



KLINGSPOR ABRASIVES GRIT CHART

Revised February 2004

SILICON CARBIDE PRODUCTS

MATERIAL	BACK.	BOND	MISC.	2000	1500	1200	1000	800	600	500	400	360	320	280	240	220	180	150	120	100	80	60	50	40	36	30	24	16	APPLICATION	
PS11	P	R/R	W	A	A	A	A	A	A	A	A	A	A	A	A	A	C	C	C	C	C	C								G P R
PS 24	P	R/R							E	E	E		E	E	E	E	E	E	E											M P R
PL25	P	G/G						E	E	E	E	E	E	E	E	E													P	
PL35	P	R/G									B	B	B	B	B	B	B	B	B	B										P
PS 35 W	P	R/R	ST Ex. Lube, SOC Semi Op.									B	B	B	B	B	C	C											G P	
CS 320	C	R/R																	Y			YX	YX						G M P R	
CS 321	C	R/R	W					X	X	X	X	X	X	X	X	X	X	X	X	X	X									G M P R
CS 330	C	R/R	W/cork SIC					X	X		X			X		X		X											G M SS	
CS 333 fix*	C	R/R	spc. reqst.										JF	JF	JF	JF	JF	JF											G M P R	
CS 333 J	C	R/R							J	J	J	J	J	J	J	J	J												G M P R	
CS 333 X	C	R/R									X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X		G M P R
CS 335	C	R/R	OC													Y	Y	Y	Y	Y	Y	Y	Y	Y	Y				G W	

ALUMINUM OXIDE PRODUCTS

MATERIAL	BACK.	BOND	MISC.	2000	1500	1200	1000	800	600	500	400	360	320	280	240	220	180	150	120	100	80	60	50	40	36	30	24	16	APPLICATION	
PS 10	P		Garnet														A	A	A/C	A/C	A/C	A/D	D	D	D	D				W
PS 12	P	R/R	W			A	A	A	A	A	A																			M W
PS 18	P	R/R	OC, A/S														E	E	E	E	E	E								W
PS 20	P	R/R									F	F	F	F	F	F	F	F	F	F	F	F			F					M W
PS 22	P	R/R									E	E	E	E	E	E	E	E	E	E	E	E	E	E	E	E	E	E		M W
PS 23	P	R/R	OC, A/S														F	F	F	F	F	F	F	F	F					W
PS 26	P	R/R	OC, A/S														F	F	F	F	F									W
PS 31	P	R/R	OC														A	A	C	C	C	D	D	D	D	D				M W
PS 33	P	R/R	ST/Semi OC						B	B	B	B	B	B	B	B	B	B	B	C	C	C	C		C					PW
PS 33 W	P	R/R	ST Ex. Lube/Semi OC	B	B	B	B	B	B	B	B	B	B	B	B	B	B	B	B											M P R
PL36	P	R/G	ST								A	A	A	A	A	A	A	A												PW
CS 308	C	R/R	W			YX	YX	YX		YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX					M W
LS309 fix.	C	R/R								JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF					M W	
LS309	C	R/R							J	J	J	J	J	J	J	J	J	J	J	J	J	J	J	J					M W	
LS309 XH	C	R/R	OC, sml bit.														XH	XH	XH	XH	XH	XH	XH	XH	XH					M W
CS 310 xfix	C	R/R													XF	XF	XF	XF	XF	XF	XF	XF	XF	XF	XF					M W
CS 310	C	R/R						X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X		M W
CS 311 fix.	C	R/R	C Semi Op								JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF					M W	
CS 311	C	R/R	OC, A/S							YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	Y	Y				M W
LS312 fix.	C	R/R	M/Semi Op							JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF						M SS W	
LS313 fix	C	R/R	M/Semi Op							JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF						M SS W	
LS 319 fix.	C	R/R	OC							JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF						M W	
CS 326*	C	R/R	agglomerate					YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX												M SS
CS 341	C	R/R	W					X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X					M SS
KL 361 fix.	C	R/R						JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF			M W
KL 371	C	G/G						#	#	#	#	#	#	#	#	#	#	#	#	#	#	#	#	#	#					M
KL 385	C	R/R						JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF	JF			M W
CS 412	C	R/R	W								YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	YX	Y	Y				M W
CS 413	C	R/R	W, OC														YX	YX	YX	YX	YX	YX	YX	YX	Y	Y				M W
CS 561	FD	R/R									*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	M

ALUMINA ZIRCONIA PRODUCTS

MATERIAL	BACK.	BOND	MISC.	2000	1500	1200	1000	800	600	500	400	360	320	280	240	220	180	150	120	100	80	60	50	40	36	30	24	16	APPLICATION		
PS 21	P	R/R									F	F	F	F	F	F	F	F	F	F	F	F	F	F	F					M SS W	
PS 36	P	R/R	ST, SOC														C	C	C	C	C	C		D	D					M SS W	
CS 408	C	R/R	W																				YY							M	
CS 409	C	R/R	M, W																YX	YX	YX	YX	Y	Y	Y					M SS	
CS 411 X	C	R/R																	X	X	X	X	X	X	X		X			M SS	
CS 411	C	R/R	W																YX	YX	YX	Y	Y	Y	Y					M SS	
CS 414	C	R/R	xtra hvy, W																	YY	YY	YY	YY	YY	YY	YY		YY			M SS
CS 416	C	R/R	W, OC																YX	YX	YX	YX	Y	Y	Y		Y			M SS	
CS 565	FD	R/R	fibro disc																	*	*	*	*	*	*					M SS	
CS 570	FD	R/R	multi-bond																	*	*	*	*	*	*					M SS	

CERAMIC ALUMINUM OXIDE PRODUCTS

MATERIAL	BACK.	BOND	MISC.	2000	1500	1200	1000	800	600	500	400	360	320	280	240	220	180	150	120	100	80	60	50	40	36	30	24	16	APPLICATION	
CS 610	C	R/R	Multibond																						Y					M SS
CS 612	C	R/R																			Y	Y	Y							M SS

W = Waterproof, A/S = Anti-static, M = Multibond lubricant, OC = Open coat, SOC = Semi-Open coat,
 * = .030 vulcanized fibre, # = medium cotton cloth, #* = crocus cloth, CS 326*, CS 333* (JF) = samples with tech approval only
 M = Metal, R = Plastic/Rubber, G = Glass & Stone, W = Wood, SS = Stainless Steel, P = Paint/Varnish/Primer



BELT SANDING MATERIAL/APPLICATION RECOMMENDATION CHART GENERAL GUIDELINES

(call for specific information)

Operation		Wood	Grit
Abrasive Planing:		Softwoods: CS311 Hardwood: CS310, CS412, CS411, CS612	24-40
Wide Belts:	Primary	Softwoods: CS311 Hardwood: CS310, CS412, CS411, CS612	40-60
	Intermediate	Softwoods: CS311, PS26, PS23 Hardwood: CS310, PS20, CS612, PS61	80-120
	Finish	Softwoods: CS311, PS26, PS23 Hardwood: CS310, PS20, PS61	150 up
Edge Sanding:		Softwoods: CS311 Hardwoods: CS310, CS412	80-180
Stroke Sanding:		Softwoods: CS311, PS26, PS23 Hardwoods: CS310, PS20, CS612, PS61	80-180
Mold Sanding:		CS311JF, LS319JF, CS631	80-180
Pump Drum Sanding:		CS311JF, LS319JF, CS310XF	80-150
Scroll Sanding:		CS311JF, LS319JF	100-150
Spindle Sanding:		Spiral Bands, AO	100-150
Flutter Sheet/Discs:		LS319JF, CS311JF, LS309J	100-150
Portable Belt Sanding:		LS309XH, CS311, CS310	60-150
Orbital Disc Sanding:		Bare Wood: PS33, PL36, PS23	80-180
		Finished Wood: PL35, PS11	220 up
Operation		Metal	Grit
Stock Removal:		Soft Metals: CS311, CS416 Hard Metals: CS310, CS412, CS411/416, CS612/610, CS409	24-40
Wide Belts:	Primary	Soft Metals: CS311, CS416 Hard Metals: CS310, CS412, CS411/416, CS612/610, CS409	40-60
	Intermediate	Soft Metals: CS311, CS416 Hard Metals: CS310, CS412, CS411, CS612/610, CS409	80-120
	Finish	Soft Metals: CS311 Hard Metals: CS310, CS412, CS612, CS631, CS409	120 up
Edge Sanding:		Soft Metals: CS311 Hard Metals: CS310, CS412, CS411, CS612, CS610, CS409	80-180
Stroke Sanding:		Soft Metals: CS311 Hard Metals: CS310, CS412, CS612, CS409	80-180
Backstand :	Grinding	CS310, CS412, CS311, CS411, CS612, CS610, CS409	24-60
	Finishing	LS309JF, LS312, LS 313, CS631	80-400
Portable Belt:		CS310, CS311, CS412, CS411, CS409	24-120