WHICH FLAP DISC SHOULD I CHOOSE?

APPENDIX / CIBO INDUSTRIAL FNC & FSC



FNC / STEEL FABRICATION

For sustained steel grinding and stock removal.



FSC / STAINLESS STEEL

For stainless grinding at lighter pressure.

HOW THEY PERFORM

What changes?	FNC / Industrial Steel	FSC / Industrial Inox
Abrasive cloth	Stronger, slightly stiffer poly-cotton cloth supports sustained steel grinding and consistent wear.	More flexible abrasive cloth cuts readily at lower pressure.
Cut and working pressure	Choose 40 grit for fast steel stock removal when finish is secondary. Apply controlled, medium pressure for sustained cutting.	Choose 40 grit for aggressive stainless grinding, weld preparation and shaping. Flexible cloth cuts readily at lighter pressure, including on 750W grinders.
Finish and grit choice	40, 60 and 80 grit in 115/125mm: from material removal to finer blending.	40, 60, 80 and 120 grit in 115/125mm: removal, blending and finer scratch refinement.

CLOTH SUPPORT AND BACKING PLATE ARE DIFFERENT

The cloth carries the abrasive grain. The glass-fibre backing plate supports the complete disc. Both ranges use zirconia abrasive, a conical shape and a glass-fibre plate; the cloth construction changes how they respond in use.

Both ranges work steel, stainless steel and cast iron. Choose FNC for general steel fabrication and FSC for stainless-steel work. For 150 or 180mm grinders, choose FNC 40 grit; for finer 120-grit work, choose FSC in 115 or 125mm.

Sources: CIBO FNC and FSC product pages and flap-disc selection guide: cibo.be/en/cibos-flap-discs.

CHOOSE THE GRIT. THEN CHECK THE FIT.

APPENDIX / GRIT SELECTION & WORKING GUIDANCE

GRIT GUIDE

Grit	When to use it	Available ranges
40 / coarse	The coarsest grit in these ranges. Use for aggressive stock removal, weld preparation and shaping when finish is secondary.	FNC and FSC
60 / general grinding	Use for general weld dressing and deburring: effective removal with a finer scratch than 40 grit.	FNC and FSC
80 / finer blending	Refine scratches and blend surfaces where a finer abrasive finish is wanted.	FNC and FSC
120 / fine	Further scratch refinement after coarser grinding; check against a finish sample.	FSC

Use the least coarse grit that will do the job. Refine with a finer grit when needed. An abrasive grit number alone does not guarantee a specific surface roughness or a polished finish.

EXAMPLES / 125mm GRINDER

Job	Disc and grit	CIBO part number
Remove steel quickly / heavy fabrication	FNC / 40 grit	FNC/40/125
Stainless stock removal / weld preparation	FSC / 40 grit	FSC/40/125
Finer stainless scratch refinement	FSC / 120 grit, after suitable preparation	FSC/120/125

BEFORE YOU START

Match disc diameter, bore and maximum RPM to the grinder. FNC and FSC use a 22mm bore and are for dry use. Use controlled, medium pressure with FNC; FSC cuts readily at lighter pressure. Test on an inconspicuous area or sample first.

Keep abrasives used on carbon steel separate from those used on stainless steel to avoid transferring iron contamination. If a decorative, brushed or polished finish is required, discuss the complete finishing sequence with R H Davey.

Sources: CIBO product and selection pages; Euro Inox, The Mechanical Finishing of Decorative Stainless Steel Surfaces.