Belt sanding

Solid wood, veneer, wood-based materials and varnishes
sia Abrasives – Your Key to a Perfect Surface

Many materials hide a secret. They keep their real beauty hidden. Only a professional finish can reveal what is inside. sia Abrasives has devoted itself to achieving perfectly finished surfaces for more than 135 years.

“Finished by sia Abrasives” – the final touch makes all the difference to a wide variety of materials: wood acquires its expressive colour, striking colour contrasts or astounding grain, leather captivates with its subtle nuances, contact lenses ensure the very best acuity of vision, metal glows at the peak of its perfection, marble develops its variety of effects, both robust and filigree, and plastics or the most sophisticated of coatings become the embodiment of functionality and aesthetic appeal.

With our tried and tested surface solutions using top-quality sia products, we would be pleased to help with your specific applications.

www.sia-abrasives.com
Perfect surfaces

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Our commitment

Company
The sia Group is based in Frauenfeld, Switzerland, and is one of the world’s top three suppliers of innovative abrasives. It develops, manufactures and markets complete abrasive systems, customised to specific requirements and applications, for the treatment of every type of surface. Sanding has become a surface treatment technology.

sia Abrasives employs about 1,250 people worldwide and is represented through local partners in more than 80 countries.

Top-quality products from Switzerland
Our careful choice of premium materials, the latest production and manufacturing equipment and sophisticated production technologies enable us to provide sanding products at the highest level. Abrasive materials from sia undergo continuous development based on demanding customer requirements and our detailed analysis of production materials. They represent top-quality Swiss precision and quality workmanship with the aim of a commitment to the perfect surface.

Innovative abrasives

Coated abrasives
Classic coated abrasives and abrasive systems for conventional surface treatment on all types of material.

Nonwoven abrasives
Nonwoven products for preparation, cleaning, finishing and regraining, especially on metal.

Microabrasives
Products on special polyester film to achieve defined surface structures in the graphics, optics and automotive industries.

Foam abrasives
Foam sanding pads in the widest possible range of shapes and grades for precision sanding on wood, fillers, paintwork and varnish.
Environment

Environmental-friendly production, competent and ethical waste disposal
For many years we have concerned ourselves with the efficient use of energy and committed ourselves to protecting the environment. We have implemented many measures within our production processes to protect the air, land 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 CO₂ 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 drains). Weekly analyses of additional industrial wastewater to ensure they meet prescribed values confirm the cleanliness of our wastewater.

Quality

Monitoring raw materials, setting quality standards
We manufacture top-quality products by thorough monitoring during the production process. The superior properties of sia products represent excellent value for our customers.

We verify
We select our raw materials and their suppliers carefully and according to strict criteria. 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 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.

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

We set an example
We comply strictly with the recommendations of the FEPA safety standards and publish this, together with other safety information, at www.sia-abrasives.com

“REACH”
Regulation 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 regarding 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.
Products
<table>
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<th>Application</th>
<th>Product</th>
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</thead>
<tbody>
<tr>
<td>Edge belt</td>
<td>1749 siaral f</td>
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<td>1919 siawood</td>
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<td>2920 siawood</td>
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<td>Cross/long belt</td>
<td>1729 sialac</td>
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<td>2920 siawood</td>
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<td>Solid wood and veneer</td>
<td>Wood-based materials</td>
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<td>Hardwood</td>
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</table>
1729 sialac – for perfect varnish sanding

**Applications**
- Intermediate sanding on industrial varnish systems
- Intermediate sanding of varnish to sand off raised wood fibres
- Removing varnish defects

**Advantages**
- Perfect surface thanks to TopTec
- Dust-free process; antistatic construction gives low dust formation on belt, workpiece and machinery
- Superior surface quality when sanding on industrial varnish systems
- Extra stearate coating prevents belt clogging
- Long product life

**Product profile:**
- Grit: silicon carbide
- Bonding: synthetic resin
- Backing: e-wt paper
- Special coating: stearate
- Grit range: P220 – P800
- Coating: closed
- Equipment: TopTec

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1749 siaral f – for calibration, medium and final sanding of panels

**Applications**
- Sanding edges and surfaces on MDF and HDF sheeting and chipboard
- Coarse and fine sanding of composite/synthetic materials and GRP surfaces
- Fine sanding of surfaces

**Advantages**
- Perfect surface thanks to TopTec
- Dust-free process; antistatic construction gives low dust formation on belt, workpiece and machinery
- Long life when sanding MDF and HDF sheeting and chipboard
- Best surface quality when sanding MDF

**Product profile:**
- Grit: silicon carbide
- Bonding: synthetic resin
- Backing: f-wt paper
- Grit range: P036 – P400
- Coating: closed
- Equipment: TopTec
**1796 sialac** – for fine sanding especially of thin varnish layers

**Product profile:**
- Grit: silicon carbide
- Bonding: hide glue
- Backing: e-wt paper
- Grit range: P180 – P800
- Coating: closed

**Advantages**
- Soft construction and flexible bonding ensure finest-quality surfaces
- For thin, difficult-to-sand varnishes
- Especially for use where surface gloss is paramount and surface quality is more important than high levels of performance

**Applications**
- Keying and matting of primers
- Intermediate sanding of thin varnish layers
- Final sanding to prepare for polishing

**Application**

**1913 siawat fc** – for cross belt use in the finest grits

**Product profile:**
- Grit: semi-friable aluminium oxide, P060 – P1200, silicon carbide, P1500 – P2500
- Bonding: synthetic resin
- Backing: c-wt paper, water-resistant
- Grit range: P060 – P2500
- Coating: closed

**Advantages**
- Very fine finish
- Smooth, even surfaces, even on curved workpieces
- Extremely adaptable to contours
- Available up to grit size P2500

**Applications**
- Can be used on oiled surfaces
- Polishing preparation for high-gloss surfaces
- Fine grit sizes for finishing high-gloss varnish
- Removal of varnish defects

**Application**
sia Abrasives products

1919 siawood – the universal series for wood and varnish sanding

Applications
• Flush sanding of edges, edge bands and protrusions
• Calibration, medium and fine sanding of surfaces
• Keying and matting of primers
• Intermediate sanding of varnishes
• Final sanding to prepare for polishing

Advantages
• Perfect surface thanks to TopTec
• Dust-free process; antistatic construction gives low dust formation on belt, workpiece and machinery
• Universal all-around product for wood and varnish
• Very versatile
• Outstanding performance and long life
• Backing keeps its shape and is unaffected by changes in temperature and humidity

Product profile:
Grit: semi-friable aluminium oxide P036 – P220
Bonding: silicon carbide P240 – P800
Back: synthetic resin
Backing: f-wt paper P036 – P220
d-wt paper P240 – P800
Special coating: stearate P240 – P800
Grit range:
Coating: open P036 – P800
closed P120 – P150
Equipment: TopTec

Application
Cross/long belt
Wide belt
Edge belt

1920 siawood – for hardwood thanks to closed coating

Advantages
• Perfect surface thanks to TopTec
• Dust-free process; antistatic construction gives low dust formation on belt, workpiece and machinery
• High surface quality when sanding hardwood
• High removal rate and fine surface quality on hardwood across the entire grit range
• High surface quality using fine grit sizes

Applications
• Flush sanding of edges, edge bands and protrusions
• Calibration, medium and fine sanding of surfaces
• Intermediate sanding of polyester varnishes

Product profile:
Grit: semi-friable aluminium oxide
Bonding: synthetic resin
Back: f-wt paper
Grit range: P060 – P400
Coating: closed
Equipment: TopTec

Application
Cross/long belt
Wide belt
Edge belt
1939 siawood – for softwood and wood containing oils or resins thanks to open coating

**Advantages**
- Perfect surface thanks to TopTec
- Dust-free process; antistatic construction gives low dust formation on belt, workpiece and machinery
- Ideal for wood that smears or wood containing oils or resins
- Very good finish on solid wood and veneer

**Applications**
- Flush sanding of edges, edge bands and protrusions
- Calibration, medium and fine sanding of surfaces

**Product profile:**
- Grit: semi-friable aluminium oxide
- Bonding: synthetic resin
- Backing: f-wt paper
- Special coating: stearate
- Grit range: P060 – P220
- Coating: open
- Equipment: TopTec

1950 siaspeed fk – film cross belts for perfect high-gloss surfaces

**Advantages**
- Consistent abrasive structure on film for the perfect finish (P800 – 1500)
- Premium series with the longest lifetime thanks to flexible and tough film backing
- New stearate concept
- siafast lamination for perfect surface quality and no excess thickness at the belt joint
- Plain belts for more aggressive sanding

**Applications**
- Efficient fine sanding of high-gloss varnishes
- For stationary polishing preparation with long/cross belts
- Removal of varnish defects such as trapped dust and orange peel effect thanks to perfect flatting

**Product profile:**
- Grit: aluminium oxide
- Coating: special coating process
- Bonding: synthetic resin
- Additional coating: stearate
- Backing: plain film / laminated film
- Grit range: P800 – P1500

**Application**
- Cross/long belt
- Wide belt
- Edge belt
1993 siawood – for final sanding of softwood and wood containing oils or resins

**Product profile:**
- Grit: semi-friable aluminium oxide
- Bonding: synthetic resin
- Backing: f-wt paper
- Grit range: P100 – P180
- Coating: open
- Equipment: TopTec

**Advantages**
- Perfect surface thanks to TopTec
- Dust-free process; antistatic construction gives low dust formation on belt, workpiece and machinery
- Very good finish on solid wood and veneer
- High performance thanks to optimised grit distribution
- Ideal for wood that smears or wood containing oils or resins

**Applications**
- Flush sanding of edges, edge bands and protrusions
- Calibration, medium and fine sanding of surfaces

**Application**
- Cross/long belt
- Wide belt
- Edge belt

2918 siapan z – for coarse sanding of wood-based materials

**Product profile:**
- Grit: semi-friable aluminium oxide
- Bonding: synthetic resin
- Backing: z-wt cloth, polyester
- Grit range: P036 – P120
- Coating: open P036 – P060, closed P080 – P120
- Equipment: TopTec

**Advantages**
- Perfect surface thanks to TopTec
- Dust-free process; antistatic construction gives low dust formation on belt, workpiece and machinery
- High level of lateral belt stability, segmentable
- For continuous, very heavy-duty use, washable
- High removal rate in coarser grit sizes on softwood and hardwood

**Applications**
- Industrial coarse sanding of various types of solid wood
- Coarse to medium sanding in plywood manufacturing
- Coarse to fine sanding of glued solid-wood panels

**Application**
- Wide belt
2920 siawood – universal for heavy-duty wood sanding

Advantages
- Perfect surface thanks to TopTec
- Dust-free process; antistatic construction gives low dust formation on belt, workpiece and machinery
- Long lifetime thanks to robust backing
- High removal rate in coarser grit sizes on softwood and hardwood

Applications
- Flush sanding of edges
- Fine sanding of surfaces and edges
- Coarse to fine sanding in plywood manufacturing
- Coarse to fine sanding of glued softwood panels
- Sanding off old varnish and paint

Product profile:
- Grit: semi-friable aluminium oxide
- Bonding: synthetic resin
- Backing: y-wt cloth, cotton P016 – P050	x-wt cloth, cotton P060 – P320
- Grit range: P016 – P320
- Coating: open: P016 – P120 closed: P150 – P320
- Equipment: TopTec

Application
- Cross/long belt
- Wide belt
- Edge belt
Sanding technology
Grit minerals

The most common materials used to make abrasive grit today are the synthetic minerals aluminium oxide and silicon carbide in their various forms. There is also a growing use of special minerals such as zirconia alumina, ceramic aluminium oxide and diamond. The use of natural minerals such as garnet and emery, however, is rapidly declining. The grit’s hardness and toughness, which are a function of the starting material used, determine the properties and applications of the abrasives.

Applications
- Emery
- Zirconia alumina
- Ceramic aluminium oxide
- Brown aluminium oxide
- Semi-friable aluminium oxide
- White aluminium oxide
- Silicon carbide
- Synthetic diamond

ferrous metals, precious metals
steel alloys
high-alloy steel
wood, metal
varnish, wood, metal
wood, varnish, paint
varnish, sheet materials, stone
hard-finish varnish, glass, stone
Storage

Due to fluctuations in humidity and/or temperature, incorrect storage of abrasives can result in the following negative effects:

- changes in dimensions
- buckling
- reduced sanding performance
- belt slippage
- belt flutter
- breakage of belts or joints

Correct storage means:

- achieving optimum sanding results
- guaranteed product life
- guaranteed good performance
- saving money

Storage conditions:

- temperature: 15 – 25 ºC | 59 – 77 ºF
- relative humidity 40 – 70%
- store abrasives in their original packaging
- hang up belts

Never store abrasives:

- on heaters
- near open windows
- on concrete floors

Safety

For safety reasons, sia Abrasives recommends that its customers wear ear protection, protective eyewear, masks and gloves and that they use a dust-removal system. Where sia Abrasives prints pictograms on products and/or packaging, these must be complied with. The sia abrasives products listed in this catalogue do not contain any hazardous materials (EU Directive 67 / 548 / EEC) and may be disposed of in an environmentally compatible way in modern waste-incineration plants. We refer specifically to the FEPA safety recommendations and the safety datasheets for abrasive products on backing material, which you can download from www.sia-abrasives.com.
TopTec – Top technology for perfect surfaces

controlled scatter

Sia high-tech scatter technology offers the following benefits:

- optimum grit volume
- perfect grit adhesion
- even grit distribution
- tested to FEPA standards

... and, as a result, perfect surface quality

Optimum belt joints

Sia belt joints offer the following benefits:

- high and consistent quality
- tailored to specific applications
- high-quality finishing
- high level of stability and long lifetime
- no sanding faults

... and, as a result, perfect surface quality

Dust-free process

The antistatic treatment of the belts has the following benefits:

- dust-free workpieces
- clean machinery
- efficient dust extraction
- clean environmental air
- longer belt life
- low clogging

... and, as a result, perfect surface quality

With TopTec, the new generation of sanding belts, Sia Abrasives reaches another milestone in the development of application-optimised sanding belts with maximum customer benefit.

Outstanding sanding results and superior surface quality come from the combination of controlled grit distribution, belt joints and backing materials designed to suit the specific application along with antistatic properties that arise from a brand-new production process.
Optimum grit sequence

Using the optimum grit sequence during the sanding process not only gives better sanding results but is also important in achieving the most economical surface treatment. For this reason it is important never to skip more than one grit size at one time!

For example:

- Use next finer grit, e.g. P150 and P180
- Use same grit, e.g. P150 and P150
- Use same grit, e.g. P150 and P150

The main exceptions to this are given below:

<table>
<thead>
<tr>
<th>from</th>
<th>to</th>
<th>Remark</th>
</tr>
</thead>
<tbody>
<tr>
<td>Contact belt sanding</td>
<td>Pad belt sanding</td>
<td>Use next finer grit, e.g. P150 and P180</td>
</tr>
<tr>
<td>Cross belt sanding</td>
<td>Pad belt sanding</td>
<td>Use same grit, e.g. P150 and P150</td>
</tr>
<tr>
<td>Pad belt sanding</td>
<td>Orbital sanding</td>
<td>Use same grit, e.g. P150 and P150</td>
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## Cutting speeds

<table>
<thead>
<tr>
<th>Material</th>
<th>Contact belt</th>
<th>Pad belt</th>
<th>Long/cross belt</th>
<th>Edge belt</th>
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<tbody>
<tr>
<td>Plywood</td>
<td>20 – 30 m/s</td>
<td>10 – 22 m/s</td>
<td>10 – 22 m/s</td>
<td>12 – 18 m/s</td>
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<tr>
<td>Chipboard/MDF</td>
<td>20 – 30 m/s</td>
<td>10 – 22 m/s</td>
<td>10 – 22 m/s</td>
<td>12 – 18 m/s</td>
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<tr>
<td>Solid wood</td>
<td>20 – 30 m/s</td>
<td>10 – 22 m/s</td>
<td>10 – 22 m/s</td>
<td>12 – 18 m/s</td>
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<tr>
<td>Veneer</td>
<td>10 – 22 m/s</td>
<td>10 – 22 m/s</td>
<td>10 – 22 m/s</td>
<td>12 – 18 m/s</td>
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<td>33 – 72 ft/s</td>
<td>33 – 72 ft/s</td>
<td>33 – 72 ft/s</td>
<td>39 – 58 ft/s</td>
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<tr>
<td>Varnish</td>
<td>1 – 4 m/s *</td>
<td>1 – 4 m/s *</td>
<td>1 – 4 m/s *</td>
<td>1 – 4 m/s *</td>
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<tr>
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<td>3 – 13 ft/s *</td>
<td>3 – 13 ft/s *</td>
<td>3 – 13 ft/s *</td>
<td>3 – 13 ft/s *</td>
</tr>
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</table>

*High cutting speeds for the intermediate sanding of varnish (of 8 – 12 m/s or 26 – 39 ft/s) are generally only for saturated polyester varnishes.*

## Feed rates

<table>
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<tr>
<th>Material</th>
<th>Contact belt</th>
<th>Pad belt</th>
<th>Long/cross belt</th>
<th>Edge belt</th>
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<tbody>
<tr>
<td>Plywood</td>
<td>5 – 10 m/min</td>
<td>8 – 15 m/min</td>
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<td>16 – 33 ft/min</td>
<td>26 – 49 ft/min</td>
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<tr>
<td>Chipboard/MDF</td>
<td>20 – 30 m/min</td>
<td>10 – 22 m/min</td>
<td>10 – 22 m/min</td>
<td>8 – 15 m/min</td>
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<td>66 – 98 ft/min</td>
<td>33 – 72 ft/min</td>
<td>33 – 72 ft/min</td>
<td>26 – 49 ft/min</td>
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<tr>
<td>Solid wood</td>
<td>5 – 10 m/min</td>
<td>8 – 15 m/min</td>
<td>8 – 15 m/min</td>
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<td>16 – 33 ft/min</td>
<td>26 – 49 ft/min</td>
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<td>Veneer</td>
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<td>26 – 49 ft/min</td>
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<td>Varnish</td>
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<td>33 – 59 ft/min</td>
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## Maximum removal rates

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<tbody>
<tr>
<td></td>
<td>Grit size</td>
<td>Roller</td>
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<tr>
<td>Solid wood</td>
<td>P036</td>
<td>Steel/hard rubber roller</td>
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<tr>
<td>Veneer</td>
<td>P040</td>
<td>Steel/hard rubber roller</td>
</tr>
<tr>
<td>Wood-based materials</td>
<td>P060</td>
<td>Steel/hard rubber roller</td>
</tr>
<tr>
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<td>P080</td>
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