitrified = V  
Resin = B

The number following the bonding type is the manufacturer's reference.

**Aluminium Oxides**

							
61A pink	62A white	63A mix pink 61A + ruby 64A	64A ruby	66A mix pink 61A + blue 72A	67A mix white 62A + blue 72A	71A off white mono-bloc	72A blue

**Silicon Carbides**

	
31C green	33C dark

# 'W' SHAPES (CYLINDRICAL)

# STANDARD SPECIFICATIONS

SHAPE	DIMENSIONS dia. x length mm	SHANK diameter	Max. Safe operating speed (RPM) x 1,000 at 13mm overhang	61A					63A			64A			72A					
				36Q5 V	60Q5 V	80Q5 V	80S5 V	120S5 V	46Q5 V	46S5 V	60Q5 V	80Q5 V	120Q5 V	46Q5 V	46R5 V	60Q5 V	80Q5 V	80R5 V	100Q5 V	
W140	2 x 5																			
W141	2.5 x 5																			
W142	2.5 x 6	1/8"	105										●							
W143	3 x 5																			
W144	3 x 6	1/8"	105					●												●
W144	3 x 6	3mm	105																	●
W145	3 x 10	1/8"	105					●					●							●
W145	3 x 10	3mm	105										●							
W146	3 x 13	1/8"	105											●						●
W146	3 x 13	3mm	105											●						
W149	4 x 6																			
W151	5 x 3																			
W152	5 x 6	3mm	105			●														
W153	5 x 10	1/8"	80										●						●	
W153	5 x 10	3mm	80										●							●
W154	5 x 13	1/8"	70			●												●		
W154	5 x 13	3mm	70					●												
W155	5.5 x 6																			
W158	6 x 3																			
W159	6 x 5																			
W160	6 x 6	1/8"	81										●							
W160	6 x 6	3mm	81											●						
W161	6 x 8																			
W162	6 x 10	1/8"	68					●												●
W163	6 x 13	1/8"	60			●								●						●
W163	6 x 13	3mm	60			●								●						●
W163	6 x 13	1/4"	76																	●
W164	6 x 20	1/8"	45											●						●
W164	6 x 20	3mm	45											●						
W166	8 x 3																			

Shaded areas denote non standard shapes subject to special manufacture.

● = STANDARD SPECIFICATION



# 'W' SHAPES (CYLINDRICAL)

# STANDARD SPECIFICATIONS

SHAPE	DIMENSIONS dia. x length mm	SHANK diameter	Max. Safe operation speed (RPM) x 1,000 at 13mm overhang	61A		63A	64A		72A										
				36Q5	46R3	60Q5	80S5	120S5	36S5	60Q5	46S5	60Q5	80Q5	120Q5	46Q5	60Q5	80Q5	80R5	100Q5
				V	V	V	V	V	V	V	V	V	V	V	V	V	V	V	V

W167	8 x 6																		
W168	8 x 8																		
W169	8 x 10																		
W170	8 x 13																		
W171	8 x 20																		
W173	10 x 3																		
W174	10 x 6	1/8"	69															●	
W175	10 x 10	1/8"	54						●									●	
W175	10 x 10	3mm	54						●									●	
W176	10 x 13	1/8"	45						●									●	
W176	10 x 13	3mm	45						●		●							●	
W176	10 x 13	1/4"	81						●										
W177	10 x 20	6mm	66				●												
W177	10 x 20	1/4"	66														●		
W178	10 x 25	1/8"	26															●	
W178	10 x 25	1/4"	55							●									
W178	10 x 25	6mm	55							●									
W179	10 x 32	1/4"	45							●								●	
W179	10 x 32	6mm	45							●									
W182	13 x 3	1/8"	73																●
W182	13 x 3	3mm	73																
W183	13 x 6																		
W184	13 x 10																		
W185	13 x 13	1/8"	34				●												●
W185	13 x 13	3mm	34															●	
W185	13 x 13	1/4"	61																●
W185	13 x 13	6mm	61				●											●	
W186	13 x 20																		
W187	13 x 25	1/4"	40																●
W187	13 x 25	6mm	40																●
W188	13 x 38	1/4"	30																●
W188	13 x 38	6mm	30															●	
W189	13 x 50																		
W191	16 x 3																		
W192	16 x 6																		
W193	16 x 10																		
W194	16 x 13																		
W195	16 x 20																		
W196	16 x 25	6mm	35																●
W197	16 x 50	6mm	21																
W198	16 x 63																		
W200	20 x 3	1/8"	47																●
W201	20 x 6	3mm	38																●
W202	20 x 10																		
W203	20 x 13																		
W204	20 x 20	1/4"	42																●
W205	20 x 25	1/4"	34																
W205	20 x 25	6mm	34																●
W206	20 x 32																		
W207	20 x 38																		

Shaded areas denote non standard shapes subject to special manufacture.

● = STANDARD SPECIFICATION

# 'W' SHAPES (CYLINDRICAL)

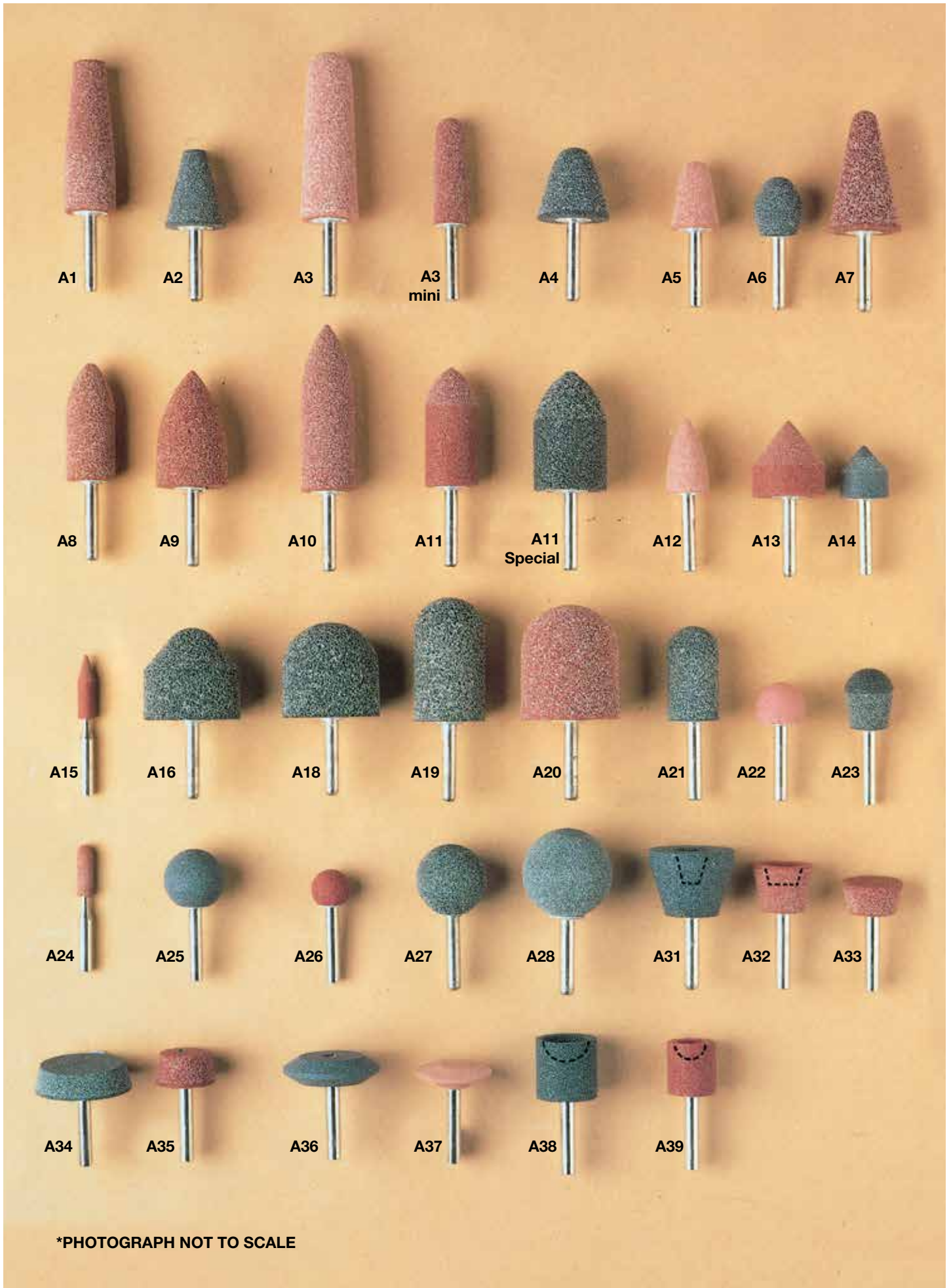
# STANDARD SPECIFICATIONS

SHAPE	DIMENSIONS dia. x length mm	SHANK diameter	Max. Safe operation speed (RPM) x 1,000 at 13mm overhang	61A				63A		64A			72A					
				4605 V	46R3 V	60S5 V	80S5 V	120S5 V	4605 V	46S5 V	60Q5 V	80Q5 V	120Q5 V	4605 V	46R5 V	60Q5 V	80Q5 V	80R5 V
W208	20 x 50	1/4"	18						●									
W208	20 x 50	6mm	18						●									
W209	20 x 63																	
W211	22 x 3																	
W212	22 x 6																	
W213	22 x 10																	
W214	23 x 6																	
W215	25 x 3	1/8"	38															●
W215	25 x 3	3mm	38								●							
W215	25 x 3	6mm	38								●							
W216	25 x 6	6mm	38		●						●					●		
W217	25 x 10																	
W218	25 x 13																	
W219	25 x 20																	
W220	25 x 25	6mm	25						●					●				
W221	25 x 38																	
W222	25 x 50																	
W222	25 x 50	6mm	15						●					●				
W223	25 x 63																	
W224	25 x 76																	
W225	32 x 6	1/4"	29													●		
W225	32 x 6	6mm	29		●													
W226	32 x 10	6mm	29							●								
W227	32 x 13	1/4"	30														●	
W228	32 x 20																	
W229	32 x 25																	
W230	32 x 32																	
W231	32 x 38																	
W232	32 x 50																	
W233	32 x 63																	
W234	32 x 76																	
W235	38 x 6	6mm	25							●								
W236	38 x 13	1/4"	25								●				●			
W236	38 x 13	6mm	25		●					●					●			
W237	38 x 25																	
W238	38 x 38																	
W239	38 x 50																	
W240	38 x 63																	
W241	38 x 76																	
W242	50 x 25	1/4"	19						●									
W242	50 x 25	6mm	19						●									
W243	50 x 38																	
W244	50 x 50																	
W245	50 x 63																	
W246	50 x 76																	

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● = STANDARD SPECIFICATION

# 'A' SHAPES





# 'A' SHAPES

# STANDARD SPECIFICATIONS

SHAPE	DIMENSIONS dia. x length mm	Max. Safe operating speed (RPM) x 1,000 at 13mm overhang	33C		61A		63A		64A		72A						
			46R5 V	37U5 V	46R3 V	80S5 V	60Q5 V	46S5 V	60Q5 V	80Q5 V	24/30R5 V	46R5 V	60Q5 V	80Q5 V	80R5 V	120Q5 V	
A1	22 x 63	19	●			●		●				●					
A1small	20 x 63																
A2	25 x 32	38										●					
A3	25 x 70	16	●	●	●			●			●	●					
A3 mini	16 x 45	17			●	●		●				●					
A4	32 x 32	29					●					●					
A5	20 x 28	45			●				●			●					
A6	20 x 28																
A7	30 x 50																
A8	20 x 50																
A9	30 x 50																
A10	22 x 70																
A11	22 x 50	19	●	●				●			●	●					
A11 special	30 x 50	14									●						
A12	20 x 32	48							●				●				
A13	30 x 32	33							●								
A14	20 x 22	53							●					●			
*A15	6.5 x 27	72				●				●				●			
A16	40 x 40																
A18	40 x 40																
A19	30 x 50																
A20	40 x 50																
A21	25 x 25	34							●								
A22	20 x 16	50							●								
A23	20 x 25																
*A24	6.5 x 20	76				●				●				●		●	
A25	Ø25	35							●					●			
A26	Ø16	59							●								
A27	Ø30																
A28	Ø40																
A31	35 x 27	27							●			●	●				
A32	25 x 19	38							●								
A33	25 x 13	38										●					
A34	40 x 11	25							●			●					
A35	25 x 11																
A36	40 x 11	23								●							
A37	30 x 7	29								●		●					
A38	25 x 25	34							●			●					
A39	20 x 20	47							●								

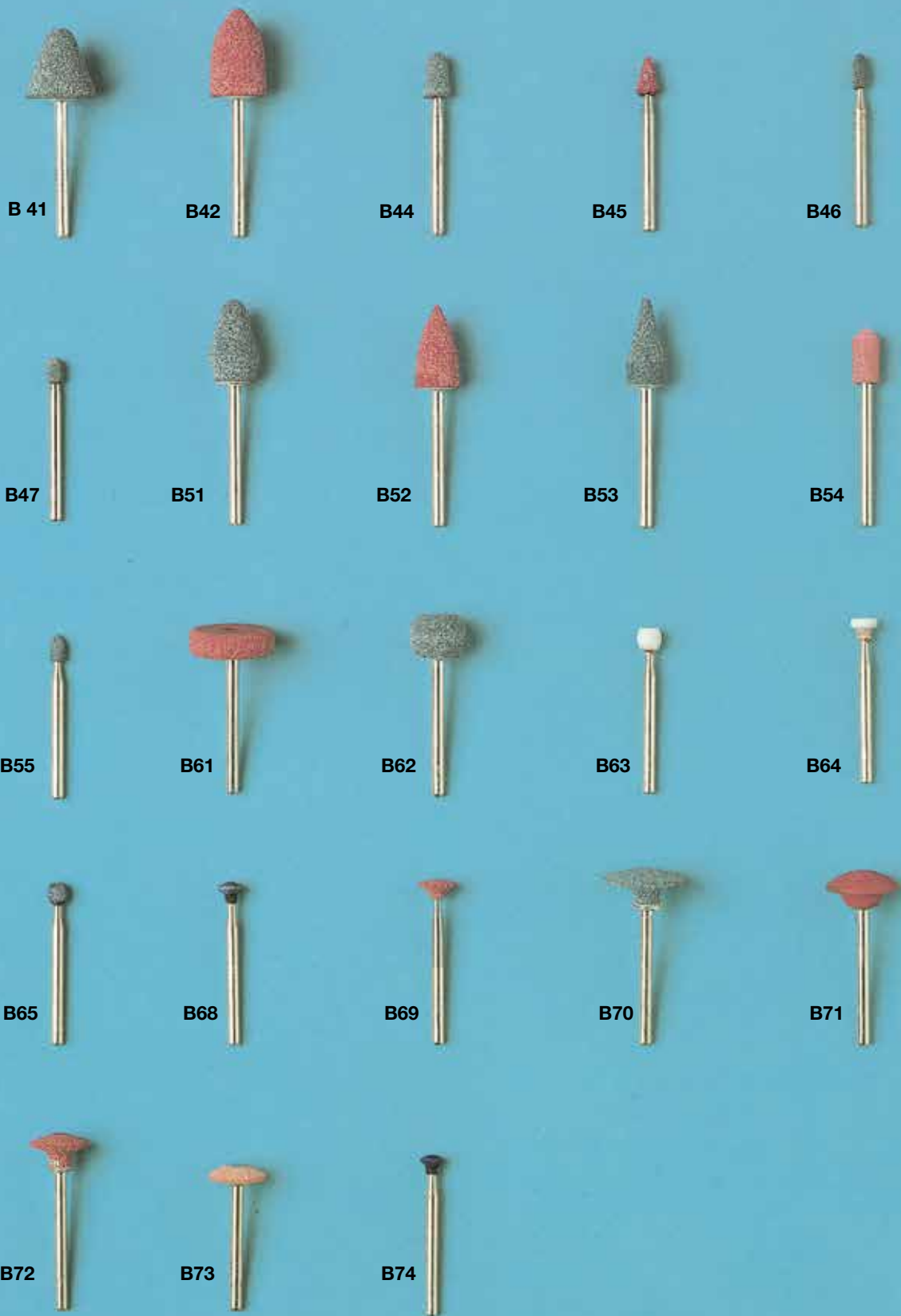
The above shapes are all available on 6.0mm or 6.35mm (1/4") shanks. Shapes A15 & A24 are also available on 3.00mm\* or 3.175mm (1/8") shanks. The maximum safe operating speed r.p.m x 1000 at 13mm overhang are

A15/3	39
A24/3	52

Shaded areas denote non standard shapes subject to special manufacture.

● = STANDARD SPECIFICATION

# 'B' SHAPES



\*PHOTOGRAPH NOT TO SCALE

# 'B' SHAPES

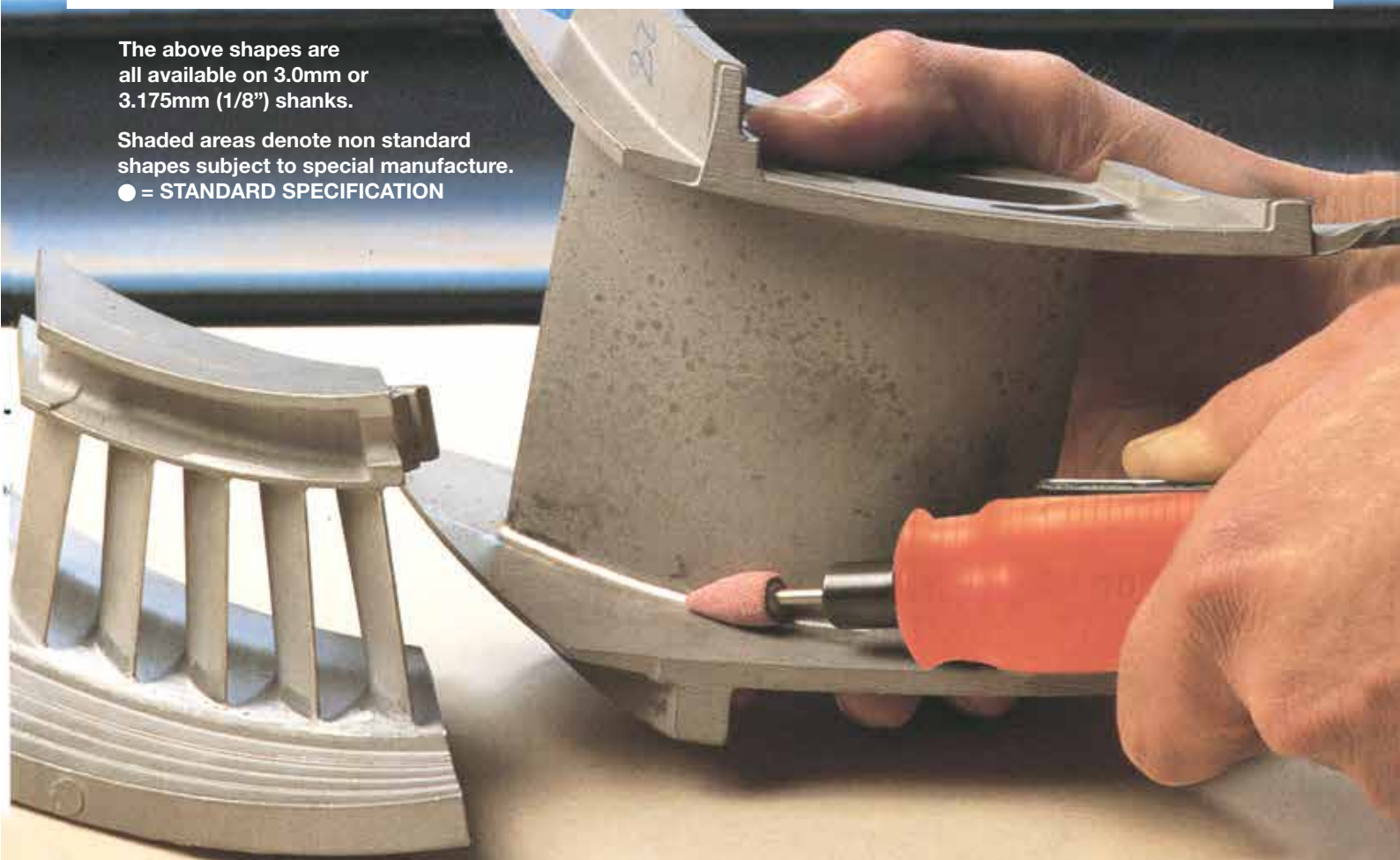
# STANDARD SPECIFICATIONS

SHAPE	DIMENSIONS dia. x length mm	Max. Safe operating speed (RPM) x 1,000 at 13mm overhang	61A				64A		72A					
			60Q5 V	80Q5 V	120Q5 V	120S5 V	80Q5 V	120Q5 V	80Q5 V	80R5 V	100P5 V	100Q5 V	120Q5 V	
B41	16 x 16	33					●							
B42	13 x 20	33						●						
B44	6 x 10	68			●			●						
B45	5 x 8	104					●							
B46	4 x 8	105											●	
B47	4 x 4													
B51	11 x 20													
B52	10 x 20	45	●				●		●					
B53	8 x 20	42					●	●	●				●	
B54	6 x 13													
B55	3 x 6													
B61	20 x 10													
B62	13 x 10													
B63	6 x 5													
B64	6 x 3													
B65	3 x 3													
B68	6 x 2													
B69	8 x 3													
B70	20 x 3													
B71	16 x 4	59						●						
B72	13 x 4													
B73	13 x 4													
B74	5 x 2													

The above shapes are all available on 3.0mm or 3.175mm (1/8") shanks.

Shaded areas denote non standard shapes subject to special manufacture.

● = STANDARD SPECIFICATION



# 'B' SHAPES



\*PHOTOGRAPH NOT TO SCALE

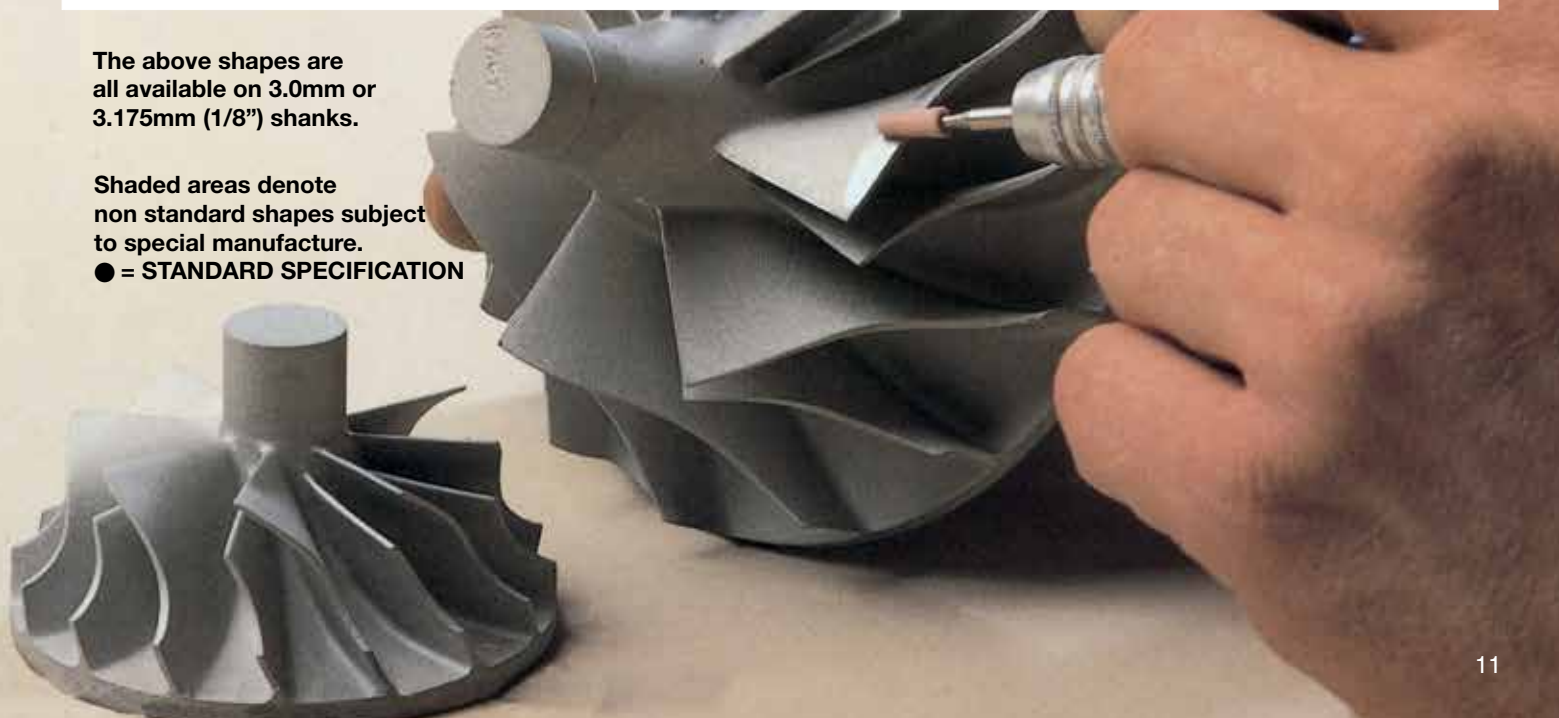
# 'B' SHAPES

# STANDARD SPECIFICATIONS

SHAPE	DIMENSIONS dia. x length mm	Max. Safe operating speed (RPM) x 1,000 at 13mm overhang	61A		64A		72A						
			60Q5 V	80Q5 V	120Q5 V	120S5 V	80Q5 V	120Q5 V	80Q5 V	80R5 V	100P5 V	100Q5 V	120Q5 V
B81	20 x 5	47					●						●
B82	13 x 6												
B83	9 x 5												
B84	8 x 5												
B90	13 x 13												
B91	13 x 16	34				●							
B92	6 x 6	81					●						●
B93	5 x 5												
B94	4 x 2												
B95	3 x 5												
B96	3 x 6	105					●						
B97	4 x 10	105		●	●	●	●						●
B101	16 x 20												
B102	16 x 14												
B103	16 x 6	59					●						
B104	8 x 10	68				●							
B105	6 x 6												
B106	3 x 3												
B108	16 x 5												
B109	8 x 3												
B110	2 x 3												
B112	10 x 13												
B113	6 x 6												
B114	5 x 9												
B115	2 x 3												
B121	Ø13	45				●			●				
B122	Ø10	61		●					●				●
B123	Ø5	104	●				●		●				●
B124	Ø3	105					●						
B125	Ø6												
B130	20 x 13												
B131	13 x 13	34				●			●				
B132	10 x 13	45				●			●				
B133	10 x 10	54							●				
B134	8 x 9												
B135	6 x 13	60					●						
B136	6 x 8												

The above shapes are all available on 3.0mm or 3.175mm (1/8") shanks.

Shaded areas denote non standard shapes subject to special manufacture.  
● = STANDARD SPECIFICATION





# MASTERFLEX

## MOUNTED POINTS

Masterflex mounted points are the answer to difficult grinding and finishing work on stainless steel/aluminium fabrications and precision castings. Masterflex mounted points are also widely used in tool rooms and die shops for maintenance and rectification work on moulds and dies.

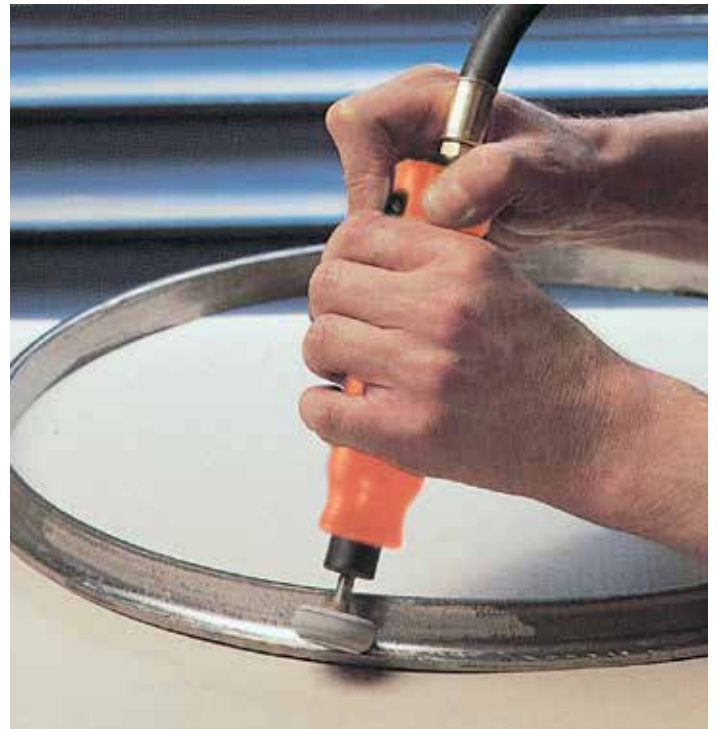
Our Masterflex range of points is unique in construction and versatile in application as they remove stock and polish.

Unlike standard bonded or coated abrasives Masterflex products are laminates of reinforced non-woven cotton fibre. The cutting and finishing properties are the result of abrasive grain and fibres impregnated by a special process. This material is then pressed and bonded to produce uniformly impregnated abrasive points.

The complete range of Masterflex points combines the free cutting qualities of vitrified points with the smoothing and finishing action of coated abrasives to meet a wide range of grinding, blending and polishing applications.

## APPLICATIONS

The Masterflex range of points was developed specifically for the grinding, polishing and blending of stainless steel, aluminium and other metals, steels and alloys.



Industrial users include: aerospace, shipbuilding, jewellery, toolmakers, automotive industry, cutlery and manufacturers of stainless steel pressure vessels, storage tanks, heat exchangers, hoppers and sinks. Fabricators of stainless steel equipment for catering, hospitals, textile machinery, dairies, breweries, nuclear plants, and food and chemical processing plants. Gear deburring on automatic machines and many other applications.





## MOUNTED POINTS

### SPECIAL FEATURES AND ADVANTAGES:

Faster stock removal  
More aggressive cutting action  
Cooler cut

No loading  
Longer life

### SMOOTH ACTION

With its soft cushion-like action it eliminates vibration or chatter, it is fast and effective for a smooth uniform finish.

## FORMULATION CHART

### A 80 G FX

**Abrasive      Grain Size      Grade      Bond**

<b>A</b> (Aluminium Oxide)	24	Coarse	G	Soft	FX – Latex TX – Resin
	36				
	54	Medium			
	80				
	120	Fine	K	Hard	
	180				
	220	V.Fine	M		
	320				

## STANDARD SPECIFICATIONS

### SPECIFICATION/APPLICATION

**A36 GFX** Blending contours of stainless steel welded fabrications and precision castings.

**A36 MTX** Smoothing contours of aluminium welded fabrications.

**A80 GFX** Polishing and touch up work on moulds and dies.

Removal of sharp edges or burrs caused by previous operations.

Deburring jet engine blades and gas turbine blades.

**A80 MTX** Polishing welded corners of stainless steel fabrications.

Deflashing and polishing die castings.



# MASTERFLEX MOUNTED POINTS 'W' SHAPES (cylindrical)

## STANDARD SPECIFICATIONS

SHAPE	DIMENSIONS dia. x length mm	SHANK diameter	Max. Safe operating speed (RPM) x 1,000 at 13mm overhang	A36	A54	A54	A80	A80	A120	A120	A180
				GFX	GFX	MTX	GFX	MTX	GFX	MTX	GFX

W163	6 x 13	1/8"	60				●	●	●	●	●
W163	6 x 13	3mm	60				●	●	●	●	●
W175	10 x 10	1/8"	54				●	●	●	●	●
W176	10 x 10	3mm	54				●	●	●	●	●
W177	10 x 20	1/8"	34				●	●	●	●	●
W177	10 x 20	3mm	34	●	●	●	●	●	●	●	●
W185	13 x 13	1/8"	34	●	●	●	●	●	●	●	●
W185	13 x 13	3mm	34	●	●	●	●	●	●	●	●
W185	13 x 13	1/4"	61	●	●	●	●	●	●	●	●
W185	13 x 13	6mm	61	●	●	●	●	●	●	●	●
W187	13 x 25	1/4"	40	●	●	●	●	●	●	●	●
W187	13 x 25	6mm	40			●	●	●	●	●	●
W201	20 x 6	1/4"	47			●	●	●	●	●	●
W201	20 x 6	6mm	47		●		●	●	●		
W204	20 x 20	1/4"	42		●		●	●	●		
W204	20 x 20	6mm	42		●		●	●	●		
W205	20 x 25	1/4"	34		●		●	●	●		
W205	20 x 25	6mm	34		●		●	●	●		
W207	20 x 38	1/4"	24		●		●	●	●		
W207	20 x 38	6mm	24				●				
W208	20 x 50	1/4"	18				●				
W208	20 x 50	6mm	18				●				
W216	25 x 6	1/4"	38				●	●	●	●	●
W216	25 x 6	6mm	38				●	●	●	●	●
W220	25 x 25	1/4"	25		●	●	●	●			
W220	25 x 25	6mm	25		●	●	●	●			
W227	32 x 13	1/4"	30	●	●		●	●			
W227	32 x 13	6mm	30	●	●		●	●			
W235	38 x 6	1/4"	25				●	●	●	●	●
W235	38 x 6	6mm	25				●	●	●	●	●
W236	38 x 13	1/4"	25	●	●		●	●			
W236	38 x 13	6mm	25	●	●		●	●			
W242	50 x 25	1/4"	19		●	●	●	●			
W242	50 x 25	6mm	19		●	●	●	●			

● = STANDARD SPECIFICATION

### CONDENSED OPERATING RULES FOR MOUNTED POINTS

#### STANDARD MAXIMUM SPEEDS

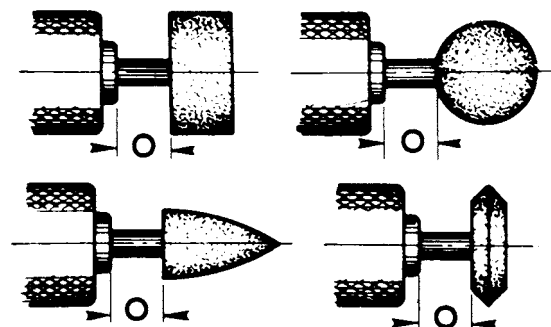
The maximum operating speed for mounted points is 9,000 surface feet per minute (SFPM)

The following factors may require a reduction in speed:

1. Shape and size of the mounted point.
2. Size of mandrel.
3. Overhang of mandrel.
4. Points specifications.

Taking the first three factors noted above into consideration, look up the maximum operating speed in the corresponding tables.

The overhangs indicated on the tables are for unthreaded mandrels. Threaded mandrels will take the same as the 13mm overhang of the unthreaded mandrel.



Drawings defining overhang Dimension "O"



# MASTERFLEX MOUNTED POINTS

## 'A' SHAPES

## STANDARD SPECIFICATIONS

SHAPE	DIMENSIONS dia. x length mm	SHANK diameter	Max. Safe operating speed (RPM) x 1,000 at 13mm overhang	A36	A54	A54	A80	A80	A120	A120	A180
				GFX	GFX	MTX	GFX	MTX	GFX	MTX	GFX

A1	22 x 63	1/4"	19	●	●		●	●	●		
A2	22 x 63	6mm	19	●	●		●	●	●		
A3	25 x 70	1/4"	16		●	●	●	●	●		
A3	25 x 70	6mm	16		●	●	●	●	●		
A5	20 x 28	1/4"	45	●	●	●	●	●	●		
A5	20 x 28	6mm	45	●	●	●	●	●	●		
A11	22 x 50	1/4"	19		●	●	●	●			
A11	22 x 50	6mm	19		●	●	●	●			
A15	6.5 x 27	1/8"	39				●	●	●	●	●
A15	6.5 x 27	3mm	39				●	●	●	●	●
A15	6.5 x 27	1/4"	72				●	●	●	●	●
A15	6.5 x 27	6mm	72				●	●	●	●	●
A21	25 x 25	1/4"	34			●	●	●	●	●	
A21	25 x 25	6mm	34			●	●	●	●	●	
A24	6.5 x 20	1/4"	45				●	●	●	●	●
A24	6.5 x 20	6mm	45				●	●	●	●	●
A24	6.5 x 20	1/4"	76				●	●	●	●	●
A24	6.5 x 25	6mm	76	●			●	●	●	●	●

## 'B' SHAPES

B51	11 x 20	1/8"	45	●	●		●	●	●	●	
B51	11 x 20	3mm	45	●	●		●	●	●	●	
B52	10 x 20	1/8"	45				●	●	●	●	●
B52	10 x 20	3mm	45				●	●	●	●	●
B53	8 x 20	1/8"	60				●	●	●	●	●
B53	8 x 20	3mm	60				●	●	●	●	●
B91	13 x 16	1/8"	34	●	●		●	●	●	●	
B91	13 x 16	3mm	34	●	●		●	●	●	●	
B111	11 x 18	1/8"	34	●	●		●	●	●	●	
B111	11 x 18	3mm	34	●	●		●	●	●	●	
B121	Ø13	1/8"	45	●	●		●	●	●	●	
B121	Ø13	3mm	45	●	●		●	●	●	●	

● = STANDARD SPECIFICATIONS

### Work Pressure-

The pressure exercised on the mounted point should at no time result in considerable springing of the mandrel.

### Safety Precautions-

Wear eye protection or face shield. Ensure when mounting the points that neither the collet or the bearings of the tool are worn.

STORE, HANDLE AND USE WITH CARE.

# Make a quality decision
















## VITRIFIED MOUNTED POINTS



### CONTACT US FOR DETAILS OF OUR OTHER PRODUCTS

- Precision Internal Grinding Wheels
- Precision Toolroom Wheels
- CBN and Diamond Superabrasives
- Ceralox Ceramic Abrasives
- Non Woven Surface Finishing Products
- MASTERFLEX Polishing Products
- Coated Abrasives
- Pneumatic Tools, Accessories & Servicing
- Tungsten Carbide Rotary Burrs
- Flapwheels
- Dressing Equipment
- Grinding Quills
- Grinding Wheels
- Cut-off Wheels
- Cratex Rubber Products



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-  Grinding Quills
-  Grinding Wheels
-  Cut-off Wheels
-  Cratex Rubber Products

For further information on our products or advice on a particular applications problem please contact us at the address shown below.



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