



HERMES **AUTOMOTIVE PROGRAM**

Hermes solutions for Press & Body Shop and Paint Shop

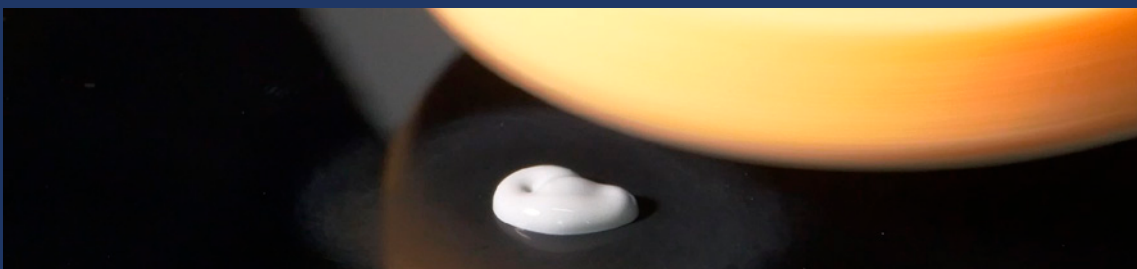


for an
excellent finish

HERMES **ONE-STOP SOLUTION FOR PRESS & BODY SHOP AND PAINT SHOP APPLICATIONS**

YOUR REQUIREMENTS IN TERMS OF
COST EFFICIENCY, SURFACE QUALITY AND A
VAILABILITY ARE CONSTANTLY INCREASING.

WE AT HERMES HAVE AN EXTENSIVE PORTFOLIO
OF ABRASIVE SOLUTIONS FOR ALL APPLICATIONS WITH
AN EXCELLENT PRICE/PERFORMANCE RATIO.



CONTENTS

PRODUCT RECOMMENDATIONS

Press & Body Shop	6
Paintshop.	12
• for Sanding Electrocoat and Primer	14
• for Topcoat Finishing	16
• for Polishing Preparation	16
• Hermes Polishing System	17

PRODUCT DESCRIPTIONS

Defect Highlighter sticks / strips	16
Film-backed abrasives	16
Cloth-backed abrasive rolls and belts	17
Abrasives with net backing	18
Foam-backed Abrasives	18
webrax non-woven web abrasives	19
Stable paper-backed abrasives	19
Paper-backed abrasives	20
Waterproof paper-backed abrasives	20
Cloth-backed abrasives	21
Abrasives with Fastlock System	21
Fiber discs	22
Abrasive sleeves	22
Flap wheels with shaft	23
Brilliance Polishing Compounds	23

PRODUCT HIGHLIGHT

Dust-free E-Coat and Primer Sanding	24
---	----

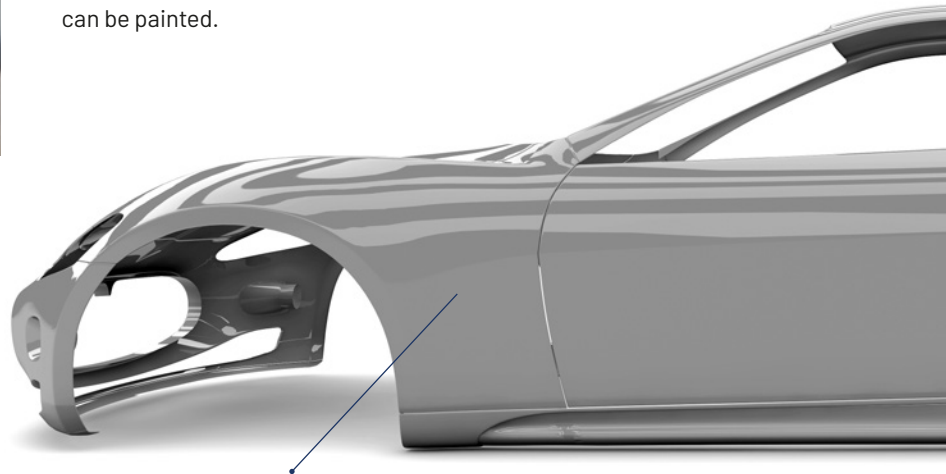
Press & Body Shop



Both production processes in bodywork manufacture and design conditions will require mechanical reworking of certain areas of bodywork as a function of vehicle model.

In this area, Hermes supplies an extensive selection of abrasives to create a surface which can be painted – everything from initial grinding to precision finishing – all to suit the enormous range of materials used.

Specific tool developments, such as HERMESIT® abrasive discs which are three-dimensional on the abrasive grain side, for example, guarantee constant surface roughness values of $R_z < 8 \mu\text{m}$ over their extended service life; such values are absolutely essential for producing a surface which can be painted.

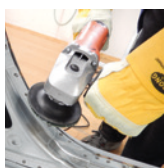


Manual defect grinding

Surface defects

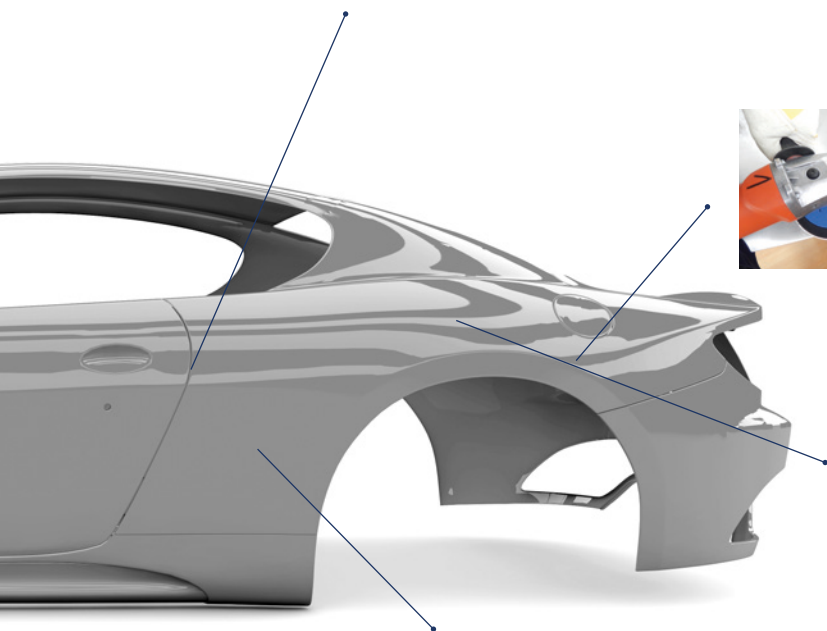
HERMES RECOMMENDATIONS FOR STEEL BODY COMPONENTS

INITIAL GRINDING FLANGES	INTERMEDIATE GRINDING	FINISH
		
VEL ceramic grain cloth disc CR 456 Z VEL Ø 125 mm, + 40	VEL ceramic grain cloth disc CR 456 Z VEL Ø 125 mm, + 80	VEL cloth disc RB 530 J VEL Ø 150 mm, P 120
 $n = 5400 \text{ min}^{-1}$	 $n = 5400 \text{ min}^{-1}$	 $n = 12000 \text{ min}^{-1}$, Orbit: $\frac{5}{16}$ ", plus backing pad MULTIHOLE, hard



Initial grinding with angle grinders

Weld spots and flanges



Initial grinding with angle grinders

Surface defects



Manual highlighting






Fault detection



Finish with random orbital sanders


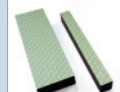






Surface defects

HERMES RECOMMENDATIONS FOR GRINDING ALUMINUM

INITIAL GRINDING BIGGER DEFECTS (OPTIONAL)	INITIAL GRINDING	FINISH	SPECIAL FINISH (OPTIONAL)
			
VEL paper disc VC 151-Longlife VEL Ø 125 mm, P 100	VEL paper disc VC 151-Longlife VEL Ø 150 mm, P 120	VEL paper disc VC 151-Longlife VEL Ø 150 mm, P 240	Net disc FineNet FN 915 VEL Ø 150 mm, + 360
 n = 6000 min ⁻¹	 n = 16000 min ⁻¹ , Orbit: 8 mm plus backing pad MULTI HOLE, hard	 n = 16000 min ⁻¹ , Orbit: 5 mm, plus backing pad MULTI HOLE, medium	 n = 16000 min ⁻¹ , Orbit: 5 mm, plus backing pad MULTI HOLE, medium





















Recommendations Press & Body Shop, Part 1

Type / Application	microlite Highlighter stick SCG 120 BU 70	microlite Highlighter stick EKW 120 BU 70	Diamond Highlighter strip DB 661SK	Sandscreen GA 924	MultiNet MN 921 VEL	webrax-OA 713 VEL	webrax-OA 708 VEL	FineNet FN 915 VEL	VC 151-Longlife VEL
	 Code 93100	 Code 93200	 Code 66105	 Code 92400	 Code 92177	 Code 71307	 Code 70807	 Code 91527	 Code 15177
















HIGHLIGHTING

Steel	+120	●●●	+120	●●	+400 (yellow)	●●●	+400	●●	P 240	●●				+240	●●●	P 180 - P 240	●
																	
Aluminum	+120	●●	+120	●●●	+800 (white)	●●●	+600	●●	P 320	●●				+360	●●●	P 240 - P 400	●●●
																	



GRINDING DEFECTS

Steel					P 240	●	+ 180	●●			+240	●	P 80 - P 150	●
														
Aluminum					P 240	●●	+180	●●	+280	●●	+360	●	P 100 - P 240	●●●
														





GRINDING FLANGES

Steel																
Aluminum																






INTERMEDIATE SURFACE GRINDING

Steel															P 80 - P 150	●
																
Aluminum															P 100 - P 240	●●●
																



SURFACE FINISHING

Steel															P 80 - P 150	●
																
Aluminum						P 240	●●●								P 100 - P 240	●●●
																

Product suitability

 highly suitable
  very suitable
  suitable




























VC 153 VEL	BW 114 VEL	CERAMIT® CR 116 VEL	RB 346 87 MX VEL	RB 480 24 YX VEL	CERAMIT® CR 456 Z VEL	HERMESIT® RB 530 J VEL	Fiber disc RB 314 fiber	Fiber disc RB 414 X- Procut	Fiber disc CERAMIT® CR 456 fiber-Procut	Fiber disc HERMESIT® RB 514 J-flex
										
Code 15307	Code 11407	Code 11627	Code 34687	Code 48027	Code 45647	Code 53067	Code 31444	Code 41450	Code 45650	Code 51441
P 180 - P 240	P 180 - P 240									
										
P 80 - P 150	P 80 - P 150									
										
			P 40 - P 60	+ 40 - + 60	+ 40 - + 60		P 36 - P 60	+ 36 - + 60	+ 36 - + 60	
										
			P 40 - P 80	+ 80	+ 40 - + 80		P 60 - P 80	+ 60, + 80		
										
P 80 - P 150	P 80 - P 150	+ 60 - + 150	P 60 - P 150	+ 80 - + 120	+ 80, + 120	P 120 - P 150	P 60 - P 120	+ 80 - + 120	+ 80, + 120	P 120 - P 150
										
				+ 120			P 120	+ 120		
										
P 80 - P 150	P 80 - P 150	+ 80 - + 150	P 60 - P 150	+ 80 - + 120	+ 80, + 120	P 120 - P 150				P 150
										

More product information on page 16 - 24



Recommendations Press & Body Shop, Part 2

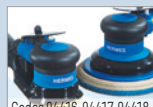
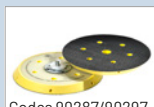
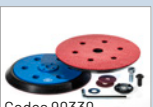
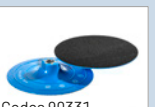


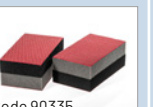

Type / Applications	Fastlock webrax-AN 704 50 Fastcut	Fastlock* webrax-AN 701 50	Fastlock* RB 486 44 Z	Fastlock* CERAMIT® CR 456 fiber Procut	Abrasive sleeves RB 346 CX	Flap wheels with shaft FW 340 X			
		 Code 70150	 Code 48644	 Code 45650	 Code 34662	 Code 34000			
 GRINDING FLANGES									
Steel			+ 36, + 50 - + 80	•	+ 36, + 80	• •			
									
Aluminum			+ 80	• •	+ 80	• •			
									
 INTERMEDIATE SURFACE GRINDING									
Steel	+ 80	• • •	+ 80, + 100	• • •	+ 50 - + 80	• •	+ 80	• • •	
									
Aluminum	+ 80	• •	+ 100, + 280	• •	+ 80	• •	+ 80	•	
									
 INTERMEDIATE SURFACE GRINDING									
Steel						P 50 - P 80	• •	P 60 - P 80	• •
									
Aluminum						P 80 - P 150	•	P 80 - P 120	•
									

* Fastlock = with Fastlock System More product information on page 16 - 24

Product suitability

• • • highly suitable • • very suitable • suitable

HERMES ACCESSORIES FOR ABRASIVES FOR PRESS & BODY SHOP

Grinding machines	Backing pads and accessories for discs			Backing pads for fiber discs	Handblocks for strips		
Random orbital sanders	VEL-Backing pad FJ for random orbital sander	VEL-Backing pad J/X for angle grinder	VEL-Handpad with loop	Backing pads for angle grinder	VEL-Combi block with a hard and soft side	VEL-Handblocks with lateral recessed grips	
 Codes 94416, 94417, 94418	 Codes 90287/90297	 Codes 90330	 Codes 90331	 Code 90339	 Codes 90329, 90331, 90330	 Code 90335	 Code 90336

Accessories for discs with Fastlock System	Accessories for abrasive sleeves	Accessories for Diamond Highlighting Stick
Backing pads, spindles, adapter	Rubber mandrels	SK-Block
 Codes 90030, 90288, 90289, 90297, 90303	 Code 90340	 Code 90347

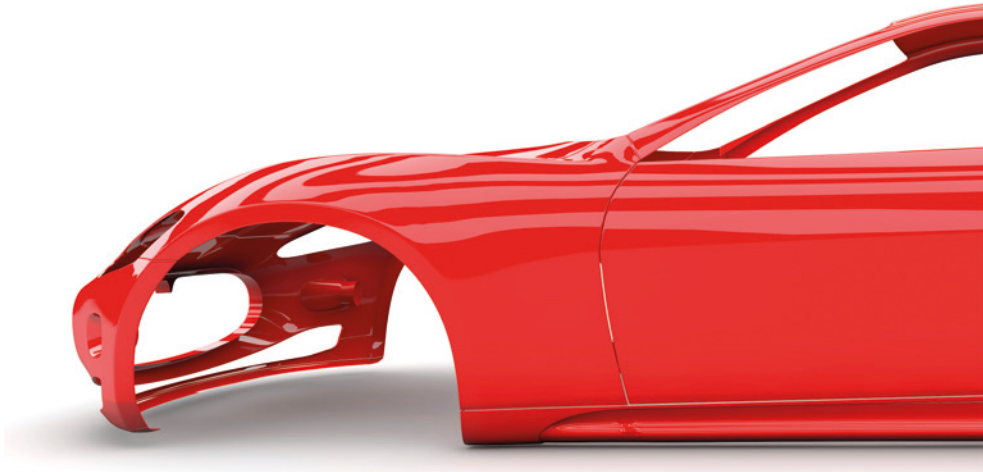


Paintshop



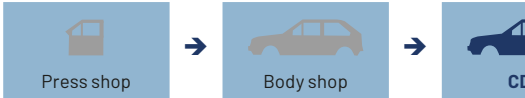
The “exterior” of any vehicle is determined by a perfect, blemish-free painted surface. Even modern paint systems still require steps following filling, priming and top-coating in order to eliminate any paint blemishes or to prepare surfaces for a subsequent coating step.

Hermes supplies a large selection of abrasives to suit the painting materials and the method required up to and including the Hermes polishing system. Modern tool systems such as the MULTIHOLE system, for example, take account of the requirement for dust-free grinding as well as for improved tool lives.

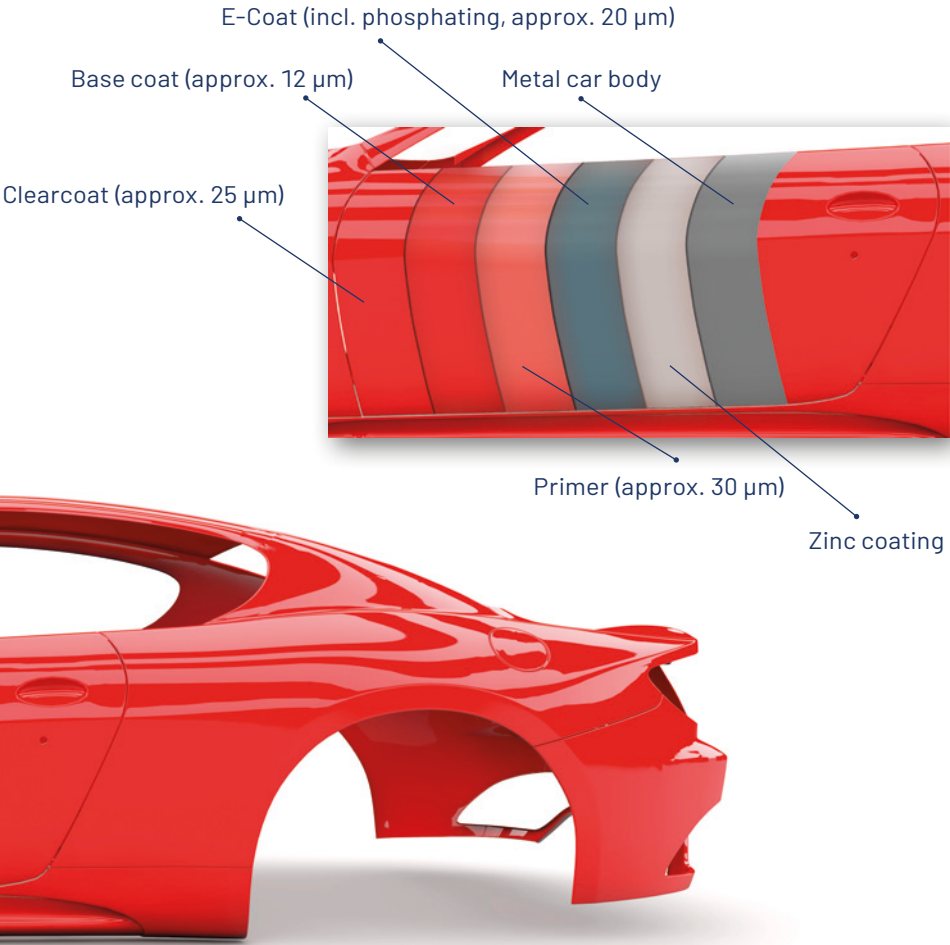


HERMES RECOMMENDATIONS FOR SANDING E-COAT



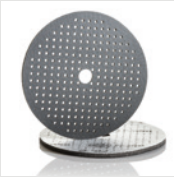


MACHINE SANDING		MANUAL SANDING	
VEL paper disc VC 154-Longlife VEL Ø 150 mm, P 240		Foam-based strips VC 154-Longlife FOAM 115 x 125 mm, P 400	
 n = 12000 U/min, Orbit: 5 mm, plus backing pad MULTIHOLE, soft		 	



EXEMPLARY CAR LACQUER LAYER STRUCTURE











HERMES RECOMMENDATIONS FOR SANDING PRIMER






















MACHINE SANDING		MANUAL SANDING	
			
VEL paper disc BRILLIANCE FC 164-Longlife VEL Ø 125 mm, P 600		Waterproof paper disc WA flex 28 B Ø 125 mm, P 800	
 n = 12000 U/min, Orbit: 5 mm, plus backing pad MULTIHOLE, soft			
			





















Recommendations for Sanding E-Coat and Primer

Type / Applications	Sandscreen GA 924	Sandscreen GA 924 VEL	MultiNet MN 921 VEL	BRILLIANCE FC 164-Longlife VEL	VC 151-Longlife VEL incl. MULTIHOLE	VC 154-Longlife	VC 154-Longlife FOAM	VC 154-Longlife VEL incl. MULTIHOLE	
	 Code 92400	 Code 92407	 Code 92177	 Code 16477	 Codes 15177/15179	 Code 15470	 Code 15478	 Codes 15477/15479	

SANDING ELECTROCOAT



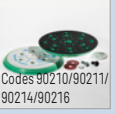







 Manual	+ 400 / + 500	••	+ 400	••	P 400 - P 500	•••	P 320 - P 500	•••	P 320 - P 500	••	P 400 / P 500	••	P 320 - P 400	••	P 320 - P 500	••	P 320 - P 500
																	
 By Machine					P 320 - P 500	•••	P 240 - P 400	•••	P 240 - P 400	••				P 240 - P 400	•••	P 240 - P 400	••
																	



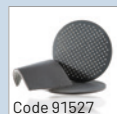














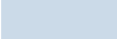
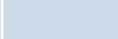




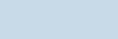
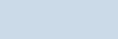
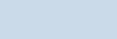

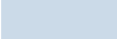
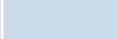
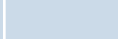









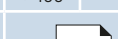



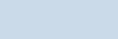
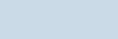
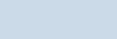
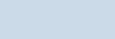
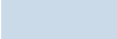

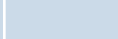
SANDING PRIMER

 Manual				P 800	•••	P 800	•••			P 800	••	P 800	••	P 800	••	P 800	••
																	
 By Machine				P 500 - P 600	•••	P 400 - P 600	•••	P 400 / P 500	••					P 400 - P 600	•••	P 400 - P 600	••
																	

Product suitability ••• highly suitable •• very suitable • suitable

HERMES ACCESSORIES

Grinding machines	Backing pads and accessories for discs							Handblocks for strips	
Random orbital sander	VEL-Backing pad FJ	VEL-Backing MULTIHOLE hard, medium, soft, super soft	VEL-Soft Pad MULTIHOLE	VEL-Soft Pad	Multiflow-Pad	VEL-Handpad with loop	VEL/SK Disc holder with water storage	VEL-Combi block with a hard and soft side	VEL-Handblock with lateral recessed grips
 Codes 94416, 94417, 94418	 Codes 90287/90297	 Codes 90210/90211/90214/90216	 Code 90311	 Code 90311	 Code 90318	 Code 90339	 Codes 90373, 90346	 Code 90335	 Code 90336

VC 154- longlife SK	WS flex 16 VEL incl. MULTIHOLE	FineNet FN 915 VEL incl. MULTIHOLE	WS flex 16	WA flex 28 B	webrax- OA 708	webrax- OA 708 VEL	webrax- OS 709	webrax- OS 709 VEL	Sanding sponge Medium, single-sided								
 Code 15475	 Codes 61607/61609	 Code 91527	 Code 61601	 Code 62820	 Code 70800	 Code 70807	 Code 70900	 Code 70907	 Code 90358								
20 - 600	••	P 400 / P 600	•	+ 360 - + 500	•••	P 320 / P 500	•	P 400, P 500	••	+ 280	•	+ 280	•			+ 180 - + 220	•
																	
40 - 600	•••	P 400 / P 600	•	+ 240 - + 500	•••					+ 280	••						
																	
600	••	P 800	•	+ 800, + 1000	•••	P 800 / P 1000	••	P 800, P 1000	•••			+ 1500	••	+ 1500	••	+ 280 - + 400	•
																	
600 - 1000	•••	P 400 / P 600	•	+ 500, + 600	•••								+ 1500	•			
																	

More product information on page 16 - 24

GRIT SIZE COMPARISON


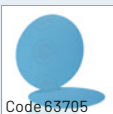























FineNet and Sanding sponges						
Conventional abrasives	Hermes FineNet	Main competitor product	Hermes Sanding sponges	Competitive Sanding sponges		
180	-	180	100	medium		
220	240					
240						
280						
320			180/360	180	fine	
360	240/360	360				
400	360		220			extra fine
500						
600	500			500	280	
800	500/600					
1000	600/800	500/600				
1200	800/1000	600/1000				
1500	1000	1000	400	ultra fine		
2000		1000/2000				

Differing product designs make direct grit size comparisons impossible.

webrax non-woven web	
Description	Standard Hermes
coarse	+ 80
medium	+ 100, + 120
fine	+ 180
very fine	+ 220, + 280, + 360
super fine	+ 500
ultra fine	+ 800, + 1500



Recommendations for Topcoat Finishing

Type / Application	VC 154-Longlife VEL incl. MULTIHOLE	FB 637 SK	FineNet FN 915 VEL incl. MULTIHOLE	webrax-OS 709	webrax-OS 709 VEL					
	 Codes 15477/15479	 Code 63705	 Codes 91527/91529	 Code 70900	 Code 70907					
TOPCOAT-GRINDING DEFECTS										
 Manual	P 1000		P 2500		+ 1000		+ 1500		+ 1500	
										
 By Machine	P 800 - P 1500		P 2500		+ 800 - + 1000				+ 1500	
										

More product information on page 16 - 24

Recommendations for Polishing Preparation








Type / Application	WS flex 16 VEL incl. MULTIHOLE	WS flex 16	WS flex 16 SK 302				
							
<div>Codes 61607/61609</div> <div>Code 61601</div> <div>Code 61608</div> <div>DECKLACK-FEHLERSCHLIFF</div>							
 Manual	P 2000 - + 5000	••	P 2000 - + 5000	••	+ 2500 - + 5000	•••	
	 						
 By Machine	P 2000 - + 5000	••			+ 2500 - + 5000	•••	
	 						

More product information on page 16 - 24

HERMES ACCESSORIES





Grinding machines	Backing pads and accessories for discs				
Random orbital sanders	VEL-Backing pad FJ	VEL- Backing pad MULTIHOLE hard, medium, soft, super soft	VEL- Soft Pad MULTIHOLE	VEL- Soft Pad	VEL-Handpad with loop
 Codes 94416, 94417, 94418	 Codes 90287/90297	 Codes 90210/90211/90214/90216	 Code 90311	 Code 90311	 Code 90339

Hermes Polishing System

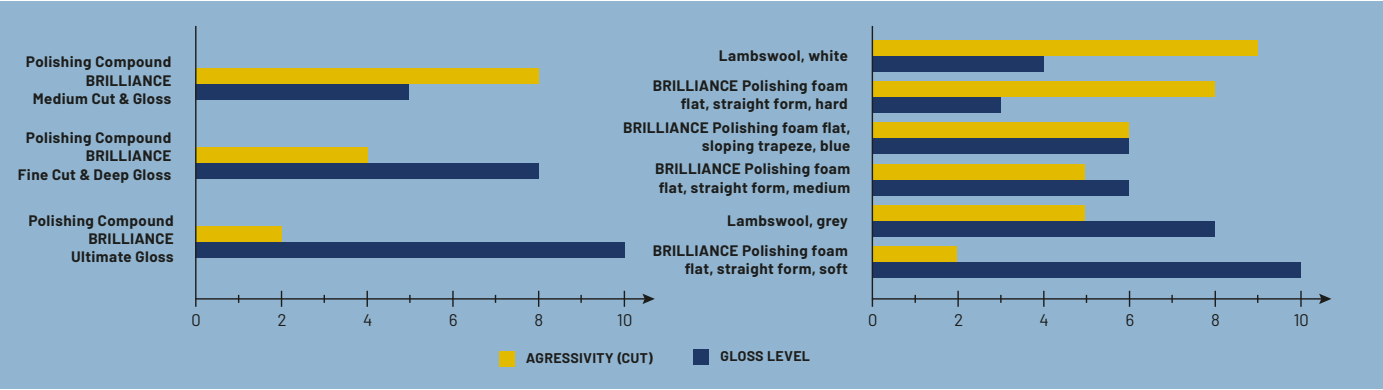
 <p>Code 90471</p> <p>BRILLIANCE Medium Cut & Gloss Polishing compound, silicone-free</p>		 <p>Code 90472</p> <p>BRILLIANCE Fine Cut & Deep Gloss 1-step Polishing compound, silicone-free</p>		 <p>Code 90473</p> <p>BRILLIANCE Ultimate Gloss Anti-Hologram Polishing compound, silicone-free</p>	
 <p>Code 61608 + 2500</p>		 <p>Code 61608 + 3000 / + 5000</p>		<p>-</p>	
					
					
<p>Orbit: 12-15 mm</p>		<p>Orbit: 12-15 mm</p>		<p>Orbit: 12-15 mm</p>	
 <p>Code 90397</p>	 <p>Code 91030</p>	 <p>Code 90397</p>	 <p>Code 91030/91059</p>	 <p>Code 91032</p>	 <p>Code 90399</p>
					 <p>Code 91030/91059</p>

More product information on page 16 - 24



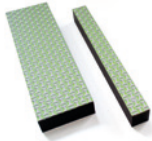
HERMES ACCESSORIES FOR HERMES POLISHING SYSTEM



Backing pads and accessories for discs			
Accessories for rosette discs	Rosette disc wet applicator	Backing pads for Hermes Polishing-System	BRILLIANCE Microfiber Polishing Cloth Pro
 <p>Codes 90345/ 90286/ 90285/90306</p>	 <p>Code 90373</p>	 <p>Codes 90314, 90320</p>	 <p>Code 90062 400 x 400 mm</p>

CUT/GLOSS VALUE COMPARISON



Product Descriptions

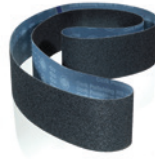
DEFECT HIGHLIGHTER STICKS / STRIPS			
			
	microlite Defect Highlighter stick SCG 120 BU 70 (code 93100)	microlite Highlighter stick EKW 120 BU 70 (code 93200)	Diamond Highlighter strip DB 661SK
Product Benefits	<p>Longer tool life in comparison to vitrified-bonded highlighting sticks</p> <p>No smearing</p> <p>No scratches, especially in the edge and radius area</p> <p>No shattering when dropped</p>	<p>Especially suitable for aluminum</p> <p>Longer tool life in comparison to vitrified-bonded highlighting sticks</p> <p>No smearing</p> <p>No scratches, especially in the edge and radius area</p> <p>No shattering when dropped</p>	<p>Longer tool life in comparison to vitrified-bonded highlighting sticks</p> <p>Low clogging characteristics</p> <p>No scratches, especially in the edge and radius area</p> <p>No shattering when dropped</p>
Abrasive grain	Silicon carbide	Aluminum oxide	Diamond
Bonding	Polyurethane	Polyurethane	Resin
Grit range	F 80 ... F 150 Recommendation: F 120	F 80 ... F 150 Recommendation: F 120	400/800

FILM-BACKED ABRASIVES		
		
	BRILLIANCE FC 164-Longlife VEL (Code 16477)	FB 637 (Code 63700)
Product Benefits	<p>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</p> <p>The semi-open coating and the optimized longlife coating prevent premature clogging and thus guarantee a long life</p> <p>In addition, semi-open coating provides constant removal rates</p> <p>High flatness ensures good running properties and safe automated wheel replacement on robot grinding systems</p> <p>For quick identification, the grit size can be read on the grain side</p> <p>The Brilliance recipe meets the latest requirements of the automotive industry for grinding tools for use on aluminum surfaces</p>	<p>The highly tear-resistant and even polyester film guarantees constant parameters of application during precision grinding operations</p> <p>Closer ranges of tolerance in the coefficients of surface roughness benefit precision grinding, due to compression resistance backing</p> <p>An excellent grain sharpness with bond strength leads to high abrasion of material</p> <p>High-performance</p> <p>Reduced cycle times</p> <p>Oil and emulsion resistant</p>
Abrasive grain	Aluminum oxide	Aluminum oxide
Bonding	Resin, grey, with additives	Resin, blue
Backing	Film, velour-backed	Film
Coating	Semi-open	Closed
Grit range	P 240, P 320, P 400 - P 2000	P 120, P 180, P 240, P 280, P 360 - P 1500, P 2500, + 4000

CLOTH-BACKED ABRASIVE ROLLS AND BELTS



RB 346 MJ (code 34602)



Cork RB 515 X (code 51522)



MERCURIT® RB 598 Y (code 59830)

Product Benefits

Synthetic resin bond ensures excellent grit adhesion
Light, flexible cloth backing for grinding contoured workpieces
Universally suitable

Long tool life
Produces an outstanding fine-structured pattern due to cork particles

Increased efficiency and productivity in comparison to conventional grinding belts due to 3 to 5 times longer tool life (reduced stoppages for belt replacement and machine downtimes, and saving costs on the disposal of used belts)
High process stability due to constant roughness values and stock removal rates throughout the entire period of use

Abrasive grain

Aluminum oxide

Silicon carbide + Cork

MERCURIT® Silicon carbide (Agglomerate)

Bonding

Resin, red-brown

Resin, black

Resin, black

Backing

J-cloth

X-cloth

Y-cloth

Coating

Closed

Closed

Closed

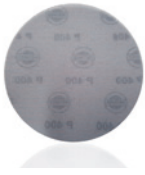

Grit range



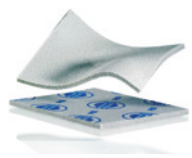
P 60 - P 800

P 150, P 220, P 280, P 400, P 600 - P 1000

P 240, P 320, P 400, P 600 - P 1200

Product Descriptions

ABRASIVES WITH NET BACKING	 	
	MultiNet MN 921 VEL (Code 92177)	GA 92400 / GA 92407 VEL (codes 92400/92407)
Product Benefits	<p>Significantly lower clogging improves surface quality and increases tool life</p> <p>The all-over dust extraction through the MultiNet network structure extends the tool life and improves the working environment.</p> <p>The dust-free and visible working surface enables a quick and exact control of the working result during sanding.</p> <p>Depending on the application at least double service life compared to conventional discs</p> <p>High tear resistance and edge stability</p> <p>Easy disc change as no hole pattern is to be observed</p>	<p>Open mesh structure means no loading and a reduction in dust</p> <p>Long tool life</p> <p>Plain backed discs can be used on both sides</p>
Abrasive grain	not specified	Aluminum oxide
Bonding	Resin, grey	Resin, brown
Backing	Abrasive net, velour-backed	Sandscreen / Sandscreen, velour-backed
Coating	not specified	Open
Grit range	P 240, P 320, P 400 - P 800	+ 400 to + 1000 / + 400, + 600

FOAM-BACKED ABRASIVES	  		
	FineNet FN 915 VEL (code 91527)	VC 154-Longlife Foam (code 15478)	Sanding sponge medium, single-sided (code 90358)
Product Benefits	<p>Abrasive adapts perfectly to contours and very tight radii</p> <p>Minimal loading and the potential to clean the used abrasive results in extended tool life</p> <p>Generates very fine surfaces with consistent surface roughness</p> <p>Dust-free sanding with minimal rework on surfaces</p> <p>Extremely versatile – wet and dry on random orbital sanders or with hand sanding.</p> <p>Pressure-equalizing foam layer facilitates "gentle" sanding and reduces the risk of sanding through surface coatings</p>	<p>For intermediate and fine sanding of primer and filler</p> <p>Additional coating prevents loading with sanding dust</p> <p>Adapts very well to contours due to the soft foam backing</p>	<p>Medium degree of flexibility</p> <p>Adapts very well to shape and small radii</p> <p>Very fine patterned surfaces with constant roughness values</p> <p>Pressure-equalizing foam layer facilitates "gentle" sanding and reduces the risk of sanding through surface coatings</p> <p>Sanding before applying primer in grit range 60 to 180</p> <p>Dry final sanding with grit sizes 220 to 600</p> <p>Universal use</p>
Abrasive grain	Silicon carbide	Aluminum oxide	Aluminum oxide
Bonding	Resin, grey	Resin, Prolub*, pink	Resin, light grey
Backing	Foam- and velour-backed net	C-weight paper, foam-backed	Hard and dense PU foam
Coating	Closed	Semi-open	not specified
Grit range	+ 240, + 360, + 500 to + 1000	P 150, P 180, P 240 - P 320, P 400 - P 800	P 60, P 100, P 150 - P 220, P 280, P 400, P 600

WEBRAX NON-WOVEN WEB ABRASIVES



webrax-OA 708
(code 70800)



webrax-OA 708 VEL
(code 70807)



webrax-OS 709
(code 70900)



webrax-OS 709 VEL
(code 70907)



webrax-OA 713 VEL
(code 71307)

Product Benefits

Highly flexible, deformable, three-dimensional non-woven web
No clogging due to open structure
Optimum product structure for hand-sanding

Highly flexible, deformable, three-dimensional non-woven web
No clogging due to open structure
Especially suitable for cleaning and roughening (body shop & electrocoat)

Highly flexible, deformable, three-dimensional non-woven web
Optimum product structure for hand-sanding

Highly flexible, deformable, three-dimensional non-woven web
No clogging due to open structure
Especially suitable for cleaning and roughening primer

Highly-compressed non-woven web with increased grit density
High strength and density of non-woven web fibers for more aggressive applications

Abrasive grain

Aluminum oxide

Aluminum oxide

Silicon carbide

Aluminum oxide

Aluminum oxide

Bonding

Resin, red-brown

Resin, red-brown

Resin, grey

Resin, grey

Resin, light brown

Backing

Non-woven web

Non-woven web, velour-backed

Non-woven web

Non-woven web, velour-backed

Non-woven web, high-density

Coating

Open

Open

Open

Open

Open

Grit range

+ 120, + 180, + 280, + 360

+ 280

+ 180, + 280, + 500, + 800, + 1500

+ 1500

+ 180

STABLE PAPER-BACKED ABRASIVES



BW 114 VEL
(code 11407)



CERAMIT® CR 116 VEL
(code 11627)



VC 153 VEL
(code 15307)

Product Benefits

Less loading characteristics
Open coating reduces loading with sanding dust, especially with resinous materials (zinc, oil)
Stable, tear-resistant F-weight paper backing with good edge stability increases work safety

High stock removal rates especially on stainless steel and high-alloyed steel
Very long tool life on composites materials
Low grinding temperatures due to additional additives
Uniform surface finish

Premium product with very long tool life
Sharp aluminum oxide abrasive grain
Suitable for low pressure applications
Strong paper backing with good edge stability
Especially suitable for finishing steel sheets
Universally applicable

Abrasive grain

Aluminum oxide

Ceramic

Aluminum oxide

Bonding

Resin, black

Resin, green

Resin, red-brown

Backing

F-weight paper, velour-backed

F-weight paper, velour-backed

E-weight paper, velour-backed

Coating

Closed

Closed

Closed

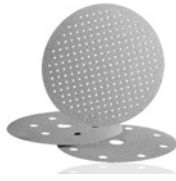



Grit range



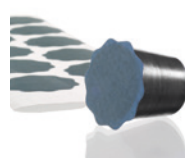
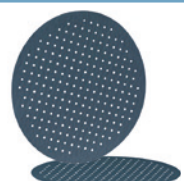
P 60 - P 150

+ 60 to + 180

P 24, P 36 - P 220

Product Descriptions

PAPER-BACKED ABRASIVES				
	VC 151-Longlife VEL (code 15177)	VC 154-Longlife (code 15470)	VC 154-Longlife SK (code 15475)	VC 154-Longlife VEL (code 15477)
Product Benefits	Low clogging with sanding dust due to semi-open coating and additional coating Highly aggressive For intermediate and final sanding primer and filler Especially suitable for sanding aluminum	Premium product sanding lacquer Long tool life and high stock removal rates due to sharp aluminum oxide abrasives grain 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 Especially suitable for intermediate sanding lacquer	Premium product sanding lacquer Long tool life and high stock removal rates due to sharp aluminum oxide grain Flexible, wear-resistant latex paper backing assures very good adaptations to contours Low clogging with sanding dust due to semi-open grain coating and additional coatings Good surface qualities when intermediate sanding lacquer Especially suitable for finishing filler and lacquer on random orbital sanders	
Abrasive grain	Aluminum oxide	Aluminum oxide	Aluminum oxide	
Bonding	Resin, with additives, white	Resin, Prolub*, pink	Resin, Prolub*, pink	
Backing	C-weight paper, velour-backed	C-weight paper	C-weight paper, self-stick	B-weight paper, velour-backed
Coating	Open	Semi-open	Semi-open	
Grit range	P 60 - P 240, P 320 - P 500	P 80 - P 1200	P 80 - P 240, P 320 - P 400, P 600, P 800, P 1200	P 80 - P 1500

WATERPROOF PAPER-BACKED ABRASIVES				
	WA flex 28 B (code 62820)	WS flex 16 (code 61601)	WS flex 16 SK 302 (code 61608)	WS flex 16 VEL (code 61607)
Product Benefits	Highly flexible waterproof latex paper backing Especially suitable for primer and lacquered surfaces as well as for pre-sanding before lacquering Can be used wet or dry	Highly flexible waterproof latex paper backing adapts very well to contours Especially suitable for sanding scratch-resistant lacquer due to hard silicon carbide Can be used wet or dry	Highly flexible waterproof latex paper backing Especially suitable for scratch-resistant lacquer due to hard silicon carbide Especially suitable for topcoat defects	Highly flexible waterproof latex paper backing adapts very well to contours Especially suitable scratch-resistant lacquer due to hard silicon carbide Especially suitable for topcoat defects Can be used wet or dry
Abrasive grain	Aluminum oxide	Silicon carbide	Silicon carbide	Silicon carbide
Bonding	Resin, brown	Resin, grey-blue	Resin, grey-blue	Resin, grey-blue
Backing	B-weight paper, waterproof	B-weight paper, waterproof	B-weight paper, waterproof	B-weight paper, waterproof
Coating	Closed	Closed	Closed	Closed
Grit range	P 400 - P 800, P 1200	P 60 - P 2000, + 2500, + 3000, + 5000	P 1200, + 2500, + 3000, + 5000	P 60, P 400 - P 1200, P 2000, + 2500, + 3000, + 5000

CLOTH-BACKED ABRASIVES



RB 346 87 MX VEL
(code 34687)



RB 480 24 YX VEL
(code 48027)



CERAMIT® CR 456 Z VEL
(code 45647)



HERMESIT® RB 530 J VEL
(code 53067)

Product Benefits

Synthetic resin bond ensures excellent grit adhesion
Self sharpening ceramic ensures longer tool life
High tear-resistant X-cloth increases safety when grinding

High stock removal rates and long tool life due to tough zirconia alumina abrasive grain

Highly economical due to low overall grinding costs
Tough and sharp ceramic grain provides high stock removal rates and long tool life
Low grinding temperatures due to the additional Procut* coating
Highly tear-resistant and waterproof polyester backing with low elongation provides high disc stability

Increased efficiency and productivity in comparison to conventional grinding belts due to 3 to 5 times longer tool life
High process stability due to constant roughness values and stock removal rates throughout the entire period of use
Especially suitable for low grinding pressure

Abrasive grain

Ceramic / Aluminum oxide

Zirconia alumina

Ceramic

HERMESIT® Aluminum oxide (coated carrier sphere)

Bonding

Resin, red-brown

Resin, blue

Resin, Procut*, green

Resin, brown

Backing

X-cloth

YX-cloth

Z-cloth

J-cloth

Coating

Closed

Closed

Closed

Special

Grit range

P 40, P 60 - P 180, P 240

+ 40, + 60 to + 120

+ 40, + 60, + 80, + 120

P 120, P 150, P 180

ABRASIVES WITH FASTLOCK SYSTEM



webrax-AN 704 50 Fastcut
(code 70450)



webrax-AN 701 50
(code 70150)



RB 486 44 Z
(code 48644)



CERAMIT® CR 456 fiber-Procut
(code 45650)

Product Benefits

Very compact, aggressive non-woven web material
Extremely tough abrasive grain provides consistent grinding performance, throughout its life time
Fabric reinforcement increases working safety
Can be used universally dry and wet (resistant to water, emulsion and oil)

Compact construction means aggressive grinding
Less loading with sanding dust and much finer surfaces compared to conventional discs
Outstanding velcro characteristic using the special VEL-Backing pad-X
No grinding through when grinding body parts
Reinforced cloth backing increases work safety

Zirconia alumina grit ensures high stock removal rates
Procut* coating means cool grinding

High stock removal rates and high economic efficiency due to high-performance ceramic grain
Low grinding temperatures due to additional Procut* coating
Especially suitable for grinding high-alloyed steel
Very stiff and stable fiber backing

Abrasive grain

Aluminum oxide

Aluminum oxide/
Silicon carbide

Zirconia alumina

Ceramic

Bonding

Resin, red-brown

Resin, brown

Resin, Procut*, blue

Resin, Procut*, green

Backing

Non-woven web, reinforced with cloth

Non-woven web, reinforced with cloth

Z-cloth

X-Fiber

Coating

not specified

not specified

Closed

Closed

Grit range

+ 80





+ 80, + 100, + 280

+ 36, + 60, + 80


+ 36, + 50 to + 80, + 120


* Procut = Size coat with active additives


Product Descriptions

FIBER DISCS				
	RB 314 fiber (code 31444)	RB 414 X-Procut (code 41450)	CERAMIT® CR 456 fiber- Procut (code 45650)	HERMESIT® RB 514 J-flex (code 51441)
Product Benefits	Long tool life achieved by using a tough aluminum oxide grain and closed coating Universal applications in the bodyshop For grinding carbon steels, aluminum and non-ferrous metal alloys	High stock removal rates due to Zirconia alumina abrasive grain Additional Procut* coating for cool grinding Especially suitable for grinding flanges and welded seams	Long tool life due to high-performance ceramic grain increases economic efficiency Additional Procut* coating means low grinding temperatures Especially suitable for grinding high-alloyed steel	Increased efficiency and productivity in comparison to conventional grinding discs due to 3 to 5 times longer tool life (reduced stoppages for disc replacement and machine downtimes and saving costs on the disposal of used discs) High process stability due to constant roughness values and stock removal rates throughout the entire period of use Especially suitable for applications with low grinding pressure High work safety due to vulcanized fiber backing
Abrasive grain	Aluminum oxide	Zirconia alumina	Ceramic	HERMESIT® Aluminum oxide (coated carrier sphere)
Bonding	Resin, red-brown	Resin, blue	Resin, Procut*, green	Resin, brown
Backing	X-Fiber	X-Fiber	Vulcanized fiber	Vulcanized fiber
Coating	Closed	Closed	Closed	Closed
Grit range	P 16, P 24, P 36 - P 120	+ 36 to + 120	+36, + 50 to + 120	P 120, P 150

* Procut = Size coat with active additives

ABRASIVE SLEEVES	
	RB 346 CX (code 34662)
Product Benefits	Grinding areas which are hard to reach Use on portable straight grinders for grinding welded seams and deburring bores and cut-outs
Abrasive grain	Aluminum oxide
Bonding	Resin, red-brown
Backing	X-cloth
Coating	Closed
Grit range	P 24, P 36 - P 180, P 240, P 320

FLAP WHEELS WITH SHAFT		
	FW 340 X (code 34000)	
Product Benefits	High degree of grit sharpness and high stock removal rates Flexibility of the fan-shaped cloth flaps allows great adaptability Universally applicable	
Abrasive grain	Aluminum oxide	
Bonding	Resin, red-brown	
Backing	X-cloth	
Coating	Closed	
Grit range	P 40, P 60 - P 120, P 320	

BRILLIANCE POLISHING COMPOUNDS			
	BRILLIANCE Medium Cut & Gloss Schleifpolitur, silikonfrei	BRILLIANCE Fine Cut & Deep Gloss One-Step Polishing Compound, silicone-free	BRILLIANCE Ultimate Gloss Antihologram Polishing Compound, silicone-free
Degree of Cut & Gloss	Cut 8 ●●●●●●●● Gloss 5 ●●●●●●●●	Cut 4 ●●●●●●●● Gloss 8 ●●●●●●●●	Cut 2 ●●●●●●●● Gloss 10 ●●●●●●●●
Product Benefits	High degree of cut with a good degree of gloss Low dust and spray development Even with longer polishing this polishing compound does not burn in Can be easily removed with a cloth wipe Universally applicable for soft and scratch-resistant lacquer	One-Step Polishing Compound - Best results with only one product Allows for a very fast working process Universally applicable on all types of soft and scratch-resistant lacquers	Produces a brilliant and durable high gloss finish, even on dark and difficult colors Removes holograms as well as fine scratches and grinding marks with grit size 5000 No scent Universally applicable on soft and scratch-resistant lacquer
Applications	For effective eliminating of scratches, overspray and sanding with grit size 2500 and finer Applicable for using random orbital sander in combination with a hard and medium polishing foam Better results by an additional polishing step with Hermes Antihologram Polishing Compound BRILLIANCE Ultimate Gloss	For the hologram-free removal of sanding processes with grit size 3000 and finer, as well as for the removal of sanding marks and holograms of previous polishing steps Applicable for using random orbital sander in combination with a medium polishing foam	Removing holograms as well as fine scratches and grinding marks with grit size 5000 Applicable for using random orbital sander in combination with a medium soft polishing foam
General Notes	Check for suitability and compatibility before use Do not use on hot surfaces Protect from frost and excessive heat		
Delivery Form	Available as 5 liter canister as well as 1 liter or 250 ml bottle		

E-Coat and Primer Sanding with Hermes

DUST-FREE SANDING IN THE PAINT SHOP ACCORDING TO YOUR NEEDS

Hermes grinding solutions set standards
in economy and surface quality

OUR PRODUCT RECOMMENDATIONS

for perfekt preparation for subsequent lacquering processes



MULTINET MN 921 VEL

Durable with tear-resistant edge
aluminum oxide mesh disc



FINENET FN 915 VEL MULTIHOLE

Foam coated, very flexible and soft
mesh cloth disc with MULTIHOLE system



VC 154-Longlife VEL MULTIHOLE

Flexible and wear-resistant latex paper
disc with MULTIHOLE system

DUST-FREE

Stock removal

Flexibility

Dust-free

Stock removal

FLEXIBILITY

Dust-free

STOCK REMOVAL

Flexibility

PRODUCT BENEFITS

- **Long service life** of the discs
- **Optimal working conditions** for use in paint booths due to total dust-free sanding
- **Fast and complete control** of the sanding result
- **Universally applicable** - both on random orbital sanders or in hand sanding
- **High edge stability**
- **Easy disc change**, because no hole pattern has to be aligned

PRODUCT BENEFITS

- **Optimal adaptation** to contours and very tight radii
- **Long service life** due to low clogging behavior and possible cleaning
- **Very fine surfaces** with **uniform roughness depths**
- **Reduces production time**, post process
- **Extremely universally applicable** - both on random orbital sanders or in hand sanding as well as dry and wet
- **„Soft“ sanding** due to pressure compensating foam
- **Multi-change possible**

PRODUCT BENEFITS

- **Longer service life** compared to discs with conventional extraction hole system or with a net-like structure
- **Very good surface quality**
- **Low sanding temperatures**
- **High sanding performance** reduces sanding times and increases the productivity
- **Universal use** of Hermes MULTIHOLE abrasives possible on all conventional backing pads with extraction holes



INTERESTING ADDITIONAL PRODUCTS AND INFORMATION

SUPPLEMENTARY TYPE



VC 151-Longlife VEL MULTIHOLE

High performance abrasive disc with MULTIHOLE system and anti clogging coating

PRODUCT BENEFITS

- Due to open grain coating and additional effective coating **especially suitable** for materials that tend to dust and clog during sanding and clogging such as primer and filler
- **Very high stock removal**
- In a competitive comparison, **use of the next finer grit possible** without loss of service life as with coarser grits

ACCESSORIES



VEL Backing pad MULTIHOLE

VEL Backing pad with MULTIHOLE system in 4 hardness variants

PRODUCT BENEFITS

- In combination with MULTIHOLE discs, **optimum dust extraction** with even lower clogging behavior
- Delivery program with **4 hardness grades (hard, medium, soft, super soft)** creates solutions for all applications
- **Low vibration** due to dynamic balancing
- **Long service life** due to high edge stability



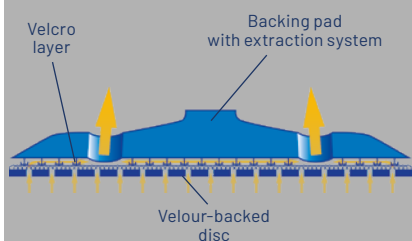
Multiflow-Pad

Backing pad adapter for MULTIHOLE discs

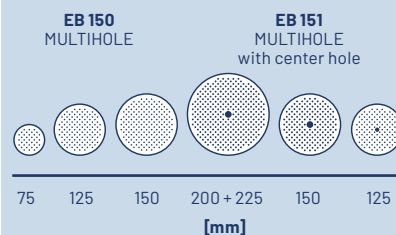
PRODUCT BENEFITS

- Open 2-channel structure ensures **full-surface dust extraction**
- **Universally applicable** on any velcro backing pad with extraction system
- **Especially suitable** for dust-intensive materials
- **Faster disc changes**, as no hole alignment is required
- **Additional support pad protection**

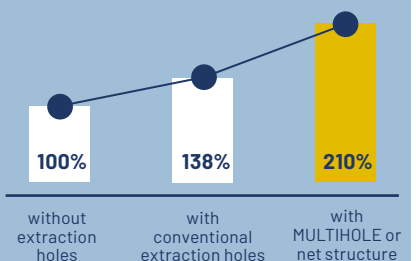
MULTIHOLE PRINCIPLE



Ø OVERVIEW MULTIHOLE



BENCHMARK





SEAM THE SUSTAINABILITY INITIATIVE

At Hermes, the topics of environmental protection and corporate responsibility have always shaped business policy. Today, we consider them more important than ever. This is why Hermes is a founding member of SEAM (Sustainable European Abrasive Manufacturers), the sustainability project of the European Abrasives Association. Within this framework, Hermes is continuously developing its sustainability standards in the three core areas of environment, society and economy. Further information on SEAM is available at www.seam.earth.



H.A.I. THE OPTIMIZATION INITIATIVE

Within the framework of the Hermes Abrasives Institute, we offer you optimization programmes that provide a customer-oriented combination of consulting services and individual training content.

This ranges from abrasives manuals, grinding process optimization and lean consulting to individual training so that theory becomes excellent practice.



HERMES **YOUR PARTNER AND EXPERT FOR EXCELLENT SURFACES**

WHO WE ARE

The aesthetic and functional finish of surfaces is our strength. That is why we are the first point of contact for a large number of users from a wide range of industries. Founded in Hamburg, Germany, we have grown out into the world. With our comprehensive portfolio of coated abrasives and precision bonded abrasives, we have been one of the world's leading manufacturers since 1927.

THE PERFECT SOLUTION FOR THEM – WHAT DRIVES US

At Hermes, we work with passion on tailor-made solutions that perfectly match your individual requirements. We are constantly expanding our in-depth knowledge of your processes, applications and associated challenges, because we want to be more than just your service provider: we want to be your partner.

SERVICE - WHAT CHARACTERIZES US

Wherever and whenever you need our support, we are there for you – internationally, with local contacts at our many locations. For our speed and flexibility we are appreciated by our customers all over the world.

TALK TO US

Optimization potential can even be found in processes that seem to run optimally. Let us work together to find out how we can get more out of it for you. You will find your contact person in the "Contact finder" section on **hermes-abrasives.com**



Hermes Schleifmittel GmbH

Luruper Hauptstrasse 106
22547 Hamburg, Germany
Tel. +49 40 8330-0
Fax +49 40 8330-230
hsd@hermes-schleifwerkzeuge.com
www.hermes-abrasives.com



Safety first

www.abrasivessafety.com