

BEAR-TEX SURFACE FINISHING PRODUCTS



Bear-Text Surface Finishing products are made of a non-woven nylon web impregnated with abrasive grain and resin. A variety of abrasives, grit sizes and backing materials give the user an extensive and superior product offering.

TYPICAL APPLICATIONS

- Light to heavy duty cleaning
- Deburring
- Blending
- Polishing
- Finishing



BEAR-TEX HAND PADS, SHEETS AND ROLLS

Bear-Text Hand Pads, Sheets and Rolls

FEATURES

- Flexible
- Gentle action
- Non-loading
- Non-rusting
- Resilient construction
- Easily cut to desired size

BENEFITS

- Conform to work surface
- Easily removes flashing or burrs without affecting dimension of workpiece
- Constant supply of new cutting edges
- No workpiece contamination
- Long life, increased productivity
- Solvent resistant
- Waterproof
- Reduces waste

BEAR-TEX SURFACE FINISHING PRODUCTS

M102

TechTips



■ Bear-Text products are non-metallic, won't rust and are an ideal replacement for steel wool.



It is the user's responsibility to refer to and comply with ANSI B7.1

BEAR-TEX SURFACE FINISHING PRODUCTS



BEAR-TEX HAND PADS

SIZE W X L	COLOR	NAME	ABRASIVE	GRIT SIZE	STD. PKG.	GOOD	
						PRODUCT NO.	UPC NO.
6 X 9	WHITE	LIGHT DUTY CLEANING PAD	NON-ABRASIVE		60	456	66261045600
6 X 9	GRAY	CLEAN & FINISH PAD	SILICON CARBIDE	ULTRA FINE	60	635	66261063500
6 X 9	DARK TAN	HEAVY DUTY PAD	ALUMINUM OXIDE	MEDIUM	40	740	66261074000
6 X 9	GRAY	METAL BLEND PAD	SILICON CARBIDE	MEDIUM	40	746	66261074600
6 X 9	MAROON	GENERAL PURPOSE PAD	ALUMINUM OXIDE	VERY FINE	60	747	66261074700
6 X 9	GRAY	FINAL SHINE PAD	SILICON CARBIDE	MICRO FINE	60	748	66261074800
6 X 9	MAROON	LONG LIFE PAD	ALUMINUM OXIDE	VERY FINE	60	777	66261077700
6 X 9	GREEN	SCOURING PAD	ALUMINUM OXIDE	VERY FINE	60	796	66261079600
6 X 9	GRAY	GENERAL PURPOSE PAD	SILICON CARBIDE	VERY FINE	40	851	66261085100
3-1/4 X 5-1/2					10		HAND PAD HOLDER 66261047583

SpecCheck

STARTING RECOMMENDATIONS

MORE AGGRESSIVE, ROUGHER FINISH				LESS AGGRESSIVE, FINER FINISH				
#740 (DARK TAN) HEAVY DUTY PAD	#746 (GRAY) METAL BLEND PAD	#777 (MAROON) LONG LIFE PAD	#747 (MAROON) GENERAL PURPOSE PAD	#796 (GREEN) SCOURING PAD	#851 (GRAY) GENERAL PURPOSE PAD	#635 (GRAY) CLEAN & FINISH PAD	#748 (GRAY) FINAL SHINE PAD	#456 (WHITE) LIGHT DUTY CLEANING PAD
<ul style="list-style-type: none"> Removing rust and oxidation Deburring Blending Replaces steel wool and wire brushes in many applications 	<ul style="list-style-type: none"> Cleaning - aluminum - around welds - glass molds - dies Light deburring of intricate parts 	<ul style="list-style-type: none"> Fast initial cut rate Cleaning Deburring Corrosion removal Oxidation removal 	<ul style="list-style-type: none"> Cleaning Finishing Deburring machinery & tools Rust removal Defuzzing wood Preparing surfaces for painting 	<ul style="list-style-type: none"> Removing - stains - marks - rust - corrosion - oxidation 	<ul style="list-style-type: none"> Removing rust and oxidation Blending around welds Cleaning glass molds Satin finishing aluminum parts 	<ul style="list-style-type: none"> Deburring plastic surfaces Cleaning fiberglass partitions Blending paint Scuffing acrylic surfaces Finishing aluminum doors and windows 	<ul style="list-style-type: none"> Light cleaning - steel - non-steel Defuzzing wood Final rub 	<ul style="list-style-type: none"> Non-abrasive Cleaning glass, fiberglass and porcelain fixtures Wood highlighting and rubbing between finish coats Use with liquid detergents Scratch-free cleaning of stainless steel, chrome, copper and ceramic

BEAR-TEX SPONGE PADS

Bear-Text material is laminated to a top quality, long-lasting sponge for the convenience of 2 pads in one.

SIZE W X L X T	COLOR	NAME	ABRASIVE	GRIT SIZE	STD. PKG.	GOOD	
						PRODUCT NO.	UPC NO.
3-1/4 X 6-1/4 X 3/4	GREEN/YELLOW	SCOUR-N-SPONGE PAD	ALUMINUM OXIDE	VERY FINE	40	893	66261059403
3-1/4 X 6-1/4 X 3/4	WHITE/YELLOW	CLEAN-N-SPONGE PAD	NON-ABRASIVE	NON-ABRASIVE	40	875	66261059402

BEAR-TEX SHEET

SIZE W X L	COLOR	ABRASIVE	GRIT SIZE	STD. PKG.	BETTER	
					UPC NO.	
6 X 9	DARK GREEN	ALUMINUM OXIDE	VERY FINE / COARSE TEXTURED	100		66261054032

BEAR-TEX SURFACE FINISHING PRODUCTS



HAND SANDING



JITTERBUG SANDER

BEAR-TEX ROLLS

Rolls may be cut for use in jitterbug sanding or on hand sanding applications.



BEST Bear-Tex High Strength Rolls – For light deburring and finishing

FEATURES

- Premium aluminum oxide grain
- Firm, durable web; strong resin binders
- Smear-proof

BENEFITS

- Clean cutting and long lasting
- High resistance to tearing on burrs and sharp edges
- Produces light satin finishes

BETTER Bear-Tex Fast Cut Rolls – Fast initial cut, flexible

FEATURES

- Premium aluminum oxide grain
- Fast initial cut
- Conformable

BENEFITS

- Clean cutting and long lasting
- Less pressure needed
- Able to get into intricate shapes and follow contours, user-friendly

BETTER Bear-Tex Clean & Blend Rolls – For general purpose use

FEATURES

- High quality aluminum oxide or silicon carbide grain
- Uniform web construction
- Can be cut to exact sizes needed

BENEFITS

- Long product life
- Controlled aggressiveness
- Economical; minimal waste

M104

SIZE (W X L)	COLOR	NAME	ABRASIVE	GRIT	STD. PKG.	BEST	BETTER
						UPC NO.	UPC NO.
4" X 30 FT.	MAROON	HIGH STRENGTH	A/O	MEDIUM	3	66261006358	66261010081 66261058364 66261058361 66261002023 66261051701
	TAN	FAST CUT	A/O	MEDIUM	3		
	MAROON	CLEAN & BLEND	A/O	FINE	4		
	MAROON	CLEAN & BLEND	A/O	VERY FINE	4		
	GREEN	FAST CUT / GREEN	A/O	VERY FINE	5		
	MAROON	FAST CUT / MAROON	A/O	VERY FINE	4		
	MAROON	HIGH STRENGTH	A/O	VERY FINE	4	66261006373	
	MAROON	CLEAN & BLEND	S/C	VERY FINE	4		
	GRAY	CLEAN & BLEND	S/C	ULTRA FINE	5		
	GRAY	CLEAN & BLEND	S/C	MICRO FINE	5		
WHITE	T- POLISHING	NONE	NON-ABRASIVE	3			
6" X 30 FT.	MAROON	HIGH STRENGTH	A/O	MEDIUM	2	66261005182	66261058376 66261004281 66261058377
	MAROON	CLEAN & BLEND	A/O	VERY FINE	3		
	MAROON	HIGH STRENGTH	A/O	VERY FINE	2		
	GRAY	CLEAN & BLEND	S/C	VERY FINE	3		

BEAR-TEX SURFACE FINISHING PRODUCTS

BEAR-TEX ROLL ASSORTMENT

Bear-TEX rolls may be cut for use in jitterbug sanding or on hand sanding applications. The convenient dispenser box contains three 2 inch wide x 15 foot long rolls. Each roll is a different grit.



SIZE W X L	ABRASIVE	GRIT	STD. PKG.	BETTER UPC NO.
THREE ROLLS 2" X 15 FT. (ONE OF EACH SPECIFICATION)	ALUMINUM OXIDE ALUMINUM OXIDE SILICON CARBIDE	FINE VERY FINE ULTRA FINE	1	66261008108

BEAR-TEX DISCS

Made of non-woven nylon web impregnated with abrasive grain and resin for use in a variety of deburring and finishing applications. Primarily used on edge.

TYPICAL APPLICATIONS

- Rust/oxide removal
- Coating removal
- Pipe ID and OD polishing
- Casting cleaning
- Highlighting (antiquing)
- Contaminant removal
- Removal of handling marks
- Gasket removal
- Cleaning and blending of surface imperfections
- Prepping prior to soldering
- Removal of filling materials
- Cleaning angles and odd shapes



BEAR-TEX SURFACE FINISHING PRODUCTS

BEST

Bear-TEX High Strength Discs – For light deburring and finishing

FEATURES

- Premium aluminum oxide grain
- Firm, durable web
- Tough, yet conformable
- Strong resin binders
- Smear-proof

BENEFITS

- Clean cutting and long lasting
- High resistance to tearing on burrs and sharp edges
- Can be “ganged” together and used as a wheel
- Highly smear-resistant
- Produces light satin finishes

SIZE D X H	ABRASIVE	MAX. RPM	STD. PKG.	BEST UPC NO.
6 X 1/4	A/O VERY FINE HIGH STRENGTH	4,000	70	66261007628
6 X 1/2	A/O MEDIUM HIGH STRENGTH A/O VERY FINE HIGH STRENGTH	4,000	70	66261005073 66261004980
8 X 1/4	A/O VERY FINE HIGH STRENGTH	3,000	50	66261008454
8 X 1/2	A/O MEDIUM HIGH STRENGTH A/O VERY FINE HIGH STRENGTH	3,000	50	66261005491 66261004506

See “Mandrel Assemblies” on page M107 when using these discs on edge.

M105

BEAR-TEX SURFACE FINISHING PRODUCTS

BEAR-TEX DISCS (CONTINUED)

BETTER Bear-Tex Fast Cut Discs – Fast initial cut

FEATURES

- Premium aluminum oxide grain
- Firm, durable and resist tearing
- Conformable
- Highly smear-resistant
- Faster cutting and more flexible than high strength discs

BENEFITS

- Fast initial cut
- Clean cutting and long lasting
- Long life, high productivity, user-friendly
- Able to get into intricate shapes and follow contours, user-friendly
- Leave no residue
- Less part dwell-time, quicker action, cooler acting

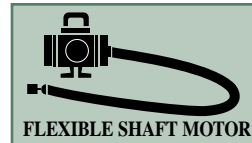
SIZE D X H	ABRASIVE	MAX. RPM	STD. PKG.	BETTER UPC NO.
6 BLANK	A/O VERY FINE FAST CUT	4,000	70	66261003193
6 X 1/4	A/O MEDIUM FAST CUT	4,000	70	66261009957
6 X 1/4	A/O VERY FINE FAST CUT	4,000	70	66261000536
6 X 1/2	A/O MEDIUM FAST CUT	4,000	70	66261009958
6 X 1/2	A/O VERY FINE FAST CUT	4,000	70	66261000601
8 X 1/4	A/O MEDIUM FAST CUT	3,000	50	66261010709
8 X 1/2	A/O MEDIUM FAST CUT	3,000	50	66261009959

BEAR-TEX RAPID STRIP DISCS AND DEPRESSED CENTER WHEELS

Constructed with thick, strong synthetic fibers and extra coarse silicon carbide abrasive, bonded together by a durable smear-resistant adhesive. The open web construction allows cleaning and conditioning of a multitude of materials, quickly and easily with little loading.

TYPICAL APPLICATIONS

- Removal of surface rust and residue, corrosion, light weld splatter, dirt, mill scale and other similar surface contaminants
- Paint and epoxy coating removal
- Surface prep before coatings are applied
- Surface prep before welding
- Cleaning and conditioning after welding



BEST Bear-Tex Rapid Strip Discs and Depressed Center Wheels

FEATURES

- Open web construction
- Conformable
- Extra coarse grit
- Used with portable tools

BENEFITS

- Minimizes loading
- Follow difficult part profiles
- Easy cleaning of uneven surfaces
- Quick cleaning and conditioning of surfaces
- Easy and safe to use especially in difficult to reach areas

BEAR-TEX SURFACE FINISHING PRODUCTS

BEAR-TEX RAPID STRIP DISCS AND DEPRESSED CENTER WHEELS

					BEST
SIZE D X H	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	UPC NO.
BEAR-TEX RAPID STRIP DISCS					
4 X 1/4	SILICON CARBIDE	EXTRA COARSE	8,000	25	66261008008
4 X 3/8	SILICON CARBIDE	EXTRA COARSE	8,000	25	66261008049
4 X 1/2	SILICON CARBIDE	EXTRA COARSE	8,000	25	66261007916
6 X 1/4	SILICON CARBIDE	EXTRA COARSE	5,500	15	66261008136
6 X 1/2	SILICON CARBIDE	EXTRA COARSE	5,500	15	66261008051
BEAR-TEX RAPID STRIP DEPRESSED CENTER WHEELS					
4-1/2 X 7/8	SILICON CARBIDE	EXTRA COARSE	10,500	10	66261009649
4-1/2 X 5/8-11	SILICON CARBIDE	EXTRA COARSE	10,500	10	66261009585
7 X 7/8	SILICON CARBIDE	EXTRA COARSE	6,600	10	66261009586
7 X 5/8-11	SILICON CARBIDE	EXTRA COARSE	6,600	10	66261009650

MANDREL ASSEMBLIES FOR RAPID STRIP DISCS AND DISCS-ON-EDGE

FITS HOLE	FOR DISC WIDTH	FOR DISC DIAMETER	SHANK DIAMETER	OVERALL LENGTH	WASHER DIAMETER	STD. PKG.	UPC NO.
1/4"	1/2" (STANDARD)	UP TO 6"	1/4"	2-1/2"	1-1/2"	1	66261009502
1/2"	1/2" (STANDARD)	UP TO 8"	1/4"	3-1/8"	2-1/4"	1	66261059420

BEAR-TEX ABRASIVE BRUSHES

Tough, flexible nylon filaments embedded with abrasive grain form the bristles of these brushes. Use Bear-Tex abrasive brushes where maximum conformability is needed.



					GOOD
SIZE D X R X H*	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	UPC NO.
7 X 1 X 7/8	SILICON CARBIDE SILICON CARBIDE	80 120	6,000	5	66261058830 66261058834

*DIAMETER X RIM WIDTH X HOLE

AIR-COOLED RUBBER BACK-UP PAD AND RETAINER NUT FOR ABRASIVE BRUSHES

DESCRIPTION	MAX. RPM	STD. PKG.	UPC NO.
7" MEDIUM PAD	7,000	5	63642543422
#103 RETAINER NUT	—	10	63642543463

BEAR-TEX SURFACE FINISHING PRODUCTS

BEAR-TEX SCF DISCS & SCF/STE BELTS

For use on a variety of electric and air powered tools to deburr, clean, blend and finish.

TYPICAL APPLICATIONS

- Removing surface defects
- Removing light edge burrs, parting lines or flashing
- Removing rust, oxides, corrosion, paints and scale
- Cleaning molds
- Blending mill marks, tool marks or uneven edges



BETTER Bear-Tex Surface Blending Discs & Belts

FEATURES

- Flexible and conformable
- Tough, reinforced nylon web
- Uniform, thorough abrasive coating
- Open construction
- Three color-coded grit sizes available
- Discs – Hook and Loop and Speed-Lok locking systems

BENEFITS

- Conform easily to workpiece
- Eliminates edge fraying and grain shedding
- Consistent finish
- Resists loading
- Easy identification and matching of product with application or finish requirement
- Quick replacement, easy on and off
- Disc stays securely on holder

SIZE	ABRASIVE	STD. PKG.	BETTER		
			COARSE (BROWN)	MEDIUM (MAROON)	VERY FINE (BLUE)

BEAR-TEX SURFACE BLENDING SCF DISCS (WITH HOOK AND LOOP FASTENING SYSTEM)

2" BLANK	A/O	80	66261004431	66261004441	66261004451
3" BLANK	A/O	60	66261004432	66261004442	66261004452
4" BLANK	A/O	40	66261004433	66261004443	66261004453
4-1/2" BLANK	A/O	40	66261004434	66261004444	66261004454
5" BLANK	A/O	40	66261004435	66261004445	66261004455
6" BLANK	A/O	30	66261006910	66261006911	66261006912
7" BLANK	A/O	25	66261004436	66261004446	66261004456
8" BLANK	A/O	20	66261006913	66261006914	66261006915

WITH SPEED-LOK TS FASTENING SYSTEM (FITS NORTON TS AND STANDARD ABRASIVES QUICK CHANGE BACK-UP PADS)

2" SPEED-LOK TS	A/O	50	66261004439	66261004449	66261004459
3" SPEED-LOK TS	A/O	25	66261004440	66261004450	66261004460
4" SPEED-LOK TS	A/O	25	66261055349	66261055350	66261055351

WITH SPEED-LOK TR FASTENING SYSTEM (FITS NORTON TR AND 3M ROLOC BACK-UP PADS)

2" SPEED-LOK TR	A/O	50	66261004437	66261004447	66261004457
3" SPEED-LOK TR	A/O	25	66261004438	66261004448	66261004458
4" SPEED-LOK TR	A/O	25	66261008822	66261008821	66261008820



BEAR-TEX SURFACE FINISHING PRODUCTS

BEAR-TEX SCF DISCS

SCF DISC ATTACHMENT SYSTEMS



SURFACE BLENDING SCF DISCS FEATURE A HOOK & LOOP FASTENING SYSTEM.



SPEED-LOK TS SURFACE BLENDING SCF DISCS ARE COMPATIBLE WITH THE NORTON SPEED-LOK TS AND STANDARD ABRASIVES QUICK CHANGE FASTENING SYSTEMS.



SPEED-LOK TR SURFACE BLENDING SCF DISCS ARE COMPATIBLE WITH THE NORTON SPEED-LOK TR AND 3M ROLOC FASTENING SYSTEMS.

PAD DIAMETER	SPINDLE OR HOLE SIZE	MAX. RPM	3M EQUIVALENT	STD. PKG.	UPC NO.
BACK-UP PADS FOR SURFACE BLENDING SCF DISCS					
1-1/2	1/4 STEEL SHANK	25,000	9215	5	66261059350
2	1/4 STEEL SHANK	23,000	922	5	66261059352
3	1/4 STEEL SHANK	20,000	923	5	66261059354
4	1/4 STEEL SHANK 1/2-13 5/8-11 M10 X 1.250 M14	18,000 13,000	924 914 914 914	5	66261059356 66261059303 66261059304 66261059305 66261059307
4-1/2	5/8-11	10,000	9145	5	66261006948
5	5/16-24 MALE 3/8-24 MALE 1/2-13 5/8-11	10,000	905 905 915 915	5	66261059360 66261059308 66261059309 66261059310
6	5/16-24 MALE* 5/8-11	10,000 8,000	906 916	5	66261059364 66261059312
7	5/8-11	6,000	917	5	66261059368
8	5/8-11	4,500	918	5	66261059372

*FOR RANDOM ORBITAL SANDERS ONLY.

PAD DIAMETER	DESCRIPTION	MAX. RPM	STD. PKG.	UPC NO.
SPEED-LOK BACK-UP PADS FOR SURFACE BLENDING SCF DISCS				
1-1/2	MEDIUM SPEED-LOK TR BACK-UP PAD	30,000	10	66261047580
2	HARD SPEED-LOK TS BACK-UP PAD	30,000	10	63642543205
	MEDIUM SPEED-LOK TS BACK-UP PAD	25,000	10	63642543210
	MEDIUM SPEED-LOK TR BACK-UP PAD	25,000	10	66261055103
3	HARD SPEED-LOK TS BACK-UP PAD	20,000	10	63642543220
	MEDIUM SPEED-LOK TS BACK-UP PAD	20,000	10	63642543225
	SOFT SPEED-LOK TS BACK-UP PAD	12,000	10	63642543230
	MEDIUM SPEED-LOK TR BACK-UP PAD	20,000	10	66261055105
4	MEDIUM SPEED-LOK TS BACK-UP PAD	12,000	10	66261043232
	MEDIUM SPEED-LOK TR BACK-UP PAD	12,000	10	66261047581

BEAR-TEX SURFACE FINISHING PRODUCTS

BEAR-TEX SCF & STE BELTS

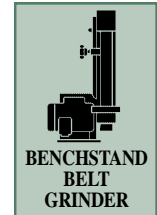
SIZE WIDTH X LENGTH	ABRASIVE	STD. PKG.	BETTER		
			COARSE (BROWN)	MEDIUM (MAROON)	VERY FINE (BLUE)

BEAR-TEX SURFACE FINISHING SCF BELTS

1/2 X 18	A/O	24	66261009048	66261008814	66261006762
1/2 X 24	A/O	24	66261008510	66261008972	66261006439
3/4 X 18	A/O	12	66261008813	66261006546	66261006706
2 X 132	A/O	6	66261008491	66261008492	66261008493
3 X 132	A/O	4	66261007022	66261008499	66261009023
4 X 132	A/O	2	66261009056	66261009057	66261009058

BEAR-TEX SURFACE FINISHING STE BELTS

1/2 X 18	A/O	24	66261055309	66261055310	66261055311
1/2 X 24	A/O	24	66261055312	66261055313	66261055314
3-1/2 X 15-1/2	A/O	8	66261055324	66261055325	66261055326
6 X 48	A/O	4	66261055330	66261055331	66261055332



SpecCheck

STARTING RECOMMENDATIONS

DEBURRING	CLEANING / BLENDING	FINISHING
Coarse (Brown)	Medium (Maroon)	Very Fine (Blue)

TechTips

- For removing 60 to 120 grit grindlines – use coarse grit (brown)
- For removing 120 to 180 grit grindlines – use medium grit (maroon)
- For removing 180 to 320 grit grindlines – use very fine grit (blue)



It is the user's responsibility to refer to and comply with ANSI B7.1

BEAR-TEX FLAP WHEELS

A very conformable Bear-Tex product. They provide a cushioning action which is ideal for use on uneven or irregular surfaces as well as flat areas.

TYPICAL APPLICATIONS

- Cleaning threaded parts
- Removing oxide from printed circuit boards
- De-glossing plastic parts
- Producing uniform finishes on aluminum, brass and stainless steel
- Can be used on automatic and robotic equipment



BEAR-TEX SURFACE FINISHING PRODUCTS

BEAR-TEX FLAP WHEELS (CONTINUED)

SIZE D X T X SPINDLE	ABRASIVE/ GRIT	MAX. RPM	STD. PKG.	BETTER	
				UPC NO.	
BEAR-TEX FLAP WHEELS – SPINDLE MOUNTED (1/4")					
2 X 1 X 1/4" SPINDLE	A/O MEDIUM A/O VERY FINE	22,000	20	66261051716 66261051717	
3 X 1 X 1/4" SPINDLE	A/O MEDIUM A/O VERY FINE	18,000	20	66261051718 66261051719	
3 X 2 X 1/4" SPINDLE	A/O MEDIUM	12,000	10	66261058474	



SIZE D X T X H	ABRASIVE/ GRIT	DENSITY	MAX. RPM	STD. PKG.	BETTER	
					UPC NO.	
BEAR-TEX FLAP WHEELS						
6 X 1 X 2	A/O MEDIUM	MEDIUM MEDIUM MEDIUM MEDIUM	3,000	4	66261058456	
	A/O FINE				66261058487	
	S/C FINE				66261058451	
	S/C VERY FINE				66261058450	
8 X 1 X 3	A/O FINE	MEDIUM	2,500	3	66261058491	
8 X 2 X 3	A/O MEDIUM	HARD MEDIUM	2,500	2	66261000889	
	A/O FINE				66261058493	
12 X 1 X 5	A/O MEDIUM	HARD MEDIUM	1,900	2	66261002051	
	A/O MEDIUM				66261000329	
12 X 2 X 5	A/O MEDIUM	HARD MEDIUM	1,900	1	66261001993	
	A/O MED. HIGH STRENGTH				66261005070	



Refer to "Bear-Tex Convolute Wheels" section, for flap wheel reducing bushings.

SIZE D X T X SPINDLE	COATED ABRASIVE/ GRIT	MAX. RPM	STD. PKG.	BETTER	
				UPC NO.	
BEAR-TEX INTERLEAF FLAP WHEELS – SPINDLE MOUNTED (1/4")					
2 X 1 X 1/4" SPINDLE	A/O 60	22,000	20	66261051720	
	A/O 80			66261051721	
	A/O 120			66261051722	
3 X 1 X 1/4" SPINDLE	A/O 60	18,000	20	66261051723	
	A/O 80			66261051724	
	A/O 120			66261051725	



SIZE D X T X H	COATED ABRASIVE/ GRIT	DENSITY	MAX. RPM	STD. PKG.	BETTER	
					UPC NO.	
BEAR-TEX INTERLEAF FLAP WHEELS						
6 X 1 X 2	A/O 80	MEDIUM MEDIUM MEDIUM	3,000	4	66261004418	
	A/O 120				66261007678	
	A/O 180				66261005387	
8 X 1 X 3	A/O 60	HARD MEDIUM MEDIUM 3:1* MEDIUM MEDIUM	2,500	3	66261008235	
	A/O 80				66261004419	
	A/O 80				66261007257	
	A/O 120				66261010711	
	A/O 180				66261005388	
12 X 1 X 5	A/O 80	MEDIUM MEDIUM MEDIUM	1,900	2	66261010712	
	A/O 120				66261004667	
	A/O 180				66261004666	

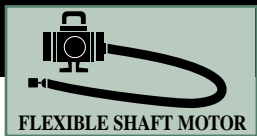


Interleaf flap wheels consist of alternating flaps of aluminum oxide coated abrasive cloth and medium grit Bear-Tex material. The interleaf product is less conformable than a standard Bear-Tex flap wheel and will remove more material.

* SUPPLIED WITH THREE FLAPS OF COATED ABRASIVE TO ONE FLAP OF BEAR-TEX MATERIAL (MORE AGGRESSIVE, LESS CONFORMABLE THAN THE 1:1 RATIO FLAP WHEELS)



BEAR-TEX SURFACE FINISHING PRODUCTS



BEAR-TEX CONVOLUTE WHEELS

Formed by wrapping and bonding web material impregnated with abrasive grain and resin around a center core. Convolute wheels offer a wide range of utility from heavy burr removal to cleaning rust and oxides.

TYPICAL APPLICATIONS

- Burr and flashing removal
- Surface roughness reduction
- Blending weld areas on stainless steel
- Blending scratch patterns
- Weld polishing
- Removing rust and oxides
- Applying decorative finishes including antique patterns

BEAR-TEX SURFACE FINISHING PRODUCTS

BEST Bear-Tex Clean & Finish Wheels – Fine finish with light pressure

FEATURES	BENEFITS
<ul style="list-style-type: none"> • Silicon carbide grain 	<ul style="list-style-type: none"> • Good for blending, rust removal, applying decorative, contrast finishes and low to moderate speed applications • Not used for deburring
<ul style="list-style-type: none"> • Open mesh construction 	<ul style="list-style-type: none"> • Used with light to moderate pressure, low speed

BEST Surface Finishing Wheels – Uniform finish with moderate pressure

FEATURES	BENEFITS
<ul style="list-style-type: none"> • Stronger web 	<ul style="list-style-type: none"> • More aggressive cutting action and more durability than Clean & Finish wheels • Ideal for rust and paint removal, coarse, decorative finishes and blending

BEST Bear-Tex Metal Finishing Wheels – For light deburring, blending and final finishing

FEATURES	BENEFITS
<ul style="list-style-type: none"> • Premium, medium grit aluminum oxide grain 	<ul style="list-style-type: none"> • Generates uniform distinct satin and antique finishes
<ul style="list-style-type: none"> • Dense, very durable web 	<ul style="list-style-type: none"> • Can be used for light deburring applications
<ul style="list-style-type: none"> • Strongest resin binders 	<ul style="list-style-type: none"> • Resilient, long life construction
<ul style="list-style-type: none"> • Uniform grain dispersion and coating 	<ul style="list-style-type: none"> • Clean and condition without gouging or changing dimensions of workpiece

BEST Bear-Tex Series 1000 Wheels – The choice for general deburring, blending and finishing

FEATURES	BENEFITS
<ul style="list-style-type: none"> • Smear and heat resistant formula 	<ul style="list-style-type: none"> • Consistent, high quality results
<ul style="list-style-type: none"> • Dense web construction (9 density) 	<ul style="list-style-type: none"> • Starting point for deburring, blending, polishing and finishing applications
<ul style="list-style-type: none"> • More open web construction (6 density) 	<ul style="list-style-type: none"> • Smear-proof and cool cutting on light deburring applications
<ul style="list-style-type: none"> • Waterproof 	<ul style="list-style-type: none"> • Use dry, wet or with oil
<ul style="list-style-type: none"> • Non-metallic 	<ul style="list-style-type: none"> • No contamination of workpiece

M112

BEAR-TEX SURFACE FINISHING PRODUCTS

BEAR-TEX CONVOLUTE WHEELS (CONTINUED)

BEST Bear-Tex Series 2000 Wheels – Engineered for deburring of heat sensitive metals	
<i>FEATURES</i>	<i>BENEFITS</i>
<ul style="list-style-type: none"> • Advanced resin bond system 	<ul style="list-style-type: none"> • Consistent, high quality results • Smear-proof • Cool cutting where heat generation must be kept to a minimum
<ul style="list-style-type: none"> • Conformable and flexible 	<ul style="list-style-type: none"> • Eliminates “over cut” or gouging on titanium products like prostheses and aerospace turbine blades

BEST Bear-Tex Series 4000 Wheels – Ideal for heavy deburring applications	
<i>FEATURES</i>	<i>BENEFITS</i>
<ul style="list-style-type: none"> • Advanced resin bond system 	<ul style="list-style-type: none"> • Free cutting
<ul style="list-style-type: none"> • High quality synthetic web 	<ul style="list-style-type: none"> • Use both wet and dry • Long life for heavy deburring, edge breaking and removing parting lines on exotic metals

<i>SIZE D X T X H</i>	<i>ABRASIVE</i>	<i>GRIT</i>	<i>MAX. RPM</i>	<i>STD. PKG.</i>	BEST <i>UPC NO.</i>
BEAR-TEX CLEAN & FINISH CONVOLUTE WHEELS					
4 X 1 X 1	SILICON CARBIDE SILICON CARBIDE	MEDIUM FINE	4,000	10	66261058502 66261058501
6 X 1 X 1	SILICON CARBIDE SILICON CARBIDE	MEDIUM FINE	3,000	4	66261058507 66261058506
6 X 2 X 1	SILICON CARBIDE SILICON CARBIDE	MEDIUM FINE	3,000	2	66261058510 66261058509
6 X 3 X 1	SILICON CARBIDE	MEDIUM	3,000	1	66261058512
6 X 4 X 1	SILICON CARBIDE	MEDIUM	3,000	1	66261058514
8 X 1 X 3	SILICON CARBIDE	MEDIUM	2,500	3	66261058518
8 X 2 X 3	SILICON CARBIDE	MEDIUM	2,500	2	66261058521
8 X 3 X 3	SILICON CARBIDE	MEDIUM	2,500	1	66261058524
8 X 4 X 3	SILICON CARBIDE	MEDIUM	2,500	1	66261058526
12 X 2 X 5	SILICON CARBIDE	MEDIUM	1,900	1	66261058534

BEAR-TEX SURFACE FINISHING CONVOLUTE WHEELS					
6 X 1 X 1	ALUMINUM OXIDE SILICON CARBIDE SILICON CARBIDE	MEDIUM COARSE MEDIUM	4,500	4	66261058550 66261058553 66261058552
6 X 2 X 1	ALUMINUM OXIDE SILICON CARBIDE	MEDIUM MEDIUM	4,500	2	66261058556 66261058560
12 X 2 X 5	SILICON CARBIDE	COARSE	2,500	1	66261058574
14 X 1 X 8	SILICON CARBIDE	COARSE	2,000	2	66261006351

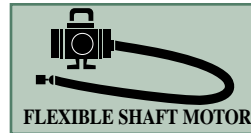
BEAR-TEX METAL FINISHING CONVOLUTE WHEELS					
6 X 1 X 1	ALUMINUM OXIDE	5AM	6,000	3	66261007936
6 X 2 X 1	ALUMINUM OXIDE	5AM	6,000	2	66261007957
8 X 1 X 3	ALUMINUM OXIDE	5AM	4,500	3	66261007831
8 X 2 X 3	ALUMINUM OXIDE	5AM	4,500	2	66261007904
12 X 1 X 5	ALUMINUM OXIDE	5AM	3,000	2	66261007434
12 X 2 X 5	ALUMINUM OXIDE	5AM	3,000	1	66261007212
14 X 2 X 8	ALUMINUM OXIDE	5AM	2,550	1	66261007817



BEAR-TEX SURFACE FINISHING PRODUCTS



BEAR-TEX CONVOLUTE WHEELS (CONTINUED)



PEDESTAL
GRINDER

BEST

SIZE D X T X H	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	UPC NO.
BEAR-TEX B442-XHD CONVOLUTE WHEELS					
6 X 1/2 X 1	SILICON CARBIDE	FINE	6,000	4	66261054908
6 X 1 X 1	SILICON CARBIDE	FINE	6,000	3	66261058700
8 X 1 X 3	SILICON CARBIDE	FINE	4,500	3	66261058710
8 X 2 X 3	SILICON CARBIDE	FINE	4,500	2	66261058718
10 X 2 X 5	SILICON CARBIDE	FINE	3,600	1	66261002302
12 X 1 X 5	SILICON CARBIDE	FINE	3,000	2	66261058730
12 X 2 X 5	SILICON CARBIDE	FINE	3,000	1	66261058732



A closed mesh, very dense product that yields fast cut rates while producing fine finishes. Best when used with heavy pressure and high speeds.



BEST

SIZE D X T X H	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	6 DENSITY UPC NO.	7 DENSITY UPC NO.	8 DENSITY UPC NO.	9 DENSITY UPC NO.
BEAR-TEX SERIES 1000 CONVOLUTE WHEELS								
6 X 1/2 X 1	SILICON CARBIDE SILICON CARBIDE	FINE MEDIUM	6,000	4		66261055222	66261055248	66261055272 66261055370
6 X 1 X 1	ALUMINUM OXIDE ALUMINUM OXIDE SILICON CARBIDE SILICON CARBIDE SILICON CARBIDE	MEDIUM FINE MEDIUM FINE VERY FINE	6,000	3	66261055205 66261055204 66261055202 66261055201 66261055200	66261055226 66261055225 66261055224 66261055223	66261055252 66261055251 66261055250 66261055249	66261055371 66261055273
6 X 2 X 1	ALUMINUM OXIDE SILICON CARBIDE SILICON CARBIDE	MEDIUM MEDIUM FINE	6,000	2	66261055206	66261055229 66261055228 66261055227	66261000496 66261055253	66261055274
8 X 1 X 3	ALUMINUM OXIDE ALUMINUM OXIDE SILICON CARBIDE SILICON CARBIDE	MEDIUM FINE MEDIUM FINE	4,500	3	66261055209	66261055232	66261055257 66261055256 66261055255	66261055372 66261055275
8 X 2 X 3	ALUMINUM OXIDE ALUMINUM OXIDE SILICON CARBIDE SILICON CARBIDE	MEDIUM FINE MEDIUM FINE	4,500	2	66261055211	66261055234 66261055233	66261055259 66261001979 66261055258	66261055276
10 X 1 X 5	ALUMINUM OXIDE SILICON CARBIDE	MEDIUM FINE	3,600	3		66261001813	66261055260	66261055277
10 X 2 X 5	SILICON CARBIDE	FINE	3,600	1			66261000836	66261002806
12 X 1 X 5	ALUMINUM OXIDE SILICON CARBIDE SILICON CARBIDE	MEDIUM MEDIUM FINE	3,000	2	66261055216 66261055215	66261055239 66261055237	66261055264 66261055263 66261055262	66261055373 66261055278
12 X 2 X 5	ALUMINUM OXIDE SILICON CARBIDE SILICON CARBIDE	MEDIUM MEDIUM FINE	3,000	1		66261055243 66261055241 66261055240	66261055266 66261055265	66261055374 66261055279
14 X 1 X 8	SILICON CARBIDE	MEDIUM	2,550	2	66261008722			66261002114
14 X 2 X 8	ALUMINUM OXIDE SILICON CARBIDE SILICON CARBIDE	MEDIUM MEDIUM FINE	2,550	1	66261055220		66261055270	66261055281

BEAR-TEX SURFACE FINISHING PRODUCTS

M114

BEAR-TEX SURFACE FINISHING PRODUCTS

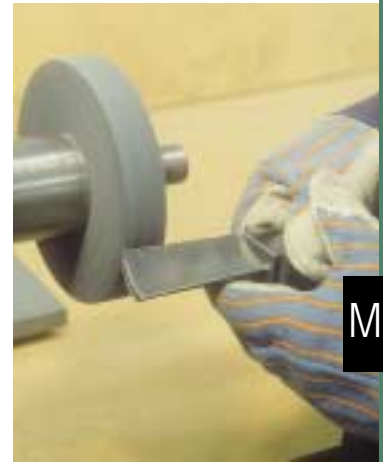
BEAR-TEX CONVOLUTE WHEELS (CONTINUED)

SIZE D X T X H	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	BEST		
					6 DENSITY UPC NO.	8 DENSITY UPC NO.	9 DENSITY UPC NO.
BEAR-TEX SERIES 2000 CONVOLUTE WHEELS							
6 X 1 X 1	SILICON CARBIDE	FINE	6,000	3	66261055282	66261055283	
6 X 2 X 1	SILICON CARBIDE	FINE	6,000	2		66261055285	
8 X 1 X 3	SILICON CARBIDE	FINE	4,500	3	66261055286		
10 X 2 X 5	SILICON CARBIDE	FINE	3,600	1		66261008674	
12 X 1 X 5	SILICON CARBIDE	FINE	3,000	2		66261055291	
12 X 2 X 5	SILICON CARBIDE	FINE	3,000	1		66261055293	
BEAR-TEX SERIES 4000 CONVOLUTE WHEELS							
6 X 1/2 X 1	SILICON CARBIDE	FINE	6,000	4			66261004021
6 X 1 X 1	ALUMINUM OXIDE SILICON CARBIDE	MEDIUM FINE	6,000	3		66261004208 66261004142	66261004141
8 X 1 X 3	ALUMINUM OXIDE SILICON CARBIDE	MEDIUM FINE	4,500	3		66261004165 66261004123	66261004135
12 X 1 X 5	SILICON CARBIDE	FINE	3,000	2		66261004284	66261004148
12 X 2 X 5	SILICON CARBIDE	FINE	3,000	1			66261004011
14 X 1 X 8	ALUMINUM OXIDE SILICON CARBIDE	MEDIUM FINE	2,550	2		66261003944 66261004965	



REDUCING BUSHINGS FOR BEAR-TEX FLAP AND CONVOLUTE WHEELS

WHEEL CENTER HOLE	BUSHING REDUCES HOLE SIZE TO	FOR WHEEL DIAMETER	STD. PKG.	UPC NO.
1"	3/8" 1/2" 5/8" 3/4" 7/8"	4" THRU 6"	1 PAIR	63642559436 63642559437 63642559438 63642559439 63642559440
2"	1/2" 5/8" 1" 1-1/4"	6"	1 PAIR	66261059464 66261059466 66261059468 66261047582
3"	1" 1-1/4" 1-1/2" 1-3/4" 2"	8"	1 PAIR	66261059472 66261059473 66261059474 66261159475 66261059476
5"	1" 1-1/4" 3"	10" AND 12"	1 PAIR	66261059487 66261059488 66261059491
8"	1-1/4" 3"	14"	1 PAIR	66261059496 66261059499



M115

BEAR-TEX SURFACE FINISHING PRODUCTS

TechTips

- Light to medium pressure is recommended. Excessive pressure may result in part damage.
- Lubricants such as water-soluble oil and straight oil will decrease the heat and improve the surface finish and lustre.
- Oscillation may be used to break up scratch lines and produce a more uniform finish. Additionally, an increase in cut may be experienced. A general starting point for oscillation is 3/8" amplitude at 200 cycles per minute.

- Convolute wheels must always run in the direction indicated by the arrow printed on the side of each wheel.



It is the user's responsibility to refer to and comply with ANSI B7.1

BEAR-TEX SURFACE FINISHING PRODUCTS

BEAR-TEX CONVOLUTE WHEELS (CONTINUED)

SpecCheck



TROUBLESHOOTING GUIDE

PROBLEM	CORRECTION
Slow cut rate	Increase density Decrease wheel speed Use coarser grit
Low conformability	Decrease density Reduce pressure
Poor form holding	Increase density Decrease wheel speed Reduce pressure
Poor finish	Increase density Increase oscillation Use lubricant: - Water – fine - Water soluble – finer - Oil – finest Increase wheel speed (observe MAX.RPM)

BEAR-TEX SERIES 1000, 2000 AND 4000 MARKING SYSTEM

BOND SYSTEM	DENSITY	ABRASIVE	GRIT SIZE
1 = Series 1000	6 = Open/Conformable	A = Aluminum Oxide	F = Fine
2 = Series 2000	7	S = Silicon Carbide	M = Medium
4 = Series 4000	8		VF = Very Fine
	9 = Dense/Durable		

STARTING SPECIFICATIONS - SERIES 1000 WHEELS

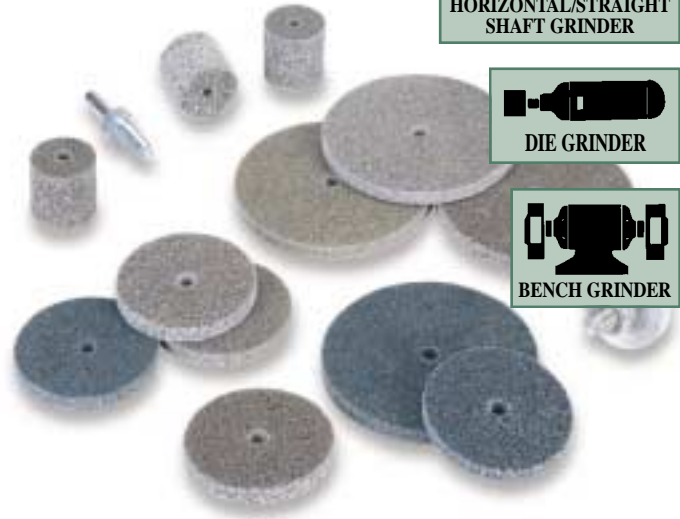
We recommend starting these applications with a Series 1000 Wheel

TOOL/EQUIPMENT PORTABLE STRAIGHT SHAFT STATIONARY	APPLICATIONS / RECOMMENDED STARTING POINT			
	CLEANING	DEBURRING	BLENDING	FINISHING
	1-6AM, 1-7AM • General purpose cleaning • Removing rust, oxidation, corrosion, discoloration	1-9SF, B442-XHD • Removing medium to heavy burrs • Deburring die cast flashings, pipe threads, machine parts, plastic molded parts	1-7SF • Smoothing parting lines • Polishing welds, machine parts • Smoothing radii on metal parts • Blending coated abrasive scratch pattern	1-7SF • Satin finish • Cosmetic finish • Brush finish

STARTING RECOMMENDATIONS

	DEBURRING/BLENDING/POLISHING		CLEANING AND FINISHING
HEAT SENSITIVE APPLICATIONS Series 2000 Wheels	DEBURRING Series 1000 Wheels Series 2000 Wheels Series 4000 Wheels	MEDIUM GRAIN FINISHING Surface Finishing Wheels Metal Finishing Wheels	FINE GRAIN FINISHING Clean & Finish Wheels

BEAR-TEX SURFACE FINISHING PRODUCTS



BEAR-TEX UNIFIED WHEELS

Designed for maintenance operations needing an efficient and cost-effective method of deburring, polishing, cleaning or finishing of metals or composites.

TYPICAL APPLICATIONS

- Deburring flashings, threads, sharp edges
- Removing excessive bonding agents after curing
- Blending alloys
- Polishing sheet metal, stainless steel
- Polishing precision metal pieces, welds

Bear-Tex Unified Wheels

FEATURES

- Easily preformed
- Hold shape well
- Non-metallic
- Uniform construction

BENEFITS

- Usable on a wide variety of shapes/contours
- Less wheel dressing
- No contamination of workpiece
- Maintains part tolerance; prevents cutting or gouging

BEST

Bear-Tex Series 10 Unified Wheels

FEATURES

- Uniform construction
- Smear-resistant formula

BENEFITS

- Extra long life
- Excellent smear-free finish

BETTER

Bear-Tex Deburring Unified Wheels

FEATURES

- Controlled density range

BENEFITS

- More durable than General Duty wheels
- Good starting point for high speed deburring applications

GOOD

Bear-Tex General Duty Unified Wheels

FEATURES

- Outstanding resistance to snagging

BENEFITS

- For general purpose light deburring applications

SIZE D X T X H	SPECIFICATION	MAX. RPM	STD. PKG.	BEST	
				UPC NO.	
BEAR-TEX SERIES 10 UNIFIED WHEELS					
1 X 1 X 3/16	UW1-6AF	30,000	50	66261003672	
	UW1-8AC			66261003680	
	UW1-8AM			66261003676	
2 X 1/4 X 1/4	UW1-2AM	18,000	60	66261003663	
	UW1-2SF			66261003666	
	UW1-4SF	22,000		66261003669	
	UW1-6AF			66261003673	
	UW1-8AM			66261003677	
3 X 1/4 X 1/4	UW1-2AM	12,000	40	66261003664	
	UW1-2SF			66261003667	
	UW1-4SF	18,000		66261003670	
	UW1-6AF			66261003674	
	UW1-8AM			66261003678	
3 X 1/4 X 3/8	UW1-2AM	12,000	40	66261003665	
	UW1-2SF			66261003668	
	UW1-4SF	18,000		66261003671	
	UW1-6AF			66261003675	
	UW1-8AM			66261003679	

TechTips

Unified wheels can be run in either direction.



It is the user's responsibility to refer to and comply with ANSI B7.1

BEAR-TEX SURFACE FINISHING PRODUCTS

BEAR-TEX UNIFIED WHEELS (CONTINUED)

SIZE D X T X H	ABRASIVE	GRIT	MAX. RPM	STD. PKG.	BETTER	
					UPC NO.	
BEAR-TEX DEBURRING UNIFIED WHEELS						
2 X 1/4 X 1/4	ALUMINUM OXIDE	120	20,000	60	66261052201	
	ALUMINUM OXIDE	220			66261052200	
2 X 1/2 X 1/4	ALUMINUM OXIDE	120	20,000	40	66261058876	
	SILICON CARBIDE	220			66261058782	
3 X 1/4 X 1/4	ALUMINUM OXIDE	120	18,000	40	66261002089	
	ALUMINUM OXIDE	220			66261058877	
	SILICON CARBIDE	220			66261058854	
3 X 1/2 X 1/4	SILICON CARBIDE	220	18,000	20	66261058859	
3 X 3/4 X 1/4	ALUMINUM OXIDE	120	18,000	20	66261058880	
	ALUMINUM OXIDE	220			66261058881	



SIZE D X T X H	ABRASIVE	GRIT	DENSITY	MAX. RPM	STD. PKG.	GOOD	
						UPC NO.	
BEAR-TEX GENERAL DUTY UNIFIED WHEELS							
1 X 1 X 3/16	ALUMINUM OXIDE	80	HARD	15,000	50	66261000938	
2 X 1/4 X 1/4	ALUMINUM OXIDE	80	HARD	11,000	60	66261052275	
2 X 1/2 X 1/4	ALUMINUM OXIDE	220	MEDIUM	11,000	40	66261058764	
	SILICON CARBIDE	150	MEDIUM			66261058766	
	SILICON CARBIDE	220	MEDIUM			66261058765	
3 X 1/4 X 1/4	ALUMINUM OXIDE	80	HARD	8,000	40	66261052276	
	ALUMINUM OXIDE	220	MEDIUM			66261058816	
	SILICON CARBIDE	220	MEDIUM			66261000745	
3 X 1/2 X 1/4	ALUMINUM OXIDE	220	MEDIUM	8,000	20	66261054046	
	SILICON CARBIDE	220	MEDIUM			66261054048	
3 X 3/4 X 1/4	ALUMINUM OXIDE	220	MEDIUM	8,000	20	66261058769	
	SILICON CARBIDE	150	MEDIUM			66261058773	
	SILICON CARBIDE	220	MEDIUM			66261058771	
6 X 1/2 X 1/2	SILICON CARBIDE	150	MEDIUM	4,800	8	66261058779	
6 X 1 X 1/2	SILICON CARBIDE	150	MEDIUM	4,800	4	66261058792	
	SILICON CARBIDE	220	MEDIUM			66261058790	
6 X 1 X 1	ALUMINUM OXIDE	220	MEDIUM	4,800	4	66261058814	
	SILICON CARBIDE	220	MEDIUM			66261058797	

BEAR-TEX SURFACE FINISHING PRODUCTS

M118

MANDREL ASSEMBLIES FOR UNIFIED WHEELS

FITS WHEEL CENTER HOLE	FOR WHEEL WIDTHS	FOR WHEEL DIAMETER	SHANK DIAMETER	OVERALL LENGTH	WASHER DIAMETER	3M EQUIVALENT	STD. PKG.	UPC NO.
1/8" - 3/16"	UP TO 3/4"	UP TO 2"	1/8"	1-3/4"	7/16"	931	1	66261009849
3/16"	1/8" - 1/2"	1" - 2"	1/4"	2"	7/16"	994	1	66261009852
1/4" - 5/16"	UP TO 1" UP TO 1"	UP TO 2"	1/4"	2-1/4"	5/8"	932	1	66261059422
		2" - 3"	1/4"	2-1/4"	3/4"	933	1	66261059421
3/8"	UP TO 1/2"	2" - 4"	1/4"	2-1/2"	1"	990	1	66261009851
1/2"	UP TO 1"	3" - 6"	1/4"	3-1/8"	1-5/8"	934	1	66261009850

THREADED MANDREL FOR UNIFIED WHEELS

SHANK LENGTH	SHANK DIAMETER	FOR CENTER HOLE	USE WITH UNIFIED WHEEL	3M EQUIVALENT	STD. PKG.	UPC NO.
2"	1/4"	3/16	1 X 1 X 3/16	948	5	66261047584

BEAR-TEX SURFACE FINISHING PRODUCTS

BEAR-TEX UNIFIED WHEELS (CONTINUED)

SpecCheck

SERIES 10 UNIFIED WHEEL MARKING SYSTEM

SPECIFICATION	DENSITY	ABRASIVE	GRIT SIZE
UW1	2 - Softer	A = Aluminum	C = Coarse
Unified Wheel	4	Oxide	M = Medium
Series 10	6	S = Silicon	F = Fine
	8 - Harder	Carbide	

STARTING RECOMMENDATIONS

APPLICATION	SPECIFICATION
Heavy deburring	UW1-8AM Series 10 Wheel
Medium deburring	UW1-6AF Series 10 Wheel
Light deburring	220 grit S/C Deburring Wheel
Medium grain finishing	150 grit S/C medium density General Duty Wheel
Fine grain finishing	220 grit S/C medium density General Duty Wheel

BEAR-TEX POLYBOND WHEELS

Polybond wheels are manufactured by bonding abrasive grain into a foamed polyurethane matrix, similar to bonded grinding wheels, yet flexible and conformable.

TYPICAL APPLICATIONS

METAL CONDITIONING WHEELS

- Heavy duty deburring applications
- High surface temperature applications
- Replacing wire brushes
- Finishing applications

WOOD FINISHING WHEELS

- Wood mold profile sanding



SIZE D X T X H	SPECIFICATION	MAX. RPM	STD. PKG.	BETTER UPC NO.
BEAR-TEX POLYBOND REINFORCED METAL CONDITIONING WHEELS				
1 X 1 X 3/16	A80-F4BTR	24,000	50	66261002022
3 X 1/4 X 1/4	A40-H5BTR C80-H4BTR	18,000	40	66261006044 66261002077



Reinforced metal conditioning wheels have a stronger, more aggressive bond than non-woven unified wheels, which provides a high rate of cut and long life. These wheels are geared for higher RPM's and air tool applications.

BEAR-TEX POLYBOND METAL CONDITIONING WHEELS

SIZE D X T X H	SPECIFICATION	MAX. RPM	STD. PKG.	UPC NO.
6 X 1/2 X 1-1/4	C150-H10BTM	3,600	8	66261010696
6 X 1 X 1-1/4	A40-H10BTM	3,600	4	66261006117
6 X 1 X 1-1/4	A40-J10BTM	3,600	4	66261010697
6 X 1 X 1-1/4	C80-F7BTM	3,600	4	66261010698
6 X 1 X 1-1/4	C240-D4BTM	2,200	4	66261010695



SpecCheck

STARTING RECOMMENDATIONS FOR BEAR-TEX POLYBOND METAL CONDITIONING WHEELS

All purpose finishing and polishing	C240-D4BTM
General deburring - nonferrous materials	C80-F7BTM
General deburring - nonferrous and coarse finishing	A40-H10BTM
General deburring and finishing	C150-H10BTM
Saw blade finishing	A40-J10BTM

STARTING RECOMMENDATIONS FOR BEAR-TEX POLYBOND REINFORCED METAL CONDITIONING WHEELS

Aircraft components - polishing, deburring	A80-F4BTR
Tool & Die - deburring, blending, polishing	A40-H5BTR
Mold and die repair	C80-H4BTR
Fabrication - edge breaking, corner blending	A80-F4BTR
Fittings - deburring, cleaning threads, slotting	A80-F4BTR

BEAR-TEX SURFACE FINISHING PRODUCTS

BEAR-TEX POLYBOND WHEELS (CONTINUED)

SIZE D X T X H	SPECIFICATION	MAX. RPM	STD. PKG.	BETTER	
				UPC NO.	
BEAR-TEX POLYBOND WOOD FINISHING WHEELS					
6 X 2 X 1-1/4	G60-H9BTW C80-F7BTW	3,600	2	66261003833 66261009750	
8 X 2 X 1-1/4	G60-H9BTW C80-F7BTW G100-D7BTW	2,600	2	66261004253 66261004579 66261009846	



Polybond polyurethane foam wood finishing wheels provide the ideal balance between long life and profile edge holding ability—matched with fast cut rates and uncompromised finishing capability.

BEAR-TEX POLYBOND WOOD FINISHING WHEEL SHAPING KIT

1 KIT | 66261055352

Contains aluminum oxide PSA-backed abrasive sheet and instructions to dress final shapes into wheels.



SpecCheck

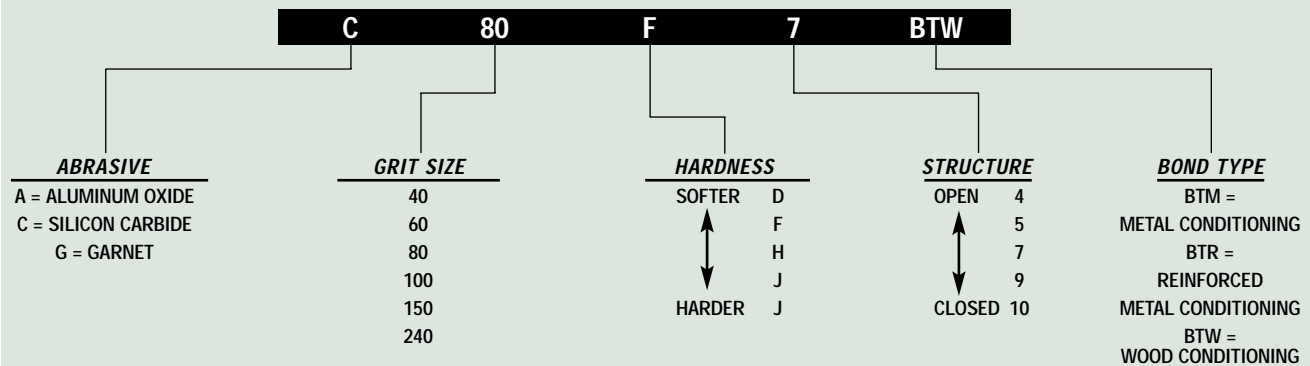
BEAR-TEX POLYBOND WOOD FINISHING WHEEL SPEED RECOMMENDATION CHART

WHEEL DIAMETER	SOFT MAPLE, POPLAR, MAHOGANY, PINE, GUM SUGGESTED SFPM: 1500 - 2000	OAK, WALNUT, ROCK MAPLE, PECAN, CHERRY SUGGESTED SFPM: 900 - 1400	SYNTHETIC BOARD PRODUCTS SUGGESTED SFPM: 2000 - 2500
6"	900 - 1250 RPM	550 - 850 RPM	1300 - 1600 RPM
8"	650 - 900 RPM	400 - 600 RPM	950 - 1200 RPM

STARTING RECOMMENDATIONS

APPLICATION	SPEC
Intermediate sanding of solid woods	G60-H9BTW
Finish sanding of solid woods	C60-H9BTW
Finish sanding of synthetic board products	C80-F7BTW
Sealer sanding	G100-D7BTW

Polybond Product Identification System



BEAR-TEX SURFACE FINISHING PRODUCTS

INTRODUCTION

Most Bear-TEX products consist of a non-woven web of nylon fibers impregnated throughout with abrasive grain and bonded with synthetic resins. This design produces a cushioned, three-dimensional material that is extremely pliable and long lasting. The uniform dispersion of abrasive throughout the web provides a continuous supply of new grain as the old grain and fibers wear away during use.

Bear-TEX products, with their open mesh construction, are waterproof, washable, resilient, conformable, non-loading, non-conductive, non-metallic, and non-rusting. Bear-TEX wheels are easily pre-formed to conform to special-shaped work pieces.

Since Bear-TEX products are designed for use where stock removal is not required, they begin where other abrasives leave off. The relatively non-aggressive nature of nylon and grit inherent in the Bear-TEX material makes it ideal as a finishing tool. While 60 to 80 grit are considered intermediate sizes in other products, they are considered coarse for Bear-TEX items.

Bear-TEX can be used on aluminum, brass, copper, nickel, chrome plate, stainless steel, zinc, titanium, tantalum, ceramics, glass, plastic, fiberglass, wood, plywood and other materials. Applications include deburring, cleaning, scrubbing, scouring, blending, polishing, highlighting, removing flash from plastic parts, removing fuzz from plywood, dulling laminates, removing oxides and rust, scuffing paint before repainting, rubbing sealers, removing raised wood fiber, and imparting satin and decorative finishes.

Used wet or dry, Bear-TEX products offer the following advantages: controlled cut, with little or no stock removal, allows for increased productivity, consistent, uniform finish, ability to automate operations, minimized smearing and reduced operator training. These advantages make Bear-TEX products an excellent alternative to bristle brushes, set-up wheels, greaseless compounds, and steel wool.

ABRASIVES

Silicon carbide and aluminum oxide abrasives are offered. Silicon carbide is sharper, cuts faster, and produces finer scratch patterns on most surfaces. Aluminum oxide is more durable and tends to last longer. It causes less discoloration on aluminum, and is more aggressive on certain applications such as hardened steel parts. Bear-TEX hand pads and rolls are also available in a non-abrasive material.

GRITS

Grit refers to the size of the abrasive grain impregnated into the nylon web. The coarser the grit, the more aggressive the cut, the rougher the finish. The finer the grit, the less aggressive the cut and the resulting surface finish will be finer, if all other conditions are equal.

GRIT DESIGNATIONS	GRIT SIZE
Coarse (C)	50 - 80
Medium (M)	100 - 150
Fine (F)	180 - 220
Very Fine (VF)	240 - 360
Ultra Fine (UF)	600
Micro Fine (MF)	800 - 1200

DENSITIES

The product "density" refers to the number of fibers which have been compressed into the nylon web material. Under identical conditions, harder density wheels cut faster, last longer and produce finer finishes than softer density wheels. Softer density wheels offer greater conformability and have less tendency to load or burn the work piece.

FIBER SIZING

Several nylon fiber sizes are used in the manufacture of Bear-TEX web material because the fiber size is a significant factor in the coating process as each produces distinct cutting characteristics.

BONDING AGENTS

Waterproof resins are used in the manufacture of Bear-TEX web material to bond the nylon fibers together and to firmly anchor the abrasive grains throughout the web.

CONVENTIONAL FINISHING METHODS VERSUS BEAR-TEX PRODUCTS

The following chart outlines the advantages achievable when using Bear-TEX products as alternatives to other cleaning, blending, deburring, and finishing methods. Bear-TEX products are listed in the sequence of normal preference for the application stated. However, because of the numerous variables, only testing can ensure selection of the most cost-effective product.

CONVENTIONAL FINISHING METHOD	KEY APPLICATION	BEAR-TEX PRODUCT AS AN ALTERNATIVE	ADVANTAGES OF BEAR-TEX PRODUCT VERSUS ALTERNATE FINISHING METHODS
Bristle Brushes	Cleaning	Clean & Finish Wheels Metal Finishing Wheels Flap Wheels	Superior cleaning performance Higher productivity No slurry or compound required More consistent finish Eliminates compound dust and flying bristles
Greaseless Compounds	Finishing	Flap Wheels Convolute Wheels Unified Wheels	Reduced maintenance No compound, instant set-up Elimination of compound dust More uniform finish More consistent work rate
Set-up Wheels	Blending/ Deburring	Convolute Wheels Unified Wheels	No break-in time required More consistent cut More uniform finish Maintains geometry Safer, no flying wheel pieces
Steel Wool	Cleaning	Rolls Discs Hand Pads	Faster, longer life Less pressure required Non-rusting, cleaner Safer, no splinters

BEAR-TEX SURFACE FINISHING PRODUCTS

GETTING THE MOST OUT OF BEAR-TEX WHEELS

Maximum wheel life and best surface conditioning results can be achieved by closely adhering to the following recommendations.

1) WHEEL DIRECTION

Convolute wheels must always run in the direction indicated by the arrow printed on the side of each wheel. Flap wheels and unified wheels can be run in either direction.

2) WHEEL SPEED

Wheel speed is an important factor in that it affects product finish, rate of cut, and wheel life. In general, fast wheel speeds give harder action and a finer finish; whereas, slower speeds give a softer action and a coarser finish for the same wheel density.

The following are recommended operating speeds for the most common applications.

APPLICATION	RECOMMENDED SPEED
Cleaning and upgrading of surface conditions	2200 to 6000 SFPM
Cut-buffing on metal surfaces	6500 to 8000 SFPM
Deburring	5500 to 8000 SFPM
Decorative finishing	500 to 3000 SFPM
Imparting decorative finishes	900 to 3000 SFPM
Oxide removal	3500 to 6500 SFPM

TESTING MAY SHOW THAT A SLOWER OR FASTER SPEED IS DESIRABLE FOR SPECIFIC OPERATIONS. NEVER EXCEED THE MAXIMUM RPM RATING OF THE WHEEL.

3) PRESSURE

Light to medium pressure is recommended for most operations. Flap wheels require much lighter pressure to perform properly than other Bear-Text wheels; whereas, unified wheels can withstand much higher pressures in order to perform deburring jobs. In all cases, avoid excessive pressure which may result in wheel deformation and damage to the work surface.

4) FEED SPEED

Feed speeds directly affect the number of pieces completed over a given period of time. Slow feed speed reduces the number of workpieces completed, while producing a shorter scratch pattern. Slow feed speed allows for longer dwell time and permits more work to be done on each piece. Conversely, a fast feed speed increases the number of workpieces completed, while producing a longer scratch pattern.

5) OSCILLATION

Oscillation may be used to break up scratch lines and produce a more uniform finish. Additionally, an increase in cut may be experienced. A general starting point for oscillation is 3/8" amplitude at 200 cycles per minute.

6) LUBRICANTS

Lubricants, such as water, water soluble oil and straight oil, will decrease the heat generated while running, improve the luster, and reduce the surface finish. The higher the viscosity of the lubricant, the lower the surface finish (RMS value) produced.

FACTORS IN WHEEL CHOICE

This chart provides a relative comparison of other Bear-Text wheel variables. It can serve as a useful guide in choosing the most suitable product for a given application. However, as many other factors affect

wheel performance, this chart can only be general in nature. The most cost-effective results can always be obtained by wheel testing on the application.

1. Wheel Conformability	MOST CONFORMABLE (SOFT) Flap Wheel	Clean & Finish	Metal Finishing	Series 1000 6 & 7 Density	Series 1000 8 & 9 Density	LEAST CONFORMABLE (HARD) B442-XHD
2. Wheel Openness	OPEN MESH	Clean & Finish	Metal Finishing	Series 1000 6 & 7 Density	Series 1000 8 & 9 Density	CLOSED MESH B442-XHD
3. Wheel Aggressiveness	MOST AGGRESSIVE	Metal Finishing	B442-XHD	Clean & Finish	Series 1000	LEAST AGGRESSIVE Flap Wheels
4. Finishing Action*	COARSER	Metal Finishing	Clean & Finish	B442-XHD	Series 1000	FLAP WHEELS FINER
5. Pressure for Best Results	LIGHTER	Flap Wheels	Clean & Finish Series 1000 6 Density	Metal Finishing Series 1000 7 Density	Series 1000 8 & 9 Density	HIGHER B442-XHD

* ON STEEL SURFACES, SILICON CARBIDE WHEELS WILL PRODUCE A BRIGHTER FINISH THAN ALUMINUM OXIDE WHEELS.

SURFACE FINISH VARIABLES

Changes in any one of many factors can affect the surface finish on the work piece. This chart shows the effect on surface finish by changes in single factors of product specifications. Arrows have been used to signify the trend direction. The arrow length does not signify that the effect of each factor is equal.

VARIABLE FACTOR	ROUGH FINISH HIGH RMS READING	SMOOTH SURFACE LOWER RMS READING
1. GRIT SIZE	COARSE	VERY FINE
2. WHEEL GRADE	SOFT	HARD
3. WHEEL SPEED	SLOW	FAST
4. FEED SPEED	FASTER (LONG SCRATCH)	SLOWER (SHORT SCRATCH)
5. OSCILLATION	NO OSCILLATION	OSCILLATION
6. LUBRICANTS and COMPOUNDS	DRY	WATER SOLUBLE OIL STRAIGHT OIL