



# Automotive

Sanding systems for the automotive industry



## **sia Abrasives – your solution for surface finishes**

Vehicles are surfaces. Functionality meets expression and passion. The sanding of body parts is characterised by a sequence of process steps involving different requirements. The right technology and matching products are combined to form a system that meets these requirements and ensures a perfect surface finish.

Simply brilliant - the perfect surface finish.





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**sia products** 30

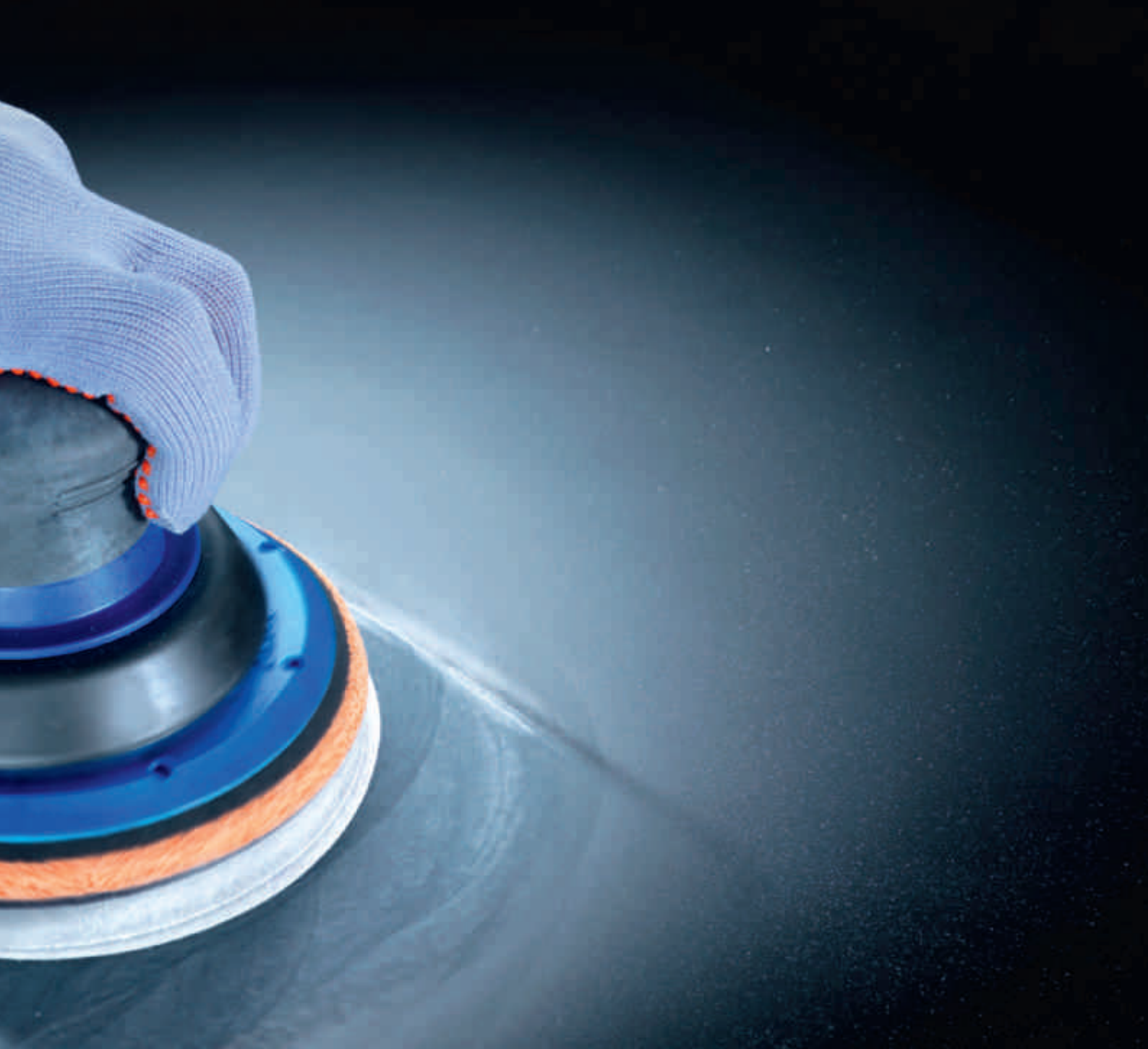


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# Automotive



# **Sanding systems**



### **The right product for perfect sanding results**

sia Abrasives offers a fully coordinated system comprising abrasives, machinery and accessories for bodywork specialists and automobile painters designed to ensure optimal and brilliant finishes.







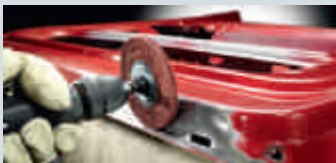



## 6 Sanding system for coarse sanding

	Type of work	Recommendation for use	sia products
	– Cutting vehicle body parts	Ø 75 mm    Ideal cut. speed    20 000 RPM Max. cut. speed    20 100 RPM	
	– Sanding off weld seams and burrs	Ø 115 mm    Ideal cut. speed    10 000 RPM Max. cut. speed    13 000 RPM	
	– Treatment of small and hard to reach areas – Treatment of welding seams	Ø 50 mm    Ideal cut. speed    20 000 RPM Max. cut. speed    30 000 RPM  Ø 75 mm    Ideal cut. speed    18 000 RPM Max. cut. speed    27 000 RPM	
	– Removal of old lacquer and rust from hard to reach areas – Treatment of fine weld seams	Ø 50 mm    Ideal cut. speed    20 000 RPM Max. cut. speed    30 000 RPM	
	– Smooth sanding of small and hard to reach areas	Ø 50 mm    Ideal cut. speed    15 000 RPM Max. cut. speed    30 000 RPM  Ø 75 mm    Ideal cut. speed    13 000 RPM Max. cut. speed    27 000 RPM	
	– Removal of old lacquer – Smooth sanding of corrosion spots	Ø 115 mm    Ideal cut. speed    8 000 RPM Max. cut. speed    11 000 RPM	
	– Smooth sanding of body parts, lacquer, stone chip protection etc.	Ø 115 mm    Ideal cut. speed    6 000 RPM Max. cut. speed    8 500 RPM	

Article ID	Grit	Dimension	sia accessories	Article ID	Dimension
<b>9189 siawheel cut-off wheels</b> 0020.0096.01 (T8443)				<b>Expanding mandrel with shaft</b> 0020.0113.01 (T4801) 6 mm 19 × 52 mm 0020.1086.01 (T4800) ¼" 19 × 52 mm	
<b>4924 siamet discs</b> 9386.9974 (T6406) P036 Ø 115 mm P040 Ø 115 mm P060 Ø 115 mm				<b>Backing pad hard</b> 0020.0348.02 (T7001) M14 Ø 115 mm	
<b>2820 siamet x siafix discs</b> 0020.1378.01 (T3871) P036 Ø 50 mm 0020.1379.01 P060 Ø 50 mm 0020.1382.01 (T3872) P036 Ø 75 mm 0020.1383.01 P060 Ø 75 mm				<b>Backing pad flexible with shaft</b> 0020.0132.01 (T8551) ¼"+6 mm Ø 50 mm Quick release 0020.0133.01 (T8551) ¼"+6 mm Ø 75 mm Quick release	
<b>2824 Flapfix siafix</b> 0020.4323.01 (T5054) K040 Ø 50 mm 0020.4324.01 (T5054) K060 Ø 50 mm 0020.4325.01 (T5054) K080 Ø 50 mm				<b>Backing pad flexible with shaft</b> 0020.0132.01 (T8551) ¼"+6 mm Ø 50 mm Quick release	
<b>6925 siamet scm siafix discs</b> 0020.0126.01 (T3875) coarse Ø 50 mm 0020.2340.01 medium Ø 50 mm 0020.0127.01 fine Ø 50 mm  0020.0129.01 (T3876) coarse Ø 75 mm 0020.2343.01 medium Ø 75 mm 0020.0130.01 fine Ø 75 mm				<b>Backing pad flexible with shaft</b> 0020.0132.01 (T8551) ¼"+6 mm Ø 50 mm Quick release 0020.0133.01 (T8551) ¼"+6 mm Ø 75 mm Quick release	
<b>1919 siawood TopTec siafast discs</b> 5903.5767 (T6077) P040 Ø 115 mm P060 Ø 115 mm P080 Ø 115 mm P100 Ø 115 mm P120 Ø 115 mm				<b>Backing pad flexible for siafast</b> 0020.0172.01 (T8584) M14 Ø 115 mm 0020.2325.01 (T8604) ⅝" Ø 115 mm	
<b>6926 siamet ud discs</b> 6723.5318.2921 (N6711) coarse Ø 115 mm 6723.5318.4921 medium Ø 115 mm 6723.5318.5921 fine Ø 115 mm				<b>Backing pad flexible for scm</b> 0020.0396.02 (T6977) M14 Ø 115 mm	



Other dimensions and grit sizes on request

## 8 Sanding system for coarse sanding

	Type of work	Recommendation for use	sia products
	<ul style="list-style-type: none"> <li>– Removal of old lacquer</li> <li>– Removal of stone chip protection</li> <li>– Smooth sanding of weld beads, edges and hard to reach areas</li> </ul>	Ø 100 mm    Ideal cut. speed    3 500 RPM Max. cut. speed    6 000 RPM	
	<ul style="list-style-type: none"> <li>– Removal of old lacquer</li> <li>– Removal of stone chip protection</li> </ul>	Ø 115 mm    Ideal cut. speed    6 000 RPM Max. cut. speed    8 000 RPM	
	<ul style="list-style-type: none"> <li>– Removal of old lacquer</li> <li>– Removal of stone chip protection</li> <li>– Smooth sanding of weld beads, edges and hard to reach areas (very flexible)</li> </ul>	Ø 100 mm    Ideal cut. speed    3 500 RPM Max. cut. speed    6 000 RPM	
	<ul style="list-style-type: none"> <li>– Removal of masking film and adhesive residues</li> </ul>	Ø 88 mm    Ideal cut. speed    2 000 RPM Max. cut. speed    4 000 RPM	

### Notes
















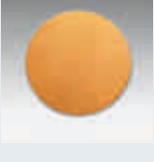


- Aluminium: treat using at least one grit size finer than for steel.

Article ID	Grit	Dimension	sia accessories	Article ID	Dimension
<b>6300 siastrip discs</b> 4329.5929.1721 (N3010)	K040	Ø 100 mm/6 mm		<b>Expanding mandrel fitted from the front</b> 0029.0287.01 (N3866)	6 mm shaft
<b>6300 sia Powerstrip</b> 1733.1719.1721 (N2065)	K040	Ø 115 mm/22 mm			
<b>6914 siafleece sd</b> 7766.0014.3911	coarse (red)	Ø 100 mm/12 mm		<b>Expanding mandrel fitted from the back</b> 0029.0009.01 (N3843)	6 mm shaft
<b>siarad strip eraser</b> 0020.3983.01 (T7812)		Ø 88 mm × 15 mm 5/16" connection 6 mm shaft			

Other dimensions and grit sizes on request









**TIP**  
**Contact corrosion:**  
Electrochemical contact corrosion occurs whenever electrochemically dissimilar metallic materials come into contact in the presence of an electrolyte.  
Caution: never use the same abrasive on different metallic surfaces.

	Type of work	Recommendation for use	sia products
	<ul style="list-style-type: none"> <li>– Removal of weathered lacquer</li> <li>– Sanding out of feather edges</li> </ul>	K060 K080–P150 Orbit for orbital sander: 10.0–5.0 mm	
	<ul style="list-style-type: none"> <li>– Flatting of body filler</li> <li>– Flatting of body filler</li> </ul>	K080–P150 K180–P280 Orbit for orbital sander: 10.0–5.0 mm	
	<ul style="list-style-type: none"> <li>– Keying of factory primers</li> </ul>	P240–P320 Orbit for orbital sander: 7.0–5.0 mm	
	<ul style="list-style-type: none"> <li>– Keying of very hard factory primers</li> <li>– Keying of aluminium panels</li> </ul>	K240–K320 Orbit for orbital sander: 5.0 mm	
	<ul style="list-style-type: none"> <li>– Matt finishing of new components and factory primers</li> </ul>	very fine Orbit for orbital sander: 7.0–5.0 mm	
	<ul style="list-style-type: none"> <li>– Flatting of primer filler</li> </ul>	P280–P360 Orbit for orbital sander: 5.0–2.5 mm	
	<ul style="list-style-type: none"> <li>– Fine sanding of primer filler</li> <li>– Keying of old lacquer</li> </ul>	P400–P500 P500–P1000 Orbit for orbital sander: 5.0–2.5 mm	
	<ul style="list-style-type: none"> <li>– Keying of scratch-resistant lacquers</li> <li>– Fine sanding of hard primer fillers</li> </ul>	K500	
	<ul style="list-style-type: none"> <li>– Cleaning/refining after sanding of primer filler</li> </ul>	ultra fine Orbit for orbital sander: 5.0–2.5 mm	

Article ID	Grit	Dimension	sia accessories	Article ID	Dimension	
<b>5550 siaprime siafast discs 15 holes</b> 5638.8237	K040–K80 P100–P280	Ø 150 mm		<b>Backing pad Yellow 15 holes (5/16")</b> 0020.4740.01 (T7215)	Ø 150 mm	soft
<b>1950 siaspeed siafast discs 15 holes</b> 7546.2948 (T2023)	K040–K80 P100–P280	Ø 150 mm		<b>Air chamber backing pad 103 holes (5/16" + M8)</b> 0020.5741.01 0020.5740.01	Ø 150 mm Ø 150 mm	hard soft
<b>1950 siaspeed siafast discs 17 holes*</b> 1866.3684	K040–K80 P100–P280	Ø 150 mm		<b>Air chamber backing pad 103 holes (5/16" + M8)</b> 0020.5741.01 0020.5740.01	Ø 150 mm Ø 150 mm	hard soft
* for Festool Multi-Jetstream						
<b>7241 siacarbon siafast discs</b> 9980.9463	K240, K320	Ø 150 mm		<b>Air chamber backing pad 103 holes (5/16" + M8)</b> 0020.5741.01 0020.5740.01	Ø 150 mm Ø 150 mm	hard soft
<b>6120 siavlies speed siafast discs</b> 7866.2539.6921	very fine (red)	Ø 150 mm		<b>Air chamber backing pad 103 holes (5/16" + M8)</b> 0020.5741.01 0020.5740.01	Ø 150 mm Ø 150 mm	hard soft
<b>1950 siaspeed siafast discs 15 holes</b> 7546.2948 (T2023)	P280–P600	Ø 150 mm		<b>Air chamber backing pad 103 holes (5/16" + M8)</b> 0020.5740.01 0020.5742.01	Ø 150 mm Ø 150 mm	soft extra soft
<b>1950 siaspeed siafast discs 17 holes*</b> 1866.3684	P280–P600	Ø 150 mm		<b>Intermediate Pad 103 holes with J Hook Velcro backing</b> 0020.5886.01	Ø 150 mm	
* for Festool Multi-Jetstream						
<b>7241 siacarbon siafast discs</b> 9980.9463.0500.01	K500	Ø 150 mm		<b>Air chamber backing pad 103 holes (5/16" + M8)</b> 0020.5740.01 0020.5742.01	Ø 150 mm Ø 150 mm	soft extra soft
<b>6120 siavlies speed siafast discs</b> 7866.2539.8715	ultra fine	Ø 150 mm		<b>Sanding guide powder set</b> 0020.2302.01 (T9032)	Set incl. 2 cartridges each 30 g	
				<b>Replacement cartridges</b> 0020.2301.01 (T9032)	6 cartridges each 30 g	

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	Type of work	Recommendation for use	sia products
	<ul style="list-style-type: none"><li>– Flatting of body filler</li></ul>	K040–P150	
	<ul style="list-style-type: none"><li>– Flatting of body filler</li><li>– Flatting of body filler</li><li>– Flatting of primer filler</li><li>– Fine sanding of primer filler</li></ul>	K080–P120 P150–P180 P240–P360 P400–P600	
			
			
	<ul style="list-style-type: none"><li>– Flatting of body filler and primer filler on convex and concave parts</li></ul> <div></div>	K080–P360	
	<ul style="list-style-type: none"><li>– Flatting of body filler and primer filler</li><li>– Fine sanding of primer filler</li></ul>	K080–P360 P400–P600	
	<ul style="list-style-type: none"><li>– Sanding of various materials</li></ul>	Use previously used discs Ø 150 mm as an enhancement to machine sanding	

Article ID	Grit	Dimension	sia accessories	Article ID	Dimension
<b>1950 siaspeed siafast strips 14 holes</b> 5618.8422 (T2043) K040 + K060 70 × 420 mm 5618.8422 K080 – P150 70 × 420 mm				<b>Body file 14 holes</b> 0020.3924.01 (T7046)	70 × 400 mm Connector for extraction system Hard cellular rubber sialett
<b>1950 siaspeed siafast strips 8 holes</b> 8457.3676 (T2040) K080 – P600 70 × 125 mm				<b>Hand sanding block 8 holes</b> 0020.3926.01 (T7046)	70 × 125 mm Connector for extraction system Hard cellular rubber sialett
<b>1950 siaspeed siafast strips 8 holes</b> 0062.9565 (T2041) K080 – P600 70 × 198 mm				<b>Hand sanding block 8 holes</b> 0020.3922.01 (T7046)	70 × 198 mm Connector for extraction system Hard cellular rubber sialett
<b>1950 siaspeed siafast strips 18 holes</b> 5348.6389 (T2042) K080 – P600 115 × 228 mm				<b>Hand sanding block 18 holes</b> 0020.3923.01 (T7046)	115 × 230 mm Connector for extraction system Hard cellular rubber sialett
<b>1950 siaspeed siafast strips 18 holes</b> 5348.6389 (T2042) K080 – P360 115 × 228 mm				<b>Flexible hand sanding block 18 holes</b> 0020.0263.01 (T7046)	115 × 228 mm Connector for extraction system Flexible plate sialett
				<b>Dust extraction hose for hand sanding tools</b> 0020.3925.01 (T7046)	∅ 25 mm / ∅ 21 mm × 4000 mm
				<b>Adaptor for dust extraction hose</b> 0020.4349.01 (T7046)	∅ 29 mm / ∅ 21 mm × 47 mm
<b>1950 siaspeed siafast strips without holes</b> 6783.9190 (T2050) K080 – P400 70 × 125 mm				<b>Hand sanding block for dry sanding</b> 0020.0342.01 (T7055)	70 × 125 mm without holes double-sided medium hard/extra soft sialett
<b>1950 siaspeed siafast discs</b> 		∅ 150 mm		<b>Round hand sanding block</b> 0020.0364.02 (T7060)	∅ 150 mm without holes soft sialett










Other dimensions and grit sizes on request

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Type of work		Recommendation for use		sia products
	<ul style="list-style-type: none"><li>– Initial sanding of curves, edges and curved shapes</li><li>– Final sanding of primer filler in hard to reach areas</li><li>– Sanding for blending</li></ul>	P150–P320	Sanding: dry	
		P320–P600 P800–P1000		
	<ul style="list-style-type: none"><li>– Initial sanding of curves, edges and curved shapes</li><li>– Final sanding of primer filler hard to reach areas</li><li>– Sanding for blending</li></ul>	medium–fine fine–extra fine super fine–micro fine	Sanding: dry Sanding: dry Sanding: dry	
	<ul style="list-style-type: none"><li>– Final sanding of primer filler in hard to reach areas</li><li>– Matt finishing of lacquered surfaces in hard to reach areas</li></ul>	K600–K800 K800–K1000	Sanding: moist Sanding: moist	
	<ul style="list-style-type: none"><li>– Flatting of primer filler, matt finishing of lacquers prior to final lacquering</li></ul>	P600–P1200	Sanding: wet	

Article ID	Grit	Dimension	sia accessories	Article ID	Dimension
<b>1950 siaspeed siasoft rolls perforated</b>					
2237.4334 (T2150)	P150–P600	115/125 mm × 25 m			
7621.1023	P800 + P1000	110/125 mm × 25 m			
<b>1950 siaspeed siasoft strips</b>					
4564.0566 (T2151)	P150–P600	115 × 140 mm			
9947.7255	P800 + P1000	110 × 140 mm			
<b>9214 Flat Pad</b>					
0020.3794.01 (T2275)	medium	115 × 140 mm			
0020.3795.01	fine	115 × 140 mm			
0020.3796.01	extra fine	115 × 140 mm			
0020.3797.01	super fine	115 × 140 mm			
0020.3798.01	micro fine	115 × 140 mm			
<b>7940 siaair siafast strips</b>					
6329.7598 (T3308)	K600	115 × 140 mm			
	K800	115 × 140 mm			
	K1000	115 × 140 mm			
<b>1913 siawat sheet</b>					
3100.3713 (T6021)	P600	230 × 280 mm		<b>Hand sanding block with slot, without Velcro backing</b>	
	P800	230 × 280 mm		0020.0389.01 (T8184)	70 × 125 mm
	P1000	230 × 280 mm			
	P1200	230 × 280 mm			
				<b>Flexible hand sanding block</b>	
				0020.3713.01 (T5099)	60 × 128 × 15 mm

Other dimensions and grit sizes on request

	Type of work	Recommendation for use	sia products
	<b>– Matt finishing of new components and factory primers before applying primer filter</b>	very fine	 
	<b>– Matt finishing of lacquers prior to final lacquering</b>	ultra fine	 
	<b>– Matt finishing of sensitive lacquers, polishable after spraying</b>	micro fine	 

Article ID	Grit	Dimension	sia accessories	Article ID	Dimension
<b>6120 siavlies speed rolls</b>					
9327.7238.6921 (N7056)	very fine (red)	100 mm × 10 m			
3144.5052.6921 (N7900)	very fine (red)	115 mm × 10 m			
2344.9555.6921 (N7013)	very fine (red)	125 mm × 10 m			
<b>6120 siavlies speed perforated strips</b>					
0055.7679.6921 (N7002)	very fine (red)	115 × 152 mm			
<b>6120 siavlies speed strips</b>					
4132.9840.6921 (N7058)	very fine (red)	115 × 229 mm			
<b>6120 siavlies speed rolls</b>					
9327.7238.8715 (N7056)	ultra fine (grey)	100 mm × 10 m			
3144.5052.8715 (N7900)	ultra fine (grey)	115 mm × 10 m			
2344.9555.8715 (N7013)	ultra fine (grey)	125 mm × 10 m			
<b>6120 siavlies speed perforated strips</b>					
0055.7679.8715 (N7002)	ultra fine (grey)	115 × 152 mm			
<b>6120 siavlies speed strips</b>					
4132.9840.8715 (N7058)	ultra fine (grey)	152 × 229 mm			
<b>6120 siavlies speed rolls</b>					
3144.5052.9913 (N7900)	micro fine (gold)	115 mm × 10 m			
<b>6120 siavlies speed perforated strips</b>					
0055.7679.9913 (N7002)	micro fine (gold)	115 × 152 mm			
<b>6120 siavlies speed strips</b>					
4132.9840.9913 (N7058)	micro fine (gold)	115 × 229 mm			



**Matting paste siamat**  
0020.4174.01 (T7026)




500 ml






**Other dimensions and grit sizes on request**

Type of work		Recommendation for use		sia products
	<b>– Matt finishing of old and new lacquers for blending</b>	P800–P1000 Orbit for orbital sander: 3.0–2.5 mm		
	<b>– Retouching of new lacquer coats</b>	P1200–P1500 Orbit for orbital sander: 3.0–2.5 mm		
	<b>– Matt finishing of conventional lacquers before applying primer filter</b> <b>– Matt finishing of conventional lacquers for blending</b>	K360–K500 K600–K800	Sanding: moist Sanding: moist	
	<b>– Matt finishing of surfaces to be sprayed</b>	K1000–K3000	Sanding: moist	
	<b>– Matt finishing of scratch-resistant lacquers before applying primer filter</b> <b>– Matt finishing of scratch-resistant lacquers for blending</b>	K500 K1000	Sanding: moist Sanding: moist	
				
	<b>– Matt finishing of old lacquers</b>	very fine ultra fine micro fine Orbit for orbital sander: 5.0–2.5 mm		
	<b>– Producing a matt finish for blending</b>	very fine ultra fine micro fine Orbit for orbital sander: 5.0–2.5 mm		
				

Article ID	Grit	Dimension	sia accessories	Article ID	Dimension	
<b>1950 siaspeed siafast discs 15 holes</b>				<b>Air chamber backing pad 103 holes</b> ( $\frac{5}{16}$ " + M8)		
7546.2948	P800	Ø 150 mm		0020.5742.01	Ø 150 mm	extra soft
	P1000	Ø 150 mm				
	P1200	Ø 150 mm				
	P1500	Ø 150 mm				
<b>1950 siaspeed siafast discs 17 holes *</b>				<b>Intermediate Pad 103 holes with J Hook Velcro backing</b>		
1866.3684	P800	Ø 150 mm		0020.5886.01	Ø 150 mm	103 holes
	P1000	Ø 150 mm				
	P1200	Ø 150 mm				
	P1500	Ø 150 mm		<b>Intermediate Pad 15 holes with Mikroklett</b>	Ø 150 mm	15 holes
* for Festool Multi-Jetstream				0020.4546.01 (T6744)		
<b>7940 siaair siafast discs</b>				<b>Air chamber backing pad 103 holes</b> ( $\frac{5}{16}$ " + M8)		
5163.3687 (T3307)	K360–K2000	Ø 150 mm		0020.5742.01	Ø 150 mm	extra soft
<b>7940 siaair siafast discs</b>				<b>Backing pad for orbital sander</b> ( $\frac{5}{16}$ " )		
3647.2462 (T3306)	K1000	Ø 80 mm		0020.1988.01 (T9012 )	Ø 77 mm	soft
	K2000	Ø 80 mm				
	K3000	Ø 80 mm				
<b>7240 siacarat siafast discs</b>				<b>Protection Disc</b>		
9967.9911 (T5096)	K500	Ø 150 mm		0020.3453.01 (T3309)	Ø 150 mm	
9967.9911 (T5096)	K1000	Ø 150 mm				
<b>7240 siacarat siafast discs</b>						
8451.8686 (T5095)	K500	Ø 80 mm				
8451.8686 (T5095)	K1000	Ø 80 mm				
<b>6120 siavlies speed discs siafast</b>				<b>Air chamber backing pad 103 holes</b> ( $\frac{5}{16}$ " + M8)		
7866.2539.6921 (N8996)	very fine (red)	Ø 150 mm		0020.5742.01	Ø 150 mm	extra soft
<b>6120 siavlies speed discs siafast</b>				<b>Matting paste siamat</b>		
7866.2539.8715 (N8996)	ultra fine (grey)	Ø 150 mm		0020.4174.01 (T7026)	500 ml	
<b>6120 siavlies speed discs siafast</b>				<b>Protection Disc</b>		
7866.2539.9913 (N8996)	micro fine (gold)	Ø 150 mm		0020.3453.01 (T3309)	Ø 150 mm	

Other dimensions and grit sizes on request

	Type of work	Recommendation for use		sia products
	<ul style="list-style-type: none"><li>– Retouching of lacquers (dust inclusions, orange-peel effect)</li></ul>	P1200–P1500 Orbit for orbital sander: 3.0–2.5 mm	Sanding: dry	
				
	<ul style="list-style-type: none"><li>– Removal of lacquer runs</li><li>– Removal of orange-peel effect and dust inclusions</li></ul>	P1200–P1500 P1500–P2500	Sanding: wet	
				
				

Article ID	Grit	Dimension	sia accessories	Article ID	Dimension
<b>1950 siaspeed siafast discs 15 holes</b>				<b>Air chamber backing pad 103 holes</b> ( $\frac{5}{16}$ " + M8)	
7546.2948 (T2023)	P1200	Ø 150 mm		0020.5742.01	Ø 150 mm extra soft
	P1500	Ø 150 mm			
<b>1950 siaspeed siafast discs 17 holes *</b>				<b>Intermediate Pad 103 holes with J Hook Velcro backing</b>	
1866.3684	P1200	Ø 150 mm		0020.5886.01	Ø 150 mm 103 holes
	P1500	Ø 150 mm			
* for Festool Multi-Jetstream				<b>Intermediate Pad 15 holes with Mikroklett</b>	
				0020.4546.01 (T6744)	Ø 150 mm 15 holes
<b>1913 siawat siafast strips</b>				<b>Hand sanding block for wet-/dry sanding</b>	
5980.9923 (T4827)	P1200	70 × 125 mm		0020.0343.01 (T7053)	70 × 125 mm double-sided hard/soft Mikroklett
	P1500	70 × 125 mm			
	P2000	70 × 125 mm			
	P2500	70 × 125 mm			
<b>1913 siawat sheet</b>				<b>Hand sanding block with slot, without Velcro backing</b>	
9219.5517 (T6140)	P1200	140 × 230 mm		0020.0389.01 (T8184)	70 × 125 mm
	P1500	140 × 230 mm			
	P2000	140 × 230 mm			
	P2500	140 × 230 mm			
<b>1913 siawat sheet</b>				<b>Flexible hand sanding block</b>	
3100.3713 (T6021)	P1200	230 × 280 mm		0020.3713.01 (T5099)	60 × 128 × 15 mm
	P1500	230 × 280 mm			
	P2000	230 × 280 mm			
	P2500	230 × 280 mm			

Other dimensions and grit sizes on request

## 22 Sanding system for micro-finishing | Retouching of lacquers

	Type of work	Recommendation for use		sia products
	– Sanding out of dust inclusions (siafast)	P1500–P2500	Sanding: moist	
	– Sanding out of dust inclusions (skf)	P1500–P2500	Sanding: moist	
	– Sanding out of dust inclusions (siafast)	P1500–P2500	Sanding: moist	
	– Sanding out of dust inclusions (skf)	P1500–P2500	Sanding: moist	
	– Fine sanding of flattened surfaces as a preliminary step prior to polishing	K2000	Sanding: moist	
		K3000	Sanding: moist	
	– Fine sanding of flattened surfaces prior to polishing of scratch-resistant and very hard lacquers	K4000	Sanding: moist	
		Orbit for orbital sander: 3.0–2.5		
				

Article ID	Grit	Dimension	sia accessories	Article ID	Dimension	
<b>1913 siawat siafast Daisy Discs</b> 4269.7970 (T8168)	P1500 P2000 P2500	Ø 37 mm Ø 37 mm Ø 37 mm		<b>Finiblock for siafast</b> 0020.3285.01 (T8550)	Ø 30 mm	round hard/soft Mikroklett
<b>1913 siawat skf Daisy Discs</b> 9251.0230	P1500 P2000 P2500	Ø 37 mm Ø 37 mm Ø 37 mm		<b>Finiblock for skf</b> 0020.3286.01 (T8550)	Ø 30 mm	round hard/soft self-adhesive
<b>1913 siawat siafast Daisy Discs</b> 4269.7970 (T8168)	P1500 P2000 P2500	Ø 37 mm Ø 37 mm Ø 37 mm		<b>Backing pad siafast</b> ( $\frac{5}{16}$ " ) 0020.1839.01 (T8564)	Ø 32 mm	soft
<b>1913 siawat skf Daisy Discs</b> 9251.0230	P1500 P2000 P2500	Ø 37 mm Ø 37 mm Ø 37 mm		<b>Backing pad skf</b> ( $\frac{1}{4}$ " ) 0020.4689.01 (T8564)	Ø 30 mm	soft
<b>7940 siaair</b> 3647.2462 (T3306)	K2000 K3000 K4000	Ø 80 mm Ø 80 mm Ø 80 mm		<b>Backing pad for orbital sander</b> ( $\frac{5}{16}$ " ) 0020.1988.01 (T9012)	Ø 77 mm	soft
<b>7940 siaair</b> 5163.3687 (T3307)	K2000 K3000 K4000	Ø 150 mm Ø 150 mm Ø 150 mm		<b>Air chamber backing pad 103 holes</b> ( $\frac{5}{16}$ " + M8) 0020.5742.01	Ø 150 mm	extra soft
<b>7240 siacarat</b> 8451.8686 (T5095)	K2000 K3000	Ø 80 mm Ø 80 mm		<b>Intermediate Pad 103 holes with J Hook Velcro backing</b> 0020.5886.01	Ø 150 mm	103 holes
				<b>Intermediate Pad</b> 0020.0269.01 (T8997)	Ø 77 mm	
<b>7240 siacarat</b> 9967.9911 (T5096)	K2000 K3000	Ø 150 mm Ø 150 mm		<b>Protection Disc</b> 0020.3453.01 (T3309)	Ø 150 mm	

Other dimensions and grit sizes on request

Ten helpful polishing tips

1. We recommend using siashine magic at every stage of the process to give surfaces the most brilliant finish possible.

2. For best results, always use the recommended combination of backing pad and polishing compound.

3. Apply the polishing compound to an area slightly smaller than the area to be polished.

4. Clean backing pads produce brilliant results. Dirty backing pads can cause scratching.






5. Cleaning backing pads regularly with water will greatly extend their useful life.
6. Dry polishing will «tarnish» the surface – do not allow the polishing compound to dry up during polishing.

7. The recommended speed is the optimum speed for mechanical polishing.

8. Never polish in direct sunlight.

9. Use less effort: let the polish and the weight of the machine do all the work.

10. Keep the polisher constantly moving to achieve a uniform finish and prevent overheating.

Type of work		
	<ul style="list-style-type: none"><li>– Polishing scratch-resistant lacquers</li></ul>	
	<ul style="list-style-type: none"><li>– Buffing up old lacquer</li><li>– After sanding surfaces</li></ul>	use 7940 siaair K2000/K3000
	<ul style="list-style-type: none"><li>– Polishing of sanded-out orange-peel effects</li><li>– Polishing of sanded-out lacquer runs</li><li>– Polishing of sanded-out dust inclusions</li><li>– Polishing of sanded surfaces</li></ul>	(sanded using 1950 P1200/P1500 and refined using 7940 siaair K2000/K3000) (sanded using 1913 P1500–P2500 and refined using 7940 siaair K2000/K3000) (sanded using 1913 P1500–P2500 and refined using 7940 siaair K2000/K3000) with 7940 siaair K4000
	<ul style="list-style-type: none"><li>– Removal of overspray</li><li>– Removal of fine scratches</li><li>– Finishing of bright colours after use of lambs-wool pad</li><li>– Intermediate step for dark and sensitive colours</li></ul>	
	<ul style="list-style-type: none"><li>– Removal of holograms</li><li>– Finishing of dark and sensitive colours</li></ul>	

Accessories



**siashine magic \***  
0020.3617.01  
(T6420)

- Effortless to use
- Removes and prevents holograms
- Non-streak shine on all lacquers

\* siashine magic is supplied without a spray nozzle



**Spray nozzle for siashine magic**  
0020.3618.01  
(T6420)

High-quality spray nozzle with viton seal

sia polishing compounds			sia polishing pads			
						
<b>siashine fast cut</b>	<b>siashine speed</b>	<b>siashine finish</b>	<b>Lambs-wool pad</b>	<b>Foam pad hard</b>	<b>Foam pad soft</b>	<b>Foam pad extra soft</b>
0020.4898.01	0020.3615.01 (T6420)	0020.3616.01 (T6420)	0020.0265.01 Ø 170 mm (T8426) 0020.4897.01 Ø 80 mm	0020.2018.01 Ø 170 mm (T8427) 0020.4896.01 Ø 80 mm	0020.0264.01 Ø 170 mm (T8427) 0020.4895.01 Ø 80 mm	0020.0262.01 Ø 170 mm (T8970) 0020.4894.01 Ø 80 mm
<div> <div>aggressive</div> <div>fast cut</div> <div>speed</div> <div>finish</div> <div>fine</div> </div>						
						
						
						
						
						



**Microfibre cloth**  
**sia Policloth**  
0020.3185.01  
(T8496)  
380 × 380 mm



**Backing pad with siafast**  
0020.1907.01  
(T8425)  
M14 Ø 150 mm  
0020.4899.01  
M14 Ø 75 mm

**Recommended cutting speed:**  
Ø 80 mm = ideal cut. speed 2200 RPM,  
max. cutting speed 3200 RPM  
Ø 170 mm = ideal cut. speed 1200 RPM,  
max. cutting speed 1800 RPM



# **Sanding technology**



### **We turn sanding into a surface technology**

Clocks, cars, furniture, yachts, snowboards – the list of products that are treated during the production process using sanding products from sia Abrasives could almost go on forever. True to our slogan «sia Abrasives – Your Key to a Perfect Surface», our world-leading expertise in surface technology means we can ensure the right texture and quality on a huge variety of surfaces and materials.

**Pages 26–29**


28 Backing pad/orbit recommendations


Backing pad type		Grit	Type of work	
Soft 5.0 orbit	Hard 10.0–5.0 orbit	40	– Mechanical lacquer removal	
		60		
		80	– Sanding out, flatting of body filler	
		100		
		120		
		150	– Sanding out, flatting of body filler	
		180		
		220	– Keying of factory primers	
	240	– Fine sanding of repair area – Fine sanding of body filler (prior to applying primer filler)		
	280			
	320	– Flatting of primer filler		
	360			
	400	– Fine sanding of primer filler (two-component lacquers)		
Intermediate Pad	Extra soft 5.0–2.5 orbit	500	– Fine sanding of primer filler (two-layer lacquers)	
		600	– Refining and dust removal using siavlies ultra fine	
		800	– Keying of old lacquer and subsequent clear coating – Matt finishing/keying for blending	
		1000		
		1200	– Retouching of new lacquer (orange-peel effect, dust inclusions)	
		1500		


**Sanding recommendation: grit size progressions**


Important: do not skip more than two grit sizes ...


**P080**


**P100**


**P120**


**P150**


**P180**


**P220**


**P240**

**P280**





**P320**

**P360**

**P400**

**P500**

**P600**



## Machine sanding

**5550 siaprime  
siafast**

Type of sanding: dry

**1950 siaspeed  
siafast**

Type of sanding: dry

**1940 siacar  
siafast**

Type of sanding: dry



P1500

P1200

P1000

P800

P600

P500

P400

P320

P280

P240

P220

K180

K150

K120

K100

K080

K060

K040

P180

P150

P120

P100

K080

K060

K040

P600

P500

P400

P320

P280

P240

P220

P180

P150

P120

P100

P060

P040

## Hand sanding

**1950 siaspeed  
siasoft**

Type of sanding: dry

**9214 Flat Pad**

Type of sanding: dry

**1913/1951 siawat**

Type of sanding: wet



P1500

P1200

P1000

P800

P600

P500

P400

P320

P280

P240

P220

P180

P150

micro fine

super fine

extra fine

fine

medium

P2500

P2000–P2500

P1500–P2000

P1200–P1500

P1000–P1200

P800–P1000

P600–P800

P500–P600

P400–P500

P320–P400

P240–P280

P220–P240

P150–P180

P120–P150

P100–P120

The image displays a variety of industrial products. At the top, there are large rolls of red leather-like material. Below these, several rolls of green and blue tapes are visible, some of which are unrolled and draped. To the left, there are circular abrasive discs in different colors (red, blue, and grey). The background is a plain, light-colored surface.

**sia products**



### **Top-quality products from Switzerland**

Careful selection of first-class raw materials, state-of-the-art, manufacturing and converting facilities and our highly-developed sia production technologies guarantee sanding products of the very highest standard and constant quality. sia abrasives are developed on the basis of demanding user requirements and detailed analysis of materials. They thus represent first-class Swiss precision and quality workmanship aimed at ensuring the very best surface finish every time.

**Pages 30–42**



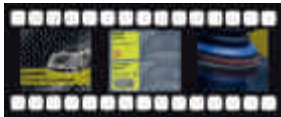
**Advantages**

- Excellent performance on hard materials
- Very good lifetime and stock removal thanks to state-of-the-art diamond technology
- Significantly reduced material expenditure
- Increased efficiency due to measurable time-saving
- Sensational sanding finish
- Full-surface dust extraction
- No dependence on hole system
- Constant removal rates
- Pleasant sanding feel
- Minimal risk of sanding through on edges
- Can be used moist or dry

**Applications**

- Hard factory primers
- Scratch-resistant lacquers
- Gelcoat (polyester and epoxy)
- Primers (epoxy)
- Hard primer fillers
- aluminium
- Primer and melamine films

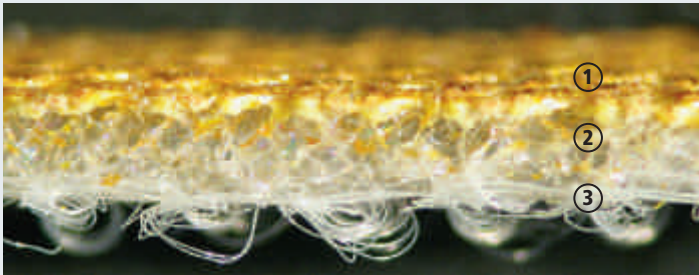
**Product show**



For more information on products, applications and much more ...  
[www.sia-abrasives.com](http://www.sia-abrasives.com)  
> Automotive > siacarbon

**Product profile: 7241 siacarbon**

Grit: Diamond  
Coating: Special process  
Bonding: Synthetic resin  
Backing: Cloth  
Grit range: K240, K320, K500



- 1** Diamond-coated net structure abrasive
- 2** Pressure-equalising foam insulation
- 3** siafast fastening system for an easy and fast change of abrasive

Product	Dimension	Grit range	Article ID
Discs	Ø 150 mm	K240, K320, K500	9980.9463.xxxx.01
	Ø 125 mm	K240, K320, K500	9453.3739.xxxx.01
	Ø 80 mm	K240, K320, K500	8486.4459.xxxx.01



### Advantages

- Homogeneous sanding finish
- Longest lifetime
- Uniform abrasive structure on film
- New stearate concept
- No scratches
- FEPA P Standard
- Can be used wet or dry
- One product for the entire grit range 40 – 1500 incl. siasoft
- Efficient and cost-effective lacquer retouching

### Applications

- Matt finishing of old and new lacquers for blending
- Retouching of new lacquer, for removal of dust inclusions and orange-peel effect

### Product show



For more information on products, applications and much more...

[www.sia-abrasives.com](http://www.sia-abrasives.com)  
> Automotive > siaspeed

### Product profile: 1950 siaspeed fk

Grit:	Aluminium oxide
Coating:	Special process
Bonding:	Synthetic resin
Additional coating:	Stearate
Backing:	Film
Grit range:	P800–P1500

Product	Dimension	Grit range	Catalogue No.	Article ID
siafast discs	Ø 150 mm without hole	P800–P1500	T2020.xxxx.x	7332.9183.xxxx.01
	Ø 150 mm 7 holes	P800–P1500		8438.1710.xxxx.01
	Ø 150 mm 15 holes	P800–P1500	T2023.xxxx.x	7546.2948.xxxx.01
	Ø 150 mm 17 holes *	P800–P1500		1866.3684.xxxx.01
siasoft perforated rolls	110/125 mm × 25 m	P800 + P1000		7621.1023.xxxx.01
siasoft sheet	110 mm × 140 mm	P800 + P1000		9947.7255.xxxx.01

Different dimensions on request.

\* for Festool Multi-Jetstream



**High-performance abrasives**

Thanks to the innovative abrasive structure and materials of the highest quality, significantly better removal rates are attained. The consistently impressive results are due to optimised scratch depth values.

**Long product life**

The ingenious stearate coating greatly reduces clogging of the abrasive. The net result is far longer lifetime.

**Cost-effective working processes**

The fully harmonised system guarantees trouble-free use, reduces sanding times and, in turn, saves money.

**A versatile all-round product**

Can be used with great success on primed, filled, painted and lacquered surfaces. Intensively trialled in our test centres to ensure that it is effective on any challenging surface in manual and manual/machine sanding operations.

**An attractive product range made to Swiss quality standards**

The complete product range, in various shapes and hole patterns, is available in a range of grit sizes from P040 to P1500, all featuring the practical siafast self fastening system.

**Applications**

- Sanding of body filler, polyester and composites
- Sanding of new components and factory primers
- Sanding out of feather edges, rust spots and stone chips
- Shaping of primer fillers
- Matt finishing of lacquers
- Retouching of new lacquer

**Product profile: 1950 siaspeed**

Grit:	Mixed grit types, semi-friable aluminium oxide, aluminium oxide	
Coating:	Electrostatic	(K040–P600)
	Special process	(P800–P1500)
Bonding:	Synthetic resin	
Additional coating:	Stearate	
Backing:	Paper	(K040–P600)
	Film	(P800–P1500)
Grit range:	K040–P1500	



Product	Dimension	Grit range	Catalogue No.	Article ID
siafast discs	Ø 150 mm without hole	K040–P1500	T2020.xxxx.x	7332.9183.xxxx
	Ø 150 mm 7 holes		T2021.xxxx.x	8438.1710.xxxx
	Ø 150 mm 15 holes		T2023.xxxx.x	7546.2948.xxxx
	Ø 150 mm 17 holes *			1866.3684.xxxx
	Ø 125 mm without hole		T2030.xxxx.x	6783.7705.xxxx
	Ø 125 mm 5 holes		T2031.xxxx.x	0845.6297.xxxx
	Ø 125 mm 6 holes		T2032.xxxx.x	3031.0713.xxxx
	Ø 125 mm 8 holes		T2033.xxxx.x	8286.8318.xxxx
	Ø 125 mm 9 holes		T2034.xxxx.x	3560.7130.xxxx
	Ø 76 mm 3 holes			6148.8222.xxxx
	Ø 80 mm without hole		T2026.xxxx.x	5816.8425.xxxx
	Ø 203 mm 9 holes		T2029.xxxx.x	5002.6471.xxxx
siafast strips	70 × 125 mm 8 holes	K040–P1500	T2040.xxxx.x	8457.3676.xxxx
	70 × 198 mm 8 holes		T2041.xxxx.x	0062.9565.xxxx
	115 × 228 mm 18 holes		T2042.xxxx.x	5348.6389.xxxx
	70 × 420 mm 14 holes		T2043.xxxx.x	5618.8422.xxxx
	93 × 180 mm 8 holes		T2044.xxxx.x	8801.7879.xxxx
	70 × 125 mm without hole		T2050.xxxx.x	6783.9190.xxxx
	115 × 230 mm without hole		T2051.xxxx.x	0465.4240.xxxx
	70 × 420 mm without hole		T2052.xxxx.x	3210.1376.xxxx
siasoft perforated rolls	115/125 mm × 25 m	P150–P600	T2150.xxxx.1	2237.4334.xxxx
	110/125 mm × 25 m	P800 + P1000		7621.1023.xxxx
siasoft unperforated rolls	115 mm × 25 m	P150–P600	T2152.xxxx.1	3973.1827.xxxx
siasoft sheet	115 × 140 mm	P150–P600	T2151.xxxx.6	4564.0566.xxxx
	110 × 140 mm	P800 + P1000		9947.7255.xxxx

\* for Festool Multi-Jetstream



The premium high-performance 5550 siaprime abrasive has been specially developed for industrial applications, as well as for repair activities. Thanks to the innovative abrasive structure, performance and lifetime are improved significantly – so you get results more quickly and cost-efficiently.

**Advantages**

- Best edge stability with film backing
- Extremely high removal rates thanks to ceramic grit
- Minimum of clogging thanks to special coating and optimised binder resin
- No disruption to coating
- High coating and tear resistance
- High level of flexibility guarantees trouble-free sanding at corners and edges
- Very efficient and productive
- Good planarity thanks to high resistance to climatic conditions

**Applications**

- Flatting of body filler, gelcoat and composites
- Sanding of lacquers and paints, steel, aluminium, plastics, hard and soft wood, mineral materials etc.

**Product show**



For more information on products, applications and much more ...  
[www.sia-abrasives.com](http://www.sia-abrasives.com)  
> Automotive > siaprime

**Product profile: 5550 siaprime**

Grit:	Innovative grit mixture (with ceramic)
Coating:	Electrostatic open
Bonding:	Synthetic resin
Backing:	Polyester film
Grit range:	K40 – K180

Product	Dimension	Grit range	Article ID
siafast discs	Ø 150 mm without hole	K40, K60, K80, K100, K120, K150, K180	5425.4472.xxxx
	Ø 150 mm 7 holes	K40, K60, K80, K100, K120, K150, K180	6530.6999.xxxx
	Ø 150 mm 15 holes	K40, K60, K80, K100, K120, K150, K180	5638.8237.xxxx
	Ø 150 mm 17 holes *	K40, K60, K80, K100, K120, K150, K180	9926.6387.xxxx

\* for Festool Multi-Jetstream



### Advantages

- Highly flexible, ideal for hard to reach areas
- Even sanding pattern
- Long lifetime thanks to dense grit coating
- Can be used wet or dry
- For manual or machine use
- High tear resistance

### Applications

- Keying of factory primers
- Keying of solid colours
- Final sanding of primer filler (with orbital sander)
- Matt finishing of metallic lacquers
- Matt finishing of water-dilutable lacquers and bright colours
- Matt finishing of sensitive paints and lacquers

### Product profile: 6120 siavlies speed

Grit:	Aluminium oxide, silicon carbide
Structure:	Open, nylon fleece
Bonding:	Synthetic resin
Backing:	siafast
Fineness:	very fine, ultra fine, micro fine

Product	Dimension	Fineness	Catalogue No.	Article ID
Rolls	100 mm × 10 m	very fine	N7056.6921.1	9327.7238.xxxx
	115 mm × 10 m	ultra fine	N7900.8715.1	3144.5052.xxxx
	125 mm × 10 m	micro fine	N7013.9913.1	2344.9555.xxxx
Discs without hole	Ø 150 mm	very fine	N8996.6921.3	7866.2539.xxxx
		ultra fine	N8996.8715.3	
		micro fine	N8996.9913.3	
Z-fold system, perforated	115 × 152 mm	very fine	N7002.6921.8	0055.7679.xxx
		ultra fine	N7002.8715.8	
		micro fine	N7002.9913.8	
Handpads	152 × 229 mm	very fine	N7058.6921.3	4132.9840.xxxx
		ultra fine	N7058.8715.3	
		micro fine	N7058.9913.3	



### Advantages

- Very even sanding pattern
- Highly adaptable to contours and curves
- Available up to grit size P2500
- Highly water resistant
- May be used wet or dry
- High stock removal with good finish
- 1913 siawat has been the market-leading wet sanding product for years

### Applications

- Removal of paint runs, orange-peel effect and dust inclusions
- Flattening of fillers, producing a matt finish on lacquers prior to final lacquering

#### Product profile: 1913 siawat

Grit:	Semi-friable aluminium oxide	P060–P1200
	Silicon carbide	P1500–P2500
Coating:	Closed	
Bonding:	Synthetic resin	
Backing:	c-wt paper, waterproof	
Grit range:	P060–P2500	

Product	Dimension	Grit range	Catalogue No.	Article ID
plain sheet	230 × 280 mm	P60–P2500	T6021.xxxx.6	3100.3713.xxxx
	140 × 230 mm	P1500/P2000/P2500	T6140.xxxx.x	9219.5517.xxxx
siafast strips	70 × 125 mm	P180–P2500	T4827.xxxx.6	5980.9923.xxxx
skf daisy discs	Ø 37 mm	P1500–P2500		9251.0230.xxxx
siafast daisy discs	Ø 37 mm	P1500–P2500	T8168.xxxx.7	4269.7970.xxxx
siafast discs	Ø 80 mm	P2000	T5126.2000.6	5013.8691.2000



### Advantages

- Very long lifetime
- Low scratch depth with high stock removal
- No risk of sanding through thanks to pressure-equalising foam
- Waterproof and washable
- Highly adaptable to edges and contours
- Absorbs water
- Can be used many times
- Permeable to air and water

### Applications

- Matt finishing of conventional lacquers
- Final sanding of primer filler in hard to reach areas
- Fine sanding of flattened surfaces prior to polishing
- Final sanding of mineral-based materials

### Product show



For more information on products, applications and much more ...

[www.sia-abrasives.com](http://www.sia-abrasives.com)  
> Automotive > siaair

### Product profile: 7940 siaair

Grit:	White aluminium oxide
Coating:	Special process
Bonding:	Synthetic resin
Backing:	Knitted fabric with foam backing
Grit range:	K240–K4000



- 1** Velvet net-backed abrasive
- 2** Foam cushioning
- 3** siafast fastening system

Product	Dimension	Grit range	Catalogue No.	Article ID
Discs	Ø 80 mm	K1000, K2000, K3000, K4000	T3306	3647.2462.xxxx
	Ø 150 mm	K240, K360, K500, K600, K800, K1000, K1500, K2000, K3000, K4000	T3307	5163.3687.xxxx
Strips	115 × 140 mm	K600, K800, K1000, K1500, K2000	T3308	6329.7598.xxxx



**Advantages**

- High-performance diamond abrasive minerals ensure maximum lifetime
- Lasts up to 40 times longer than conventional abrasives
- Waterproof and washable
- Highly adaptable when sanding around contours
- Low scratch depth with high stock removal
- No risk of sanding through thanks to pressure-equalising foam
- Can be used many times

**Applications**

- Sanding of scratch-resistant lacquer systems
- Ultrafine sanding of mineral materials
- Sanding of epoxy-based materials
- Matt finishing and refining of very hard surfaces



**Product profile: 7240 siacarat**

Grit:	Diamond
Coating:	Special process
Bonding:	Synthetic resin
Backing:	Knitted fabric with foam backing
Grit range:	K500, K1000, K2000, K3000

- 1** Velvet net-backed abrasive
- 2** Foam cushioning
- 3** siafast fastening system

Product	Dimension	Grit range	Catalogue No.	Article ID
Discs	Ø 80 mm	K500, K1000, K2000, K3000	T5095	8451.8686.xxxx
	Ø 150 mm	K500, K1000, K2000, K3000	T5096	9967.9911.xxxx



**siaway – a sure footing every step of the way**

Smooth, wet or oily floors are a major safety hazard. Slip-resistant floor coverings can help minimise this risk. The general-purpose anti-slip tape 5770 siaway is a safe and cost-effective way to prevent accidents caused by tripping, slipping or falling. siaway meets the most stringent material requirements and can be industrial, commercial and private area - quickly and easily.

**Advantages**

- Ideal for vehicles, plant rooms, scaffolds, stairs, corridors etc.
- Resilient and long-lasting thanks to high-quality materials
- Excellent grip thanks to special adhesive
- Suitable for universal use indoors and outdoors (UV-resistant)
- Up to 20 % lighter than conventional products
- The low thickness of the tape means that it can be traversed easily by vehicles and eliminates the risk of tripping
- Excellent water resistance



**Applications**

- Buses, rail vehicles, mobile shops, rescue vehicles, fire engines
- Construction and agricultural machinery, cranes, lifting platforms
- Plant rooms, walking surfaces, roofs
- Ladders, scaffolding, standing aids
- Stairs, steps, ramps, corridors, escape routes etc.

**Product profile: 5770 siaway**

Grit:	Non-slip mineral grit
Bonding:	Elastic binder
Backing:	Lightweight polyester covered with a removable protective film

Product	Dimension	Article ID
Roll of anti-slip tape	20 m × 25 mm	9147.1571.0060.01
	20 m × 50 mm	2164.3888.0060.01
	20 m × 100 mm	8134.3817.0060.01
	20 m × 150 mm	4136.6332.0060.01
	20 m × 300 mm	2089.5537.0060.01
	20 m × 400 mm	4061.8448.0060.01

Other sizes on request.



Advantages

- Developed for multi-hole and net-type abrasives
- Also suitable for 6-, 7-, 9- and 15-hole discs
- The 103-hole pattern guarantees consistent dust extraction
- Compatible with all standard orbital sanders thanks to Festo adaptor (5/16" + M8)
- New, heat-resistant Velcro backing guarantees improved extraction and longer lifetime
- Low vibration thanks to perfectly balanced backing

Applications

- Coarse sanding, precision finishing and micro finishing using orbital sander
- Pad hardness is optimised for each specific application

Product	Type	Dimension		Article ID
Air chamber backing pad	extra soft	Ø 150 mm	103 holes *	0020.5742.01
	yellow soft	Ø 150 mm	103 holes *	0020.5740.01
	hard	Ø 150 mm	103 holes *	0020.5741.01
Intermediate Pad	with J Hook Velcro backing	Ø 150 mm × 10 mm	103 holes	0020.5886.01
	with Mikroklett backing	Ø 150 mm × 12 mm	15 holes	0020.4546.01

\* The following articles are included with the multi hole air chamber backing pad:  
– Mounting set including Festo adaptor and spacer discs/screws 5/16" + M8 / Assembly instructions in several languages



### Advantages

- Direct and uniform transfer of force to the workpiece
- Ergonomically shaped handles
- Low weight
- The hole pattern and dimensions are designed to meet market requirements
- New hose system for even better extraction
- Extraction power can be controlled using the special valves supplied

### Applications

- Flattening of body filler and primer filler
- Fine sanding of primer filler



### TIP

To ensure that the hand blocks can always be used to their best advantage, even with a powerful extraction system, each hand-block set includes a regulator valve which provides optimum vacuum level control.

Product	Dimension	Catalogue No.	Article ID
Flexible hand sanding block	115 × 228 mm 18 holes	T7046.0000.1	0020.0263.01
Block	70 × 125 mm 8 holes	T7046.0001.1	0020.3926.01
	70 × 198 mm 8 holes	T7046.0002.1	0020.3922.01
	115 × 228 mm 18 holes	T7046.0003.1	0020.3923.01
File	70 × 400 mm 14 holes	T7046.0004.1	0020.3924.01
Extraction hose	4000 × 25 mm	T7046.0005.1	0020.3925.01
Connecting piece	Ø 29 / Ø 21 / 47 mm	T7046.0006.1	0020.4349.01



**Our system –  
Your advantages**



### **Surface finishing expertise with innovation**

The trend towards new materials with different properties continues unabated. New surface solutions are therefore a must. In response to this, sia Abrasives has further expanded its expertise in sanding and grinding of surfaces through product innovation and partnerships. sia Abrasives is consistently oriented towards the needs of the customer throughout the whole value added chain – from research and development, through logistics, all the way to training.

**Pages 44–49**



► **Customer advice**

**On site, from one professional to another**

Within the scope of our personalised customer service, we provide access to specialists who are happy to share their technical expertise and visit your premises as required.

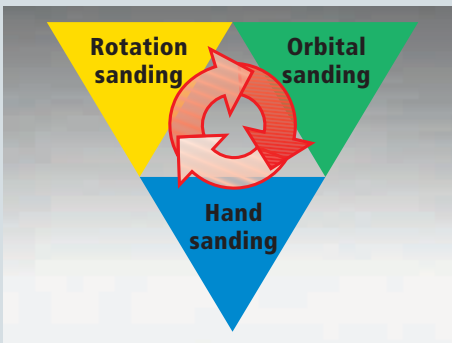
Our many years of experience ensure that you will find optimal solutions for all your abrasive technology requirements.



► **Surface technology**

**Economical and efficient treatment processes**

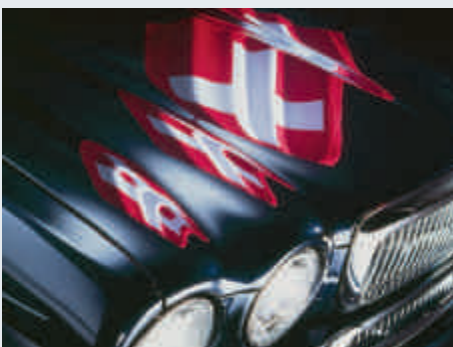
We examine the desired surface quality with a holistic approach. This means that both upstream and downstream treatment processes are considered in our analysis, while factors such as efficiency, economy, quality and environmental impact are also taken into account. We look for alternative solutions whenever necessary.



► **Treatment process**

**Perfectly suited products**

Our technical staff will support you in choosing the most suitable product to ensure that you achieve the desired surface result. We will also work with you to determine the optimum steps for your process.



► **Abrasives**

**top-quality products from Switzerland**

Abrasives from sia Abrasives represent the state of the art and are manufactured with great care from selected raw materials.

Our range includes products for every kind of industrial and commercial application from coarse sanding to finishing and polishing work.



► **Tools and accessories**

**Everything you could need**

Every possible user requirement is taken care of thanks to a full and diverse range of accessories, all of which are ideally suited for use with abrasives and designed for optimal surface quality.



### ► Application training

#### Customer-specific seminars in Switzerland

Every year, our state-of-the-art training centre in Frauenfeld provides comprehensive training to numerous specialist staff from various sectors of trade and industry. Our seminars allow participants to acquire new knowledge and share experiences in a comfortable, relaxed atmosphere.



### ► Documentation

#### Application-oriented resources

We provide a wide range of documentation including comprehensive product information and detailed application recommendations. These documents give you the means to ensure that you work with our products in a safe manner while guaranteeing that you end up with a perfect surface finish.

In particular, we refer to FEPA safety recommendations and safety data sheets dealing with abrasives, all of which can be downloaded from [www.sia-abrasives.com](http://www.sia-abrasives.com).



### ► Packaging

#### Perfect protection

Practical reusable packaging and shipping units are designed to meet the needs of both dealers and end-users.

Storage advice

Never ...

... on a concrete floor

... near an open window

... near sources of heat



### ► Distribution

#### Punctual and reliable

The aim of our efficient sales system is to satisfy customer requirements with regard to product choice, quantity and delivery schedule.

The sia Group is represented in over 80 countries around the world.

## Our commitment



### Company

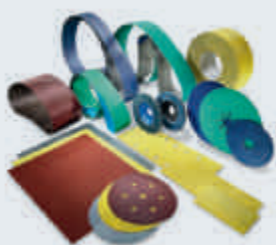
The sia Group is based in Frauenfeld, Switzerland, and is one of the world's top three suppliers of innovative abrasives. sia develops, manufactures and sells complete sanding systems tailored to specific requirements and applications of all kinds, transforming sanding into surface technology.

sia Abrasives employs about 1250 people and is represented in more than 80 countries.

### Top-quality products from Switzerland

Careful selection of first-class raw materials, state-of-the-art, manufacturing and converting facilities and our highly-developed sia production technologies guarantee sanding products of the very highest standard and constant quality. sia abrasives are developed on the basis of demanding user requirements and detailed analysis of materials. They thus represent first-class Swiss precision and quality workmanship aimed at ensuring the very best surface finish every time.

## Innovative abrasives



### Coated abrasives

Classic flexible abrasives and systems for conventional surface treatment on all types of material.



### Nonwoven abrasives

Nonwoven products for preparation and cleaning tasks and for structuring, especially on metal.



### Microabrasives

Products on special polyester film to produce defined surface structures in the graphic, optical and automotive industries.



### Foam abrasives

Foam sanding pads in the widest possible range of shapes and grades for precision sanding on wood, fillers, paints and lacquers.

## Environment



### Environmentally-friendly production, competent and ethical waste disposal

For many years we have concerned ourselves with the efficient use of energy and been committed to protecting the environment. We have implemented many measures within our production processes to protect the air, earth and water. We use our energy and raw material resources efficiently and carefully.

#### We care

By joining the «EnAW» (Energy Agency for Industry) programme, we have voluntarily made a commitment to improve energy efficiency and limit our CO<sub>2</sub> emissions as part of our day-to-day operations.

#### We take responsibility

As a «dry factory», we protect nature by not putting untreated industrial wastewater back into the water system (i.e. public waste treatment system). Weekly testing of our surplus industrial wastewater for compliance with regulations demonstrates that our wastewater is clean.

## Quality



### Choosing raw materials, setting quality standards

The comprehensive inspection programme in place in our manufacturing operations enables us to produce premium-quality products. The superior properties of sia products represent excellent value for our customers.

#### We verify

We select our raw materials and their suppliers in accordance with strict criteria on quality, environmental impact and safety. Long-standing partnerships and continuous testing of raw materials ensure good-quality, reliable and fault-free materials.

#### We continually optimise

Our internal process management system (PMS) records and improves important procedures and allows direct intervention in the production process where necessary. In this way we can operate an active, committed opportunity management programme.

## People



### A safe, healthy workplace

We set the standard for an accident and hazard-free workplace. The well-being of people is an integral part of our culture and is based on OHSAS 18001 (Occupational Health and Safety Management Systems).

#### We are clean

We develop products that also effectively help our customers stay healthy. We have had our sanding products tested for dust formation by the Swiss Accident Insurance Fund (SUVA). The results are impressive: we achieve the lowest dust emissions compared with our competitors' products.

#### We set an example

sia Abrasives is one of the first companies in the world to comply with the new OHSAS 18001:2007 standard. We also comply strictly with the recommendations of the FEPA safety standards and publish this, together with other safety information, at [www.sia-abrasives.com](http://www.sia-abrasives.com).



#### «REACH»

##### Regulations for chemicals – a priority project

REACH (Registration, Evaluation and Authorisation of Chemicals) is a European Community regulation dealing with chemicals and has been in force since June 2007. Its purpose is to gather all necessary information about the properties of chemical substances and to examine their use and the associated risks to humans and the environment.

We ensure compliance with REACH by *keeping up-to-date records of all chemical materials and substances* and by taking all necessary steps to meet our REACH obligations.

Composites – hightech abrasives for fibre composites



The demands on materials are growing by the day. Fibre composites often provide the answer. They are used whenever components with excellent combinations of properties are called for.

This brochure provides application-oriented information about the challenges facing the grinding and sanding processes for the transport, wind power, automotive and marine industries.

Careful co-ordination of products with perfectly matched abrasives ensures a systematic and perfect finish on the synthetic fibre composites.

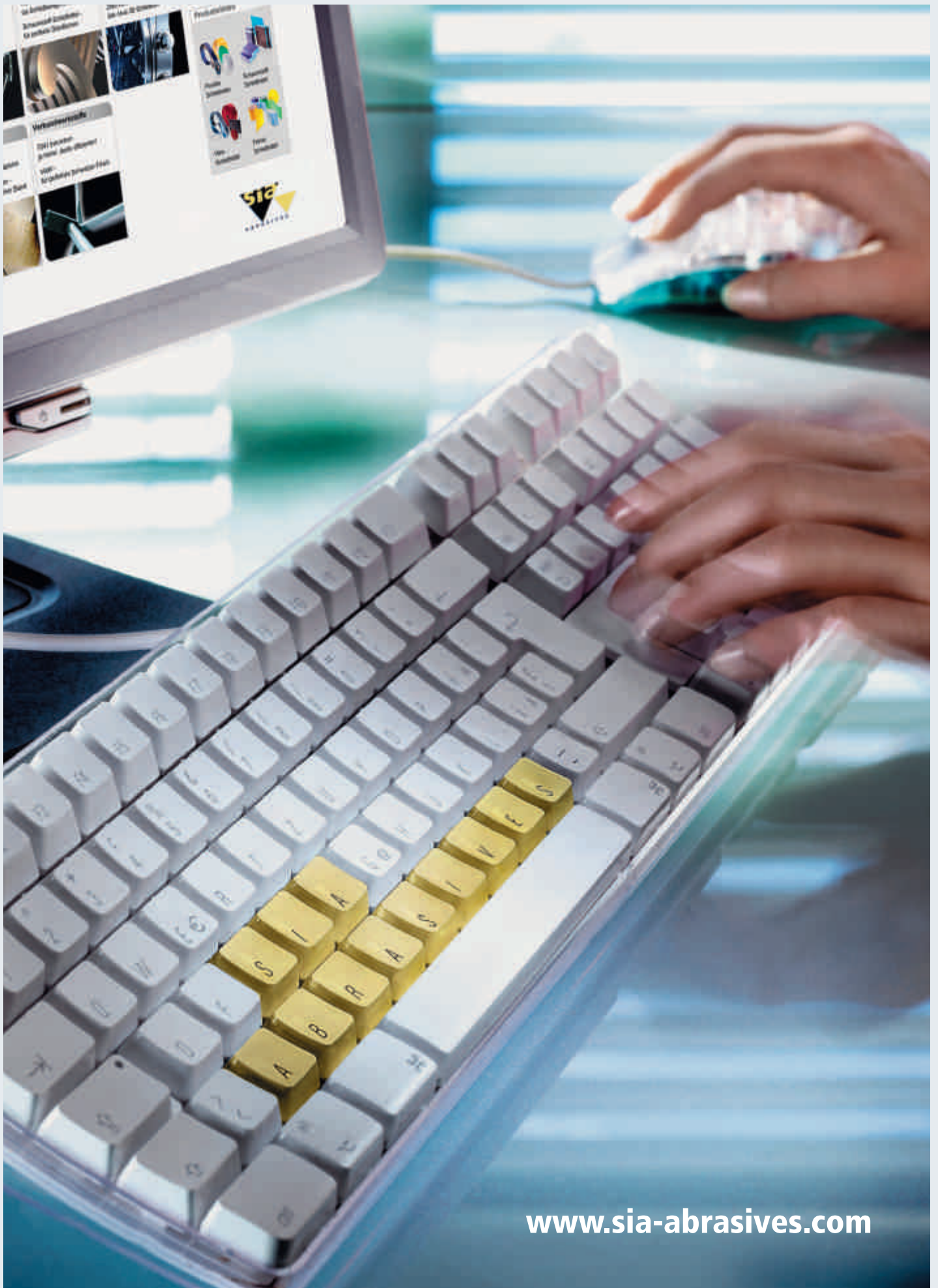
High-performance abrasives for metalworking applications



This brochure provides clearly structured sanding recommendations based on criteria such as material type, type of sanding, sanding job and performance level while taking into account the desired product characteristics (e.g. contact pressure, material removal, stability, finish or flexibility).

Materials such as steels, alloys, high-alloy metals and non-ferrous metals are listed.

All sanding and grinding tasks in the field of metalworking are co-ordinated with matching abrasive products to ensure that a perfect finish is not left to chance.



[www.sia-abrasives.com](http://www.sia-abrasives.com)

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