

The Complete Cabinetry & Millwork Solution

Hermes High-Performance Abrasives for Woodworking





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FOR AN EXCELLENT FINISH**

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Hermes – for an excellent finish all

AT HERMES, TRADITION HAS A FUTURE

Hermes Schleifmittel is a Hamburg company in the true tradition, with roots going back to 1927. The company is not only one of the world's key manufacturers of coated abrasives – since 1993, it has also occupied a leading market position in the production of precision bonded abrasives.

Hermes owes this market position to its insistence on unsurpassed quality. We feel an obligation to this tradition and it is our main priority for the future. This obligation is the greatest incentive there is, and we devote all our energy and commitment to it – tradition shaping the future.

Hermes maintains numerous production sites and sales offices in all the main industrial and emerging nations of the world, underlining its international commitment and its efforts to provide its customers with a competent local consulting service.



4



1



5



2



3

A SELECTION OF OUR SITES

- 1 | Headquarters Hamburg, Germany
- 2 | Hermes Austria
- 3 | Hermes Poland
- 4 | Hermes USA
- 5 | Hermes China

over the world

SUPPORTING NATURE AND THE ENVIRONMENT

Compliance with national and international laws and regulations is one of the key principles of Hermes corporate policy and protection of the environment is a core constituent of our corporate responsibility. As a consequence, as long ago as 1996, Hermes was the first European abrasives factory to be successfully audited on a voluntary basis in line with the EMAS (Eco-Management and Audit Scheme).

The management system currently being implemented covers all areas of the company, with processes relevant to the environment and energy, as well as to quality, being described and monitored internally as well as certified externally by the TÜV-Nord organization in line with DIN EN ISO 14001 : 2009.

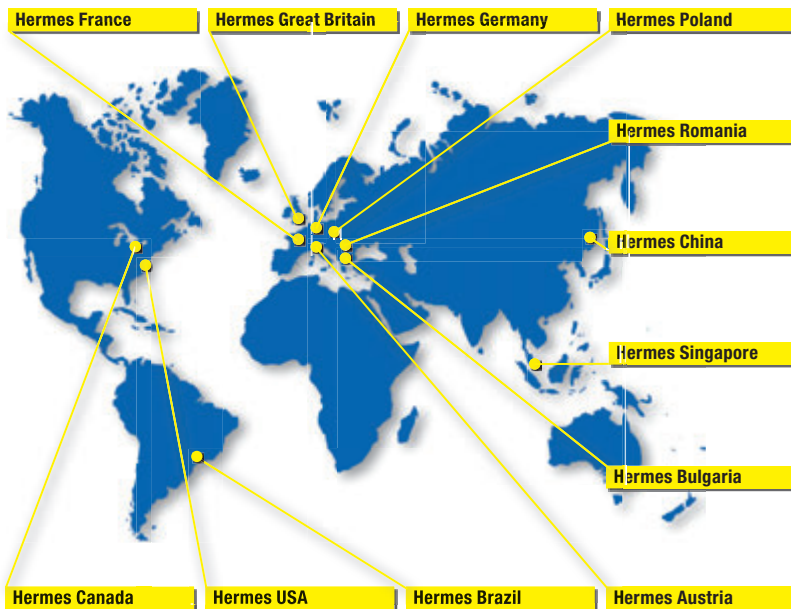


QUALITY – OUR TRADEMARK

Bound to tradition on the one hand, yet a pioneering developer of innovative products on the other, Hermes places greatest emphasis on the production of high-quality, state-of-the-art abrasives.

To enable this high standard of quality to be pursued and expanded still further in the future, the TÜV NORD CERT auditing company awarded the Hermes Group the quality seal for meeting the requirements of DIN EN ISO standard 9001.

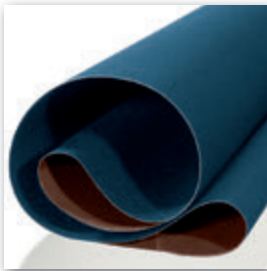
Our customers – in other words you – benefit considerably from this reliability.





Calibrating


Planing wood down to a rough dimension



RB 484 44 Z

☆☆☆ Premium

RB 484 44 Z (CODE 48444)

Abrasive grain	Zirconia alumina	Bonding	Resin, antistatic
Backing	Z-cloth	Coating	open
Grit range	24 - 80	Delivery form	 Wide belts up to 64" width

PRODUCT BENEFITS

- Aggressive and high grinding performance through novel mixtured zirconia alumina grain
- Highly tear-resistant polyester backing with low elongation provides high belt stability

☆☆ Performance

RB 316 36 Z OP (CODE 31636)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	Z-cloth	Coating	open
Grit range	60 - 80	Delivery form	 Wide belts up to 54" width

PRODUCT BENEFITS

- High stock removal rates for long belt life
- Consistent surface finishes for the life of the belt
- Improved dust control in the work area
- Open coat resists premature loading



RB 316 36 Z op

☆ Standard

RB 316 33 X OP (CODE 31633)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	X-cloth	Coating	open
Grit range	36, 50 - 80	Delivery form	 Wide belts up to 52" width

PRODUCT BENEFITS

- High stock removal rates for long belt life
- Consistent surface finishes for the life of the belt
- Improved dust control in the work area
- Open coat resists premature loading



RB 316 33 X op

Cloth Intermediate and Finishing Sanding

Final wide belt sanding prior to application to finish

☆☆☆ Premium

RB 316 36 Z OP (CODE 31636)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	Z-cloth	Coating	open
Grit range	80 - 180	Delivery form	 Wide belts up to 54" width

PRODUCT BENEFITS

- High stock removal rates for long belt life
- Consistent surface finishes for the life of the belt
- Improved dust control in the work area
- Open coat resists premature loading



RB 316 36 Z op

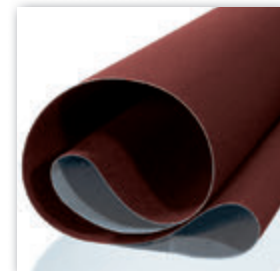
☆☆ Performance

RB 377 YX (CODE 37710)

Abrasive grain	Aluminum oxide	Bonding	Resin
Backing	YX-cloth	Coating	closed
Grit range	80 - 220	Delivery form	 Wide belts up to 64" width

PRODUCT BENEFITS


- Special aluminum oxide grain mix provides high stock removal rates in the coarse grit range
- Very constant surface quality in the fine grit range
- Polyester/cotton cloth backing ensures smooth running for belts and wide belts



RB 377 YX

☆ Standard

RB 316 33 X OP (CODE 31633)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	X-cloth	Coating	open
Grit range	80 - 220	Delivery form	 Wide belts up to 52" width

PRODUCT BENEFITS

- High stock removal rates for long belt life
- Consistent surface finishes for the life of the belt
- Improved dust control in the work area
- Open coat resists premature loading



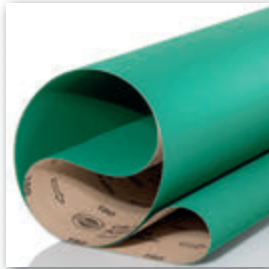
RB 316 33 X op



Paper Intermediate and Finish Sanding


Final wide belt sanding prior to application of finish

☆☆☆ Premium



CERAMIT® CR 116

CERAMIT® CR 116 (CODE 11623)

Abrasive grain	Ceramic	Bonding	Resin, antistatic
Backing	F-weight paper	Coating	semi-open
Grit range	80 - 180	Delivery form	 Wide belts up to 62" width

PRODUCT BENEFITS


- High stock removal rates and very long tool life especially on hard wood
- Low sanding temperatures

☆☆ Performance



CB 115

CB 115 (CODE 11523)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	F-weight paper	Coating	semi-open
Grit range	80 - 240	Delivery form	 Wide belts up to 54" width

PRODUCT BENEFITS


- High stock removal rates for long belt life
- Consistent surface finishes for the life of the belt
- Improved dust control in the work area
- Open coat resists premature loading

☆ Standard



BW 114

BW 114 (CODE 11400)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	F-weight paper	Coating	open
Grit range	80 - 400	Delivery form	 Wide belts up to 64" width

PRODUCT BENEFITS

- Very high stock removal rates, especially on softwood.
- Open coating and antistatic structure reduces loading with sanding dust, especially with resinous materials
- Stable and tear-resistant F-weight paper backing allows sanding with high sanding pressure

☆☆☆ Finish

BS 118 (CODE 11800)

Abrasive grain	Silicon carbide	Bonding	Resin, antistatic
Backing	F-weight paper	Coating	closed
Grit range	180 - 1200	Delivery form	 Wide belts up to 64" width

PRODUCT BENEFITS


- Very hard silicon carbide abrasive grain
- Stable F-weight paper backing with a good edge stability
- Very fine surface pattern



BS 118

☆☆ Finish

BW 115 (CODE 11500)

Abrasive grain	Aluminum oxide	Bonding	Resin
Backing	F-weight paper	Coating	closed
Grit range	80 - 320	Delivery form	 Wide belts up to 64" width

PRODUCT BENEFITS


- Closed coating for long tool life
- Stable, tear-resistant F-weight paper backing allows sanding with high sanding pressure



BW 115

☆☆ Price Point

BW 110 (CODE 11000)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	E-weight paper	Coating	semi-open
Grit range	80 - 220	Delivery form	 Wide belts up to 62" width

PRODUCT BENEFITS

- Antistatic and semi-open structure reduces the risk of loading
- Good stock removal rate even at low sanding pressure
- Stable and flexible E-weight paper backing
- Good sanding pattern
- Economical sanding of all types of wood



BW 110



Paper Stroke Sanding

Hand Block, Hand Lever, Auto., & Auto Feed Through



CERAMIT® CR 116

☆☆☆ Premium

CERAMIT® CR 116 (CODE 11623)

Abrasive grain	Ceramic	Bonding	Resin, antistatic
Backing	F-weight paper	Coating	semi-open
Grit range	80 - 180	Delivery form	

PRODUCT BENEFITS


- High stock removal rates and very long tool life especially on hard wood
- Low sanding temperatures



CB 115

☆☆☆ Performance

CB 115 (CODE 11523)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	F-weight paper	Coating	semi-open
Grit range	80 - 240	Delivery form	

PRODUCT BENEFITS

- High stock removal rates for long belt life
- Consistent surface finishes for the life of the belt
- Improved dust control in the work area
- Open coat resists premature loading



BW 114

☆☆ Standard

BW 114 (CODE 11400)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	F-weight paper	Coating	open
Grit range	80 - 400	Delivery form	

PRODUCT BENEFITS

- Very high stock removal rates, especially on softwood.
- Open coating and antistatic structure reduces loading with sanding dust, especially with resinous materials
- Stable and tear-resistant F-weight paper backing allows sanding with high sanding pressure



BS 118

☆☆☆ Finish

BS 118 (CODE 11800)

Abrasive grain	Silicon carbide	Bonding	Resin, antistatic
Backing	F-weight paper	Coating	closed
Grit range	180 - 1200	Delivery form	

PRODUCT BENEFITS

- Very hard silicon carbide abrasive grain
- Stable F-weight paper backing with a good edge stability
- Very fine surface pattern

Cloth Stroke Sanding

Hand Block, Hand Lever, Auto., & Auto Feed Through
(For both flat & profile work)

☆☆☆ Premium

RB 316 36 Z OP (CODE 31636)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	Z-cloth	Coating	open
Grit range	80 - 180	Delivery form	

PRODUCT BENEFITS

- High stock removal rates for long belt life
- Consistent surface finishes for the life of the belt
- Improved dust control in the work area
- Open coat resists premature loading



RB 316 36 Z op

☆☆ Performance

RB 316 33 X OP (CODE 31633)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	X-cloth	Coating	open
Grit range	80 - 220	Delivery form	

PRODUCT BENEFITS


- High stock removal rates for long belt life
- Consistent surface finishes for the life of the belt
- Improved dust control in the work area
- Open coat resists premature loading



RB 316 33 X op

☆ Standard

RB 304 J-FLEX (CODE 30480)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	J-cloth	Coating	open
Grit range	80 - 150	Delivery form	

PRODUCT BENEFITS

- Highly flexible abrasive cloth with excellent conformability for profiles
- Open coating means less clogging
- Reduced heat generation
- Antistatic
- Improved stock removal



RB 304 J-flex



Edge Sanding


Side Stroke Sanders

☆☆☆ Premium



RB 316 36 Z op

RB 316 36 Z OP (CODE 31636)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	Z-cloth	Coating	open
Grit range	60 - 180	Delivery form	

PRODUCT BENEFITS


- High stock removal rates for long belt life
- Consistent surface finishes for the life of the belt
- Improved dust control in the work area
- Open coat resists premature loading

☆☆ Performance



RB 377 YX

RB 377 YX (CODE 37710)

Abrasive grain	Aluminum oxide	Bonding	Resin
Backing	YX-cloth	Coating	closed
Grit range	60 - 220	Delivery form	

PRODUCT BENEFITS


- Special aluminum oxide grain mix provides high stock removal rates in the coarse grit range
- Very constant surface quality in the fine grit range
- Polyester/cotton cloth backing ensures smooth running for belts and wide belts

☆ Standard



RB 316 33 X op

RB 316 33 X OP (CODE 31633)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	X-cloth	Coating	open
Grit range	60 - 220	Delivery form	

PRODUCT BENEFITS

- High stock removal rates for long belt life
- Consistent surface finishes for the life of the belt
- Improved dust control in the work area
- Open coat resists premature loading

Edge Sanding

Dead Head or Noseblock

★★★ Premium

RB 304 J-FLEX (CODE 30480)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	J-cloth	Coating	open
Grit range	80 - 150	Delivery form	

PRODUCT BENEFITS


- Highly flexible abrasive cloth with excellent conformability for profiles
- Open coating means less clogging
- Reduced heat generation
- Antistatic
- Improved stock removal



RB 304 J-flex

★★ Performance

RB 306 J-FLEX (CODE 30660)

Abrasive grain	Aluminum oxide	Bonding	Resin
Backing	J-cloth	Coating	closed
Grit range	60 - 180	Delivery form	

PRODUCT BENEFITS


- Highly flexible J-flex cotton cloth
- Highly adaptable to contours and radii
- Good stock removal rate
- Very good grit adhesion



RB 306 J-flex

★ Standard

RB 346 J-FLEX (CODE 34660)

Abrasive grain	Aluminum oxide	Bonding	Resin
Backing	J-cloth	Coating	closed
Grit range	60 - 180	Delivery form	

PRODUCT BENEFITS


- Excellent adaptability to contoured workpieces and radii
- Suitable for intricate profiles and small radii.
- The high strength bonding system prevents a premature abrasive grain shedding
- Improved abrasive life
- High stock removal rates



RB 346 J-flex

Alternate

RB 346 X-FLEX (CODE 34670)

Abrasive grain	Aluminum oxide	Bonding	Resin
Backing	X-cloth	Coating	closed
Grit range	60 - 180	Delivery form	

PRODUCT BENEFITS

- Excellent adaptability to contoured workpieces and radii
- Suitable for intricate profiles and small radii.
- The high strength bonding system prevents a premature abrasive grain shedding
- Improved abrasive life
- High stock removal rates



RB 346 X-flex



Mold Sanding

Shape Sanding

☆☆☆ Premium



RB 304 J-flex

RB 304 J-FLEX (CODE 30480)

Abrasive grain	Aluminum oxide	Bonding	Resin, antistatic
Backing	J-cloth	Coating	open
Grit range	80 - 180	Delivery form	

PRODUCT BENEFITS


- Highly flexible abrasive cloth with excellent conformability for profiles
- Open coating means less clogging
- Reduced heat generation
- Antistatic
- Improved stock removal

☆☆ Performance



RB 346 X-flex

RB 346 X-FLEX (CODE 34670)

Abrasive grain	Aluminum oxide	Bonding	Resin
Backing	X-cloth	Coating	closed
Grit range	60 - 180	Delivery form	

PRODUCT BENEFITS


- Excellent adaptability to contoured workpieces and radii
- Suitable for intricate profiles and small radii.
- The high strength bonding system prevents a premature abrasive grain shedding
- Improved abrasive life
- High stock removal rates

☆ Standard



RB 346 J-flex

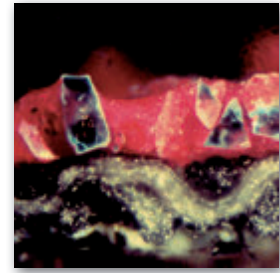
RB 346 J-FLEX (CODE 34660)

Abrasive grain	Aluminum oxide	Bonding	Resin
Backing	J-cloth	Coating	closed
Grit range	60 - 180	Delivery form	

PRODUCT BENEFITS

- Excellent adaptability to contoured workpieces and radii
- Suitable for intricate profiles and small radii.
- The high strength bonding system prevents a premature abrasive grain shedding
- Improved abrasive life
- High stock removal rates

Technical Information

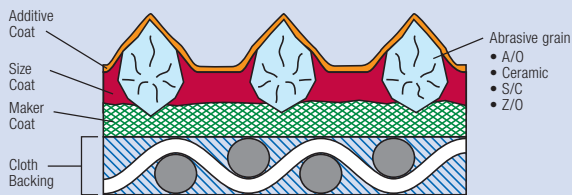


PRINCIPLE CONSTRUCTION OF COATED ABRASIVES

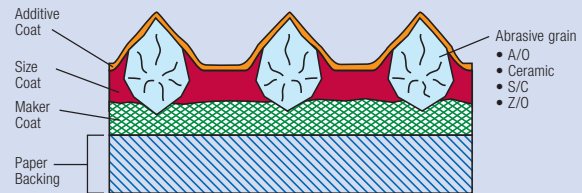
Basically, coated abrasives consist of abrasive grains anchored to a backing material by a coating of adhesive. These 3 components in their variations may be combined to create an unlimited number and range of different products.

The following information, charts and graphics will give you a better understanding of the construction of our products.

Single Layer – Cloth



Single Layer – Paper



ABRASIVE GRAINS AND GRAIN STANDARDS

Abrasive Grain

- A/O – Aluminum Oxide
- S/C – Silicon Carbide
- Z/O – Zirconia Alumina
- Ceramic
- Garnet

Grain Standards

- P = FEPA - DIN 69 176
- # = ANSI - B74.18-1984
- + = Hermes-Standard






GRIT SIZE COMPARISON (ABRASIVE PAPER, FILM, CLOTH, STITCH BONDED CLOTH AND FIBER)


$d_{k,50}$ (µm) average grain diameter	750	630	525	400	325	260	200	160	125	93	76	68	58	52	46	39	35	30	26	22	18	14	12	10	8
FEPA 43-D-1984 R 1993 DIN ISO 6344	P 24	P 30	P 36	P 40	P 50	P 60	P 80	P 100	P 120	P 150	P 180	P 220	P 240	P 280	P 320	P 360	P 400	P 500	P 600	P 800	P 1000	P 1200	P 1500	P 2000	P 2500
ANSI B 74.18-1996	24	30	36	40	50	60	80	100	120	150	180	220		240	280	320	360	400	500	600					






The differences of the respective grit size standards are defined in the relevant test standards.



All at a glance – Hermes high-performance abrasives

	Paper-backed wide belts				
Type / Application					
	BW 110	BW 114	BW 115	CB 115	CERAMIT® CR 116
Grain	Aluminum oxide	Aluminum oxide	Aluminum oxide	Aluminum oxide	Ceramic
Bonding	Resin, antistatic	Resin, antistatic	Resin	Resin, antistatic	Resin, antistatic
Backing	E-weight paper	F-weight paper	F-weight paper	F-weight paper	F-weight paper
Coating	semi-open	open	closed	open	closed
Grit Range	24, 36 - 220, 400	40 - 800	40 - 320, 400	80 - 220	60 - 180, 240

	Paper-backed narrow belts			Cloth-backed narrow belts	
Type / Application					
	BW 114	CB 115	BS 118	RB 316 33 X op	RB 316 36 Z op
Grain	Aluminum oxide	Aluminum oxide	Silicon carbide	Aluminum oxide	Aluminum oxide
Bonding	Resin, antistatic	Resin, antistatic	Resin, antistatic	Resin, antistatic	Resin, antistatic
Backing	F-weight paper	F-weight paper	F-weight paper	X-weight cloth	Z-weight cloth
Coating	open	open	closed	open	open
Grit Range	40 - 800	80 - 220	16, 24, 36 - 1200	36, 50 - 220	60 - 180



	Paper-backed discs			Cloth-backed discs	Film-backed discs
Type / Application					
	VC 151-Longlife VEL	VC 152 SK	VC 154-Longlife VEL	RB 306 J-flex VEL	Brilliance Film FC 164-Longlife VEL
Grain	Aluminum oxide	Aluminum oxide	Aluminum oxide	Aluminum oxide	Aluminum oxide
Bonding	Resin, Prolub	Resin, Prolub	Resin, Prolub	Resin	Resin with additives
Backing	C-weight paper	D-/C-weight paper	Flexible B-weight paper	J-flex weight cloth	Film
Coating	open	open	closed	closed	semi-open
Grit Range	60 -240, 320 - 500	40, 60 - 240	80 -1500	120	600 - 2000


	Accessories				
Type / Application					
	Back up pad - SK Hermes code: 90222	Back up pad - VEL Hermes code: 90282	Back up pad - VEL Hermes code: 90292	Hand pad - VEL Hermes code: 90339	Hand block - VEL Hermes code: 90349
Backing	Fiberglass plate	Fiberglass plate	Fiberglass plate	1/8" foam	n/a
Profile	regular	thin	thin	thin	wedge shaped
Format	no holes	no holes	Multihole	no holes	n/a
Density	medium	hard	hard	flexible	hard
Thread	5/16" x 24	5/16" x 24	5/16" x 24	n/a	n/a

es for woodworking

Cloth-backed wide belts					
					
BS 118	RB 316 33 X op	RB 316 36 Z op	RB 377 YX	RB 484 44 Z	
Silicon carbide	Aluminum oxide	Aluminum oxide	Aluminum oxide	Zirconia alumina	
Resin, antistatic	Resin, antistatic	Resin, antistatic	Resin	Resin	
F-weight paper	X-weight cloth	Z-weight cloth	Cotton/Polyester blend	Z-weight cloth	
closed	open	open	closed	closed	
16, 24, 36 - 1200	36, 50 - 220	60 - 180	36, 40, 60 - 320, 400, 500	24, 36 - 120	

Cloth-backed narrow belts			
			
RB 304 J-flex	RB 346 J-flex	RB 346 X-flex	
Aluminum oxide	Aluminum oxide	Aluminum oxide	
Resin, antistatic	Resin	Resin	
J-flex weight cloth	J-flex weight cloth	X-flex weight cloth	
closed	open	closed	
80 - 150	40 - 400, 600	60 - 320, 400	

Paper-backed sheets		webrax-sheets	Sanding sponges		
					
VC 152	SF 168	webrax-OA 708 (6" x 9")	Single sided (4 1/2" x 5 1/2" x 3/16")	Double sided (3 7/8" x 4 7/8" x 1/2")	Four sided (2 3/4" x 4" x 1")
Aluminum oxide	Aluminum oxide	Aluminum oxide	Aluminum oxide	Silicon carbide	Aluminum oxide
Resin, Prolub	Resin, Prolub	Resin	Resin	Resin	Resin
D-/C-weight paper	B-weight paper	Non-woven abrasive web	open structured foam	flexible foam	hard foam
open	open	open	closed	closed	closed
40, 60 - 320, 400	80 - 320, 400, 500	120, 180, 280, 360	60, 100, 150, 180, 220, 280, 400, 600	60, 100, 180, 220	60, 100, 150, 180, 220

	
Hand block - VEL	
Hermes code: 90349	
n/a	
rectangle	
n/a	
hard	
n/a	



Disc Sanding

Wood in white and Sealer

☆☆☆ Premium



VC 152

VC 152 SK (CODE 15205)

Abrasive grain	Aluminum oxide	Bonding	Resin
Backing	D-/C-weight paper, self-stick	Coating	open
Grit range	40, 60 - 240		

PRODUCT BENEFITS

- Sharp Aluminum oxide grain and open coating mean high stock removal rates
- Low loading characteristics
- Materials have very good surface quality
- Flexible paper backing
- Good price/performance ratio

☆☆☆ Velcro

VC 151-LONGLIFE VEL / MULTIHOLE (CODES 15177/15179)

Abrasive grain	Aluminum oxide	Bonding	Resin, coated with additives
Backing	C-weight paper, velour-backed	Coating	open
Grit range	60 - 240, 320 - 500		

PRODUCT BENEFITS

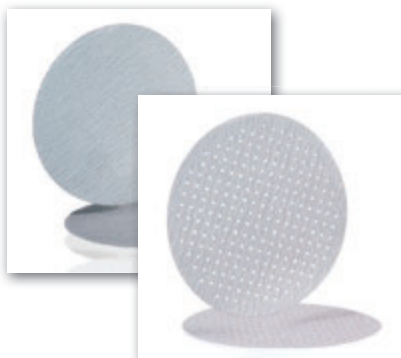
- Low clogging with sanding dust due to semi-open coating and additional coating with additives
- Flexible, strong paper guarantees very good adaptability when grinding contours and curved surfaces

VC 154-LONGLIFE VEL / MULTIHOLE (CODES 15477/15479)

Abrasive grain	Aluminum oxide	Bonding	Resin, coated with additives
Backing	B-weight paper, velour-backed	Coating	semi-open
Grit range	80 - 1500		

PRODUCT BENEFITS

- Flexible, wear-resistant Latex paper backing assures very good adaptations to contours
- Low clogging with sanding dust due to semi-open coating and additional coating with additives
- Consistent stock removal rates and consistent roughness values during the whole sanding process



VC 151-Longlife VEL / MULTIHOLE



VC 154-Longlife VEL / MULTIHOLE

☆☆☆ Premium Film (Velcro)

BRILLIANCE FILM FC 164-LONGLIFE VEL (CODE 16477)

Abrasive grain	Aluminum oxide	Bonding	Resin, coated with additives
Backing	Abrasive film, velour-backed	Coating	semi-open
Grit range	240 - 2000		

PRODUCT BENEFITS

- The new film backing combines the advantages of cloth (high edge stability & tear resistance) and paper (high flexibility and low weight). And it allows a uniform grain orientation, which leads to perfect surfaces
- The semi-open coating and the optimized longlife coating prevent premature clogging and thus guarantee a long life.
- In addition, semi-open coating provides constant removal rates
- High flatness ensures good running properties and safe automated wheel replacement on robot grinding systems
- For quick identification, the grit size can be read on the grain side



Brilliance Film FC 164-Longlife, velour-backed

☆☆ Cloth

RB 306 J-FLEX SK / VEL (CODES 30665/30667)

Abrasive grain	Aluminum oxide	Bonding	Resin
Backing	J-flex cloth	Coating	closed
Grit range	Self-stick: 120 - 220 / velour-backed: 120, 180		

PRODUCT BENEFITS

- Highly flexible J-flex cotton cloth
- Highly adaptable to contours and radii
- Good stock removal rate
- Very good grit adhesion



RB 306 J-flex

☆☆ Finish

SF 168 SK (CODE 16815)

Abrasive grain	Silicon carbide	Bonding	Resin, coated with additives
Backing	B-weight paper, self-stick	Coating	open
Grit range	60 - 320, 400		

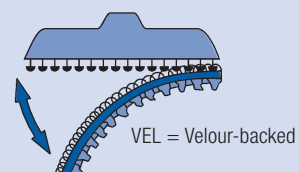
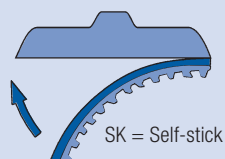
PRODUCT BENEFITS

- Highly flexible adaptable paper
- Longlife coating means increased tool life
- Good sanding result on transparent lacquer systems
- Especially good results on lacquer intermediate sanding
- Open coating prevents premature loading with sanding dust



SF 168, self-stick

CLOTH AND PAPER DISC BACKING ATTACHMENT SYSTEMS





Hand Sanding

Wood in white and Sealer



SF 168

★ Light Paper

SF 168 (CODE 16810)

Abrasive grain	Silicon carbide	Bonding	Resin, coated with additives
Backing	B-weight paper	Coating	open
Grit range	80, 120 - 320, 400, 500		

PRODUCT BENEFITS

- Highly flexible adaptable paper
- Longlife coating means increased tool life
- Good sanding result on transparent lacquer systems
- Especially good results on lacquer intermediate sanding
- Open coating prevents premature loading with sanding dust



VC 152

★ Heavy Paper

VC 152 (CODE 15200)

Abrasive grain	Aluminum oxide	Bonding	Resin
Backing	D-/C-weight paper	Coating	open
Grit range	40, 60 - 320, 400		

PRODUCT BENEFITS

- Sharp Aluminum oxide grain and open coating mean high stock removal rates
- Low loading characteristics
- Materials have very good surface quality
- Flexible paper backing
- Good price/performance ratio



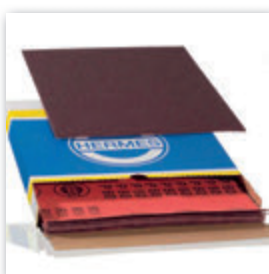
VC 151-Longlife VEL

VC 151-LONGLIFE VEL (CODE 15177)

Abrasive grain	Aluminum oxide	Bonding	Resin, coated with additives
Backing	C-weight paper, velour-backed	Coating	open
Grit range	80 - 240, 320 - 500	Size	2 5/8" x 5 3/8" for VEL (hand block)

PRODUCT BENEFITS

- Low clogging with sanding dust due to semi-open coating and additional coating with additives
- Flexible, strong paper guarantees very good adaptability when grinding contours and curved surfaces



RB 346 J-flex

★ Cloth

RB 346 J-FLEX (CODE 34660)

Abrasive grain	Aluminum oxide	Bonding	Resin
Backing	J-cloth	Coating	closed
Grit range	40 - 400, 600		

PRODUCT BENEFITS

- Excellent adaptability to contoured workpieces and intricate profiles and small radii
- The high strength bonding system prevents a premature abrasive grain shedding
- Improved abrasive life
- High stock removal rates

Sponges

Wood in white and Sealer

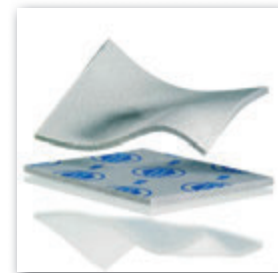
★ Single-Sided

MEDIUM, SINGLE-SIDED (CODE 90358)

Abrasive grain	Aluminum oxide	Grit range	60, 100, 150 - 220,
Backing	PU foam light grey, dense and semi-flexible		280, 400, 600

PRODUCT BENEFITS

- Fine sanding of wood in preparation for staining and lacquering
- Can be used wet or dry
- For flat and slightly shaped workpieces



Medium, single-sided

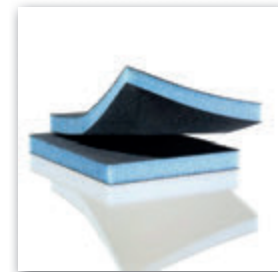
★ Double-Sided

PREMIUM, DOUBLE-SIDED (CODE 90550)

Abrasive grain	Silicon carbide	Grit range	60, 100, 180, 220
Backing	PU foam blue, flexible		

PRODUCT BENEFITS

- Fine sanding of wood in preparation for staining and lacquering
- Intermediate sanding of primers and lacquers
- Can be used wet or dry
- For highly profiled and contoured workpieces



Premium, double-sided

★ Block

SANDING SPONGE, FOUR-SIDED (CODE 90351)

Abrasive grain	Aluminum oxide	Grit range	36, 60, 100, 180, 220
Backing	PU foam grey, dense and hard		

PRODUCT BENEFITS

- Fine sanding of wood in preparation for staining and lacquering
- Can be used wet or dry
- For slightly shaped workpieces and mitres



Sanding sponge, four-sided



Accessories

★ Backup pads



SK-Backup pad

SK-BACKUP PAD (CODE 90222)

Dimension **5"**
 Description **Without holes, tapered edge, medium density**

PRODUCT BENEFITS

- Formed out of polyurethane
- High edge stability
- For self-stick discs, punched and without holes



VEL-Backup pad

VEL-BACKUP PAD (CODE 90282)

Dimension **5"**
 Description **Without holes, tapered edge, thin, hard density**

PRODUCT BENEFITS

- Formed out of polyurethane
- High edge stability
- For velour-backed discs, punched and without holes



VEL-Backing pad MULTIHOLE, hard

VEL-BACKUP PAD MULTIHOLE (CODE 90292)

Dimension **5" and 6"**
 Description **MULTIHOLE, tapered edge, thin, hard density**

PRODUCT BENEFITS

- Formed out of polyurethane
- High edge stability
- The use of MULTIHOLE discs (5" and 6") assures an ideal dust extraction



Graphite roll GL 580

GRAPHITE ROLLS FOR MACHINES WITH CONTACT BARS

Types **GL 580 / 581**
 Dimension **-**

PRODUCT BENEFITS

- GL 580 – Granular construction for paper and cloth belt applications
- GL 581 – Flake construction for cloth belt applications

★ Hand Pads / Blocks

VEL-HAND HELD BACKUP PAD (CODE 90339)

Dimension **5" without holes, 1/8" thin**
Description **firm foam**

PRODUCT BENEFITS

- Flexible handpad, 1/8" thin
- With loop for manual sanding using velour-backed discs



VEL-Hand held backing pad with loop

VEL-HAND BLOCK "ERGONOMIC PALM SANDER" (CODE 90349)

Dimension **5" x 3"**
Description **Wedge Shape**

PRODUCT BENEFITS

- Made of polyurethane
- 5" velour-backed discs suitable for random orbital sanders can be used



VEL-Hand block "Ergonomic palm sander"

VEL-HAND BLOCK (CODE 90349)

Dimension **2 5/8" x 5 3/8"**
Description **Rectangle**

PRODUCT BENEFITS

- For ideal sanding with Hermes velour-backed sheets



VEL-Hand block

VEL-HAND BLOCK SADDLEHORN (CODE 90348)

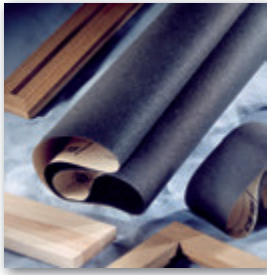
Dimension **5"**
Description **Round**

PRODUCT BENEFITS

- Made of polyurethane
- 5" velour-backed discs suitable for random orbital sanders can be used



VEL-Hand block Saddlehorn



Application Notes

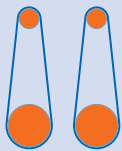
Wide Belt Troubleshooting Guide, Sanding Tips,
Wide Belt Set-Ups and Cut Guidelines

WIDE BELT TROUBLESHOOTING GUIDE			
PROBLEM		PROBABLE CAUSES	
Problems with Work Piece Quality		Problems with Belt Life	
Chatter		Belt Tracking Off	
		<ol style="list-style-type: none"> 1. Contact element & idler not parallel 2. Low belt tension 3. Tracking mechanism not adjusted properly 4. Damaged edge or cone shaped belt 5. Sanding pressure too high 	
Poor Tolerance		Belt Breaking	
		<ol style="list-style-type: none"> 1. Belt creased or damaged in handling 2. Uneven sanding pressure 3. Incorrect joint or belt mounted in wrong direction 4. Belt tension too low 5. Dumbbell shaped drum or idler roll 	
Streaking	Follows belt tracking	Belt Creasing	
	Straight line marks	Poor Belt Life	
Deep Scratches			
		<ol style="list-style-type: none"> 1. Improper product, grit, or joint for application 2. Improper storage conditions for belts 3. Dust collection restricted or inadequate 	
Edges Rounded Over			
		<ol style="list-style-type: none"> 1. Drum and/or platen too high or low 2. Infeed or outfeed rolls/shoes too high 	

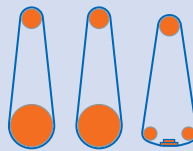
SANDING TIPS	
<ol style="list-style-type: none"> 1. Hang belts prior to use and store them off the floor 2. Use coarsest grit size to do the job properly 3. Follow stock removal guidelines set up by the manufacturer 4. Load workpieces evenly across feed belt 5. Finish head should only remove pencil mark 6. Check platens and recover regularly 	<ol style="list-style-type: none"> 7. Use low angle inspection lights at the outfeed 8. Check dust hoods regularly to ensure open air flow 9. Load overlap jointed belts in correct direction 10. Use paper vs. cloth belts whenever possible 11. Tape jointed belts may be reversed to extend life

TYPICAL WIDE BELT SET-UPS

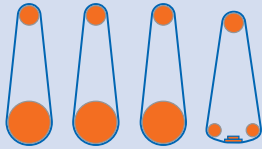
APPROXIMATE STOCK REMOVAL CAPABILITIES AT 25 FPM **THREE EXAMPLES FOR EACH MACHINE TYPE



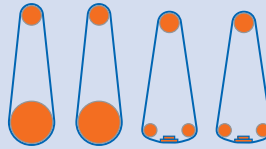
#1 80g (.025") 120g (.011")
 #2 100g (.017") 150g (.007")
 #3 120g (.011") 180g (.005")



#1 80g (.025") 120g (.011") 180g (.005")
 #2 100g (.017") 150g (.007") 180g (.005")
 #3 120g (.011") 180g (.005") 220g (.003")



#1 100g (.017") 120g (.011") 150g (.007") 180g (.005")
 #2 100g (.017") 150g (.007") 180g (.005") 220g (.003")
 #3 120g (.011") 150g (.007") 180g (.005") 220g (.003")



#1 100g (.017") 120g (.011") 180g (.005") 220g (.003")
 #2 120g (.011") 150g (.007") 180g (.005") 220g (.003")
 #3 100g (.017") 150g (.007") 180g (.005") 220g (.003")

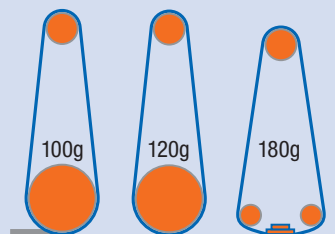
STOCK REMOVAL AND DEPTH OF CUT GUIDELINES FOR WIDE BELT MACHINES (APPROXIMATE)

AVERAGE ABRASIVE BELT STOCK REMOVAL AT NORMAL FURNITURE / CABINET OPERATING SPEEDS

AVERAGE DEPTH OF SCRATCH LEFT BY A PARTICULAR GRIT ABRASIVE BELT

Grit	Depth of Cut	Grit	Depth of Scratch
60	.035" - .040"	36	.028" - .030"
80	.020" - .030"	60	.025" - .022"
100	.015" - .020"	80	.015" - .018"
120	.010" - .013"	100	.010" - .012"
150	.006" - .009"	120	.008" - .010"
180	.004" - .006"	150	.005" - .006"
220	.002" - .004"	180	.004" - .005"
		220	.003" - .004"

Example



Stock Removal	.018"	.010"	.003"
Depth of Scratch	.011"	.009"	.003"



Application Notes

Orbital Sanding Guidelines and Storage Recommendations

ORBITAL SANDING GUIDELINES

USING THE FOLLOWING GUIDELINES WILL ASSURE YOU GET THE MOST OUT OF YOUR RANDOM ORBITAL SANDER

Equipment Operation

1. Set the sander FLAT on the workpiece prior to starting the sander.
2. Remove the sander from the workpiece prior to releasing the sanding lever.
3. Let the abrasive do the work. You do not need to work the abrasive.
4. The typical sander weighs around 2-3 pounds. This is the exact weight that should be applied to the workpiece. Putting excessive pressure on the tool will cause the sander to stall, resulting in swirl marks.
5. Avoid tilting the sander on edge. This practice will result in dipping of the sanded surface and deeper swirl marks than normal.
6. Make sure that the back up pad is in good condition. Missing chunks, as well as buildup on the pad's surface will "telegraph" through to the part being sanded, resulting in swirl marks.
7. Several passes over the area to be sanded are more effective than trying to push the sander hard with one pass. The best sanding pattern is long sweeping strokes with just the weight of the machine.
8. The sanding pattern of a random orbital sander is non-directional. It is not necessary to follow the grain of the wood.
9. Once a small area has been sanded, it is best to blend in the repair by lightly sanding the whole piece for a smooth consistent finish.

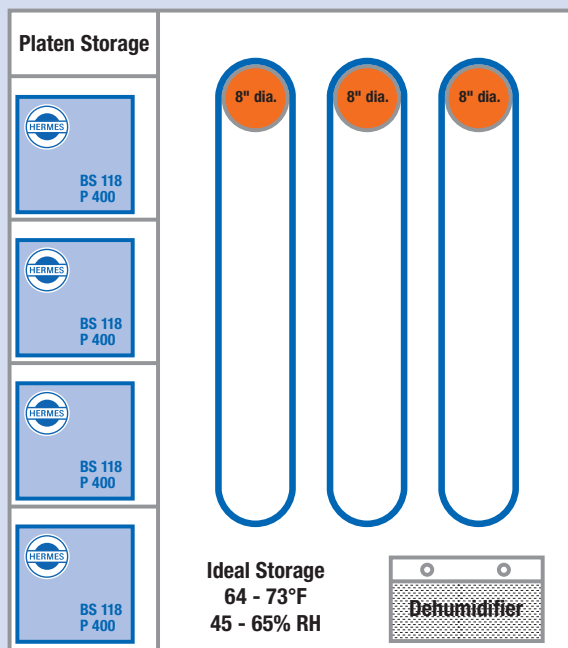
Air Supply Recommendations for Orbital Sanders

1. When random orbital sanders are operated at air pressures below the manufacturer's recommendations, they are far more likely to produce swirl marks on the work piece.
2. The air supply at the sander can be checked while the tool is running by utilizing a "T" fitting with an air pressure gauge attached. The "T" fitting should be the same I.D. as the connector on the tool.
3. The coupling from the tool to the hose should be the same I.D. as the pipe fitting recommended for that tool (i.e. Orbital sanders normally accept a 1/4" NPTF fitting). The I.D. of that fitting **SHOULD NOT** be reduced from 1/4" by a 3/16" quick change coupler. Quick-change couplers in 1/4" are also available.
4. Most air tool manufacturers recommend the use of the next larger size I.D. hose from the tool to the pipe. A 5/16" hose is needed for a sander with a 1/4" I.D. coupling.
5. The length of hose between the tool and the air pipe should be as short as possible (under 20 feet) as rubber hoses restrict airflow. If longer hoses are necessary, the next larger I.D. should be utilized.
6. Any type of air control equipment attached to the iron supply pipe, (ex: oilers, gauges), should have an I.D. at least as large as the hose I.D. Even one restriction in the air supply system will reduce the air supply below the minimum requirement.
7. Proper lubrication is required. If in-line oilers are not utilized, a daily application of the proper oil should be applied to the tool.
8. Random orbital sanders run most efficiently at approximately 90 PSI at the tool while running under load.

STORAGE OF WIDE BELTS AND OF COATED ABRASIVES IN GENERAL

Careful storage ensures maximum benefits – Hermes abrasives are high quality tools and as such require corresponding storage considerations. Improper storage and handling may have adverse effects on performance. Particular care must be taken in the storage of paper-backed products as they are more susceptible to surrounding climatic conditions than cloth-backed.

Recommended Wide Belt Storage to Control Humidity level and protect paper belts



Specifications

- 1" square steel tubing used for the frame
- 1/2" plywood or similar for exterior sheathing
- Doors open on the front for full access
- Dehumidifier placed in the box and plumbed outside
- Belts hung on 8" diameter PVC or similar
- Number of belt racks depend upon the qty. of grits used
- Should have one extra rack to hang used belts when not in use

General Storage Recommendations of Coated Abrasives



- Room temperature 64 - 73°F
- Relative humidity 45 - 65%
- If possible in original packaging on shelves, pallets or stands.
- Products should be used in the order they are received



- Near sources of heat such as heaters or radiators
- Extreme variations in temperature (cold/hot)
- Store directly on concrete or stone floors
- Store in unheated rooms in winter



Hermes Abrasives Institute – for your efficient sanding process



The H.A.I optimization programs offer you individual services and consulting, as well as training courses which will make you more competitive and successful.

You will find that our H.A.I consultants are knowledgeable partners who will support you with their many years' experience in process optimization and in managing and designing staff training courses.



The optimization programs are divided into the following three areas aimed at users, industrial customers and dealers who like to optimize their profitability, consolidate their expertise or avoid quality problems:

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Process optimization and Lean consulting are the key components which can improve your abrasive processes in terms of productivity, profitability and quality.

Our experienced consultants at H.A.I Consulting combine holistic analysis with modern measuring and analysis techniques on your own premises, using knowledge transfer which delivers not only reliable data and measured results, but also genuine competitive advantages.

At the Hermes Abrasives Institute, an extensive range of sanding machines allows us to imitate a wide variety of customer applications, simulating and analyzing applications in the process.

H.A.I Training – Turning theory into outstanding practice.

We want to do more than just communicate knowledge, we want to provide concrete demonstrations and training for your team enabling them to implement theoretical and practical know-how correctly – catered to your requirements.

Our training courses:

- Basic training about coated abrasives and how to use it correctly
- Training course content about Lean principles in the form of a simulation of corporate decisions and processes (“Baking Factory”)

H.A.I Manual – The manual for your abrasive processes.

As specialists in complex processes, we collaborate with you to produce manuals for your abrasive processes which contain process-specific and general information about “Sanding” independently of the products you use.

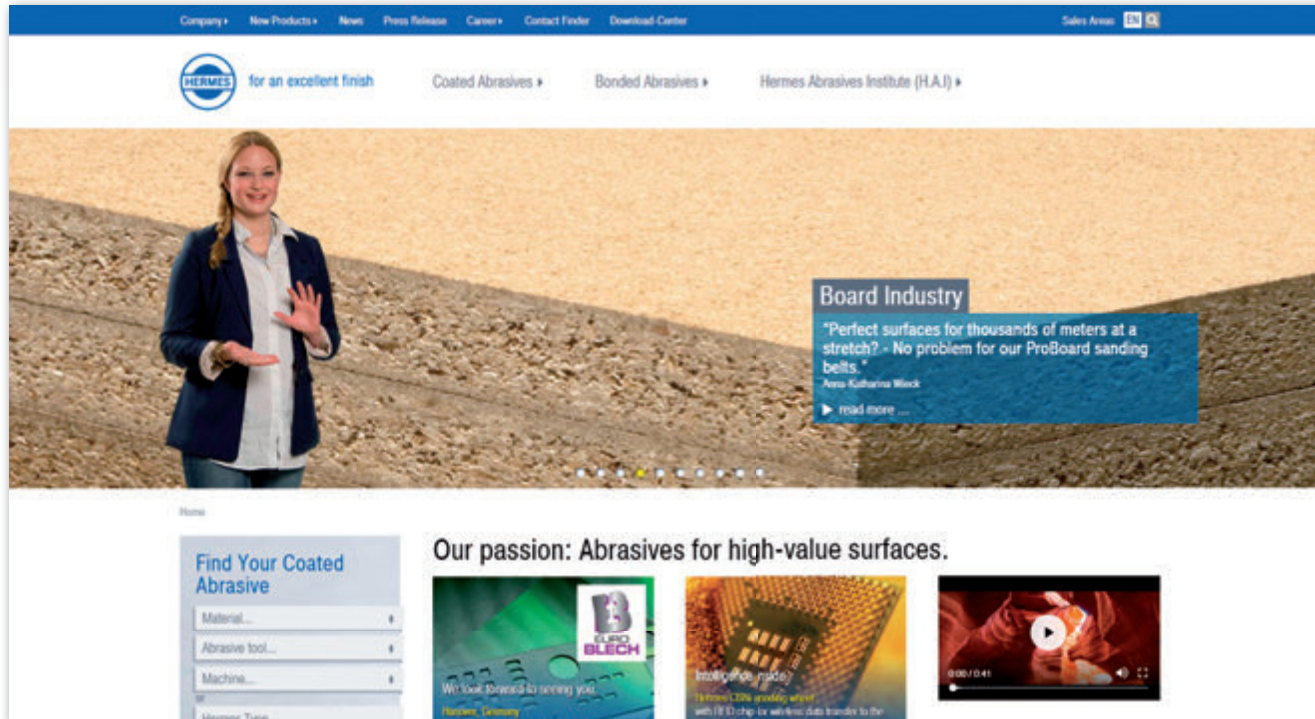
WE WOULD BE DELIGHTED TO ADVISE YOU.

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