Sanding Systems for the Automotive Industry





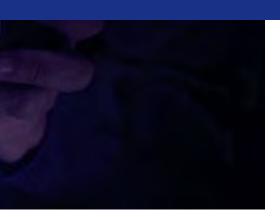






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sia's commitment



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 of the highest level. Abrasive materials from sia undergo continuous development based on demanding customer requirements and our detailed analysis of production materials. They thus represent the finest examples of Swiss precision and quality with one goal: a commitment to the perfect surface.

Continuous development

External audits combined with more than 25 inhouse inspections and risk analyses each year covering all areas of our operations allow us to be competitive and to maintain a sustained development programme to ensure the commercial success of sia Abrasives.

By being certified to ISO 14001, ISO 9001 and OHSAS 18001, sia Abrasives is committed to an active programme of environmental protection, to compliance with quality requirements, and to ensuring health and safety at work.

Priority projects

Regulations for chemicals

REACH (Registration, Evaluation and Authorisation of Chemicals) concerns 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.

Health and safety team

Our newly formed Health and Safety Team, which includes among others members of the sia staff, ensures the progress of ongoing projects, tests new ideas, and puts new health and safety schemes into action.



sia's commitment







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, earth and water. We use our energy and rawmaterial 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 $\mathrm{CO_2}$ 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 testing of additional 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 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 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

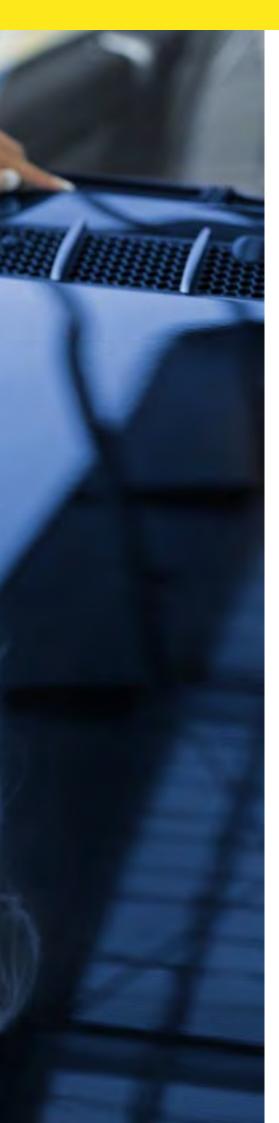
sia Abrasives is one of the first companies in the world to comply with the new OHSAS 18001:2007 standard. We also comply strictly with the recommendations of the FEPA safety standards and publish this, together with other safety information, at www.sia-abrasives.com.











Our System - Your Advantage

sia Abrasives develops, manufactures and markets complete abrasive systems, tailored to specific requirements and applications, for the treatment of every type of surface.

The comprehensive advantages for the customer are summarised in the nine categories below:

- Customer advice
- Surface technology
- Treatment processes
- Abrasives
- Tools and accessories
- Application training
- Documentation
- Packaging
- V Distribution

Customer advantages



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.

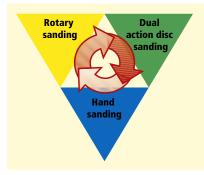


Surface technology

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 processes

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

Products with Swiss quality

Abrasives from sia Abrasives are manufactured with great care from selected raw materials, using the latest technology.

Our range includes products for every kind of industrial and commercial application from rough 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 for ensuring surface quality.

Customer advantages



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 containing 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 perfect surfaces. In particular, we provide references to FEPA safety recommendations and safety datasheets dealing with abrasives, all of which can be downloaded from www.sia-abrasives.com.

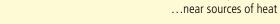


Packaging Perfect protection

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



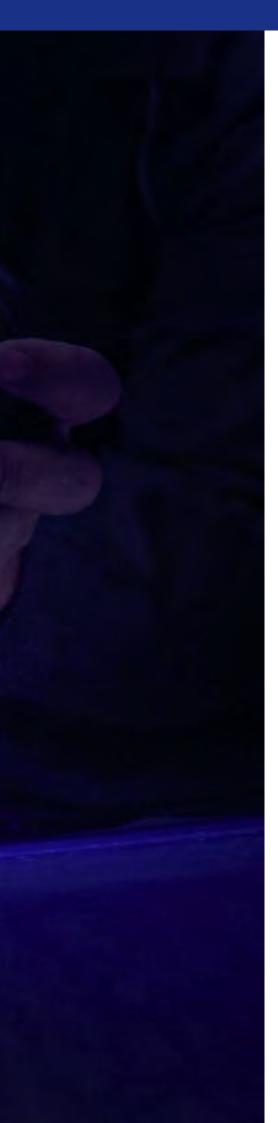


Distribution Punctual and reliable

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.





Sanding Systems

All products are categorised within the groupings coarse sanding, fine sanding or finishing operations to allow us to provide clear recommendations and working instructions.

- ▼ Coarse sanding Bodywork and body-in-white
- ▼ Fine sandingBody filler, sanding of primer filler and lacquers
- Micro-finishingRefinishing of lacquered surfaces

Coarse sanding system

Kind of work	Application recommendation	sia product
Cutting of car body panels	ø 75 mm Ideal cutting speed 20'000 Max. cutting speed 20'100	
Sanding of welding seams and burrs	ø 115 mm Ideal cutting speed 10'000 Max. cutting speed 13'000	
 Grinding of small and hard-to-reach areas Grinding of welding seams 	ø 50 mm Ideal cutting speed 20'000 Max. cutting speed 30'000 ø 75 mm Ideal cutting speed 18'000 Max. cutting speed 27'000	O rpm
 Removal of old paint and rust in hard-to-reach areas Treatment of fine welding seams 	ø 50 mm Ideal cutting speed 20'000 Max. cutting speed 30'000	O rpm O rpm
Grinding of small or hard to-get-at areas	ø 50 mm Ideal cutting speed 15'000 Max. cutting speed 30'000 Ø 75 mm Ideal cutting speed 13'000 Max. cutting speed 27'000	O rpm
 Removal of old paint Bright grinding of corroded areas 	ø 115 mm Ideal cutting speed 8'000 Max. cutting speed 11'000	
Grinding of body panels, lacquer, stone protection, etc.	ø 115 mm Ideal cutting speed 6'000 Max. cutting speed 8'500	

Artno	Grit	Dimensions	sia accessories	Artno	Dimensions
9189 siawheel cut-off wl 0020.0096.01 (T8443)	neel	ø 75 / 10 / 1 mm	T	Mandrel with shaft 0020.0113.01 (T4801) 6 mm 0020.1086.01 (T4800) 1/4"	19 x 52 mm 19 x 52 mm
4924 siamet discs 9386.9974 (T6406)	P036 P040 P060	ø 115 mm ø 115 mm ø 115 mm	0	Back plate hard 0020.0348.02 (T7001) M14	ø 115 mm
9206 siamet x siafix discs 0020.1378.01 (T3871) 0020.1379.01 0020.1382.01 (T3872) 0020.1383.01	P036 P060 P036 P060	ø 50 mm ø 50 mm ø 75 mm ø 75 mm	4	Back plate flexible with shaft 0020.0132.01 (T8551) 1/4" + 6 mm 0020.0133.01 (T8551) 1/4" + 6 mm	ø 50 mm quick shutter ø 75 mm quick shutter
2824 Flapfix siafix 0020.4323.01 (T5054) 0020.4324.01 (T5054) 0020.4325.01 (T5054)	K040 K060 K080	ø 50 mm ø 50 mm ø 50 mm	4	Back plate flexible with shaft 0020.0132.01 (T8551) 1/4" + 6 mm	ø 50 mm quick shutter
9208 scm siafix discs 0020.0126.01 (T3875) 0020.2340.01 0020.0127.01 (T3876) 0020.0129.01 (T3876) 0020.2343.01 0020.0130.01	coarse medium fine coarse medium fine	ø 50 mm ø 50 mm ø 50 mm ø 75 mm ø 75 mm ø 75 mm	41	Back plate flexible with shaft 0020.0132.01 (T8551) 1/4" + 6 mm 0020.0133.01 (T8551) 1/4" + 6 mm	ø 50 mm quick shutter ø 75 mm quick shutter
1919 siawood TopTec sia 5903.5767 (T6077)	Fast discs P040 P060 P080 P100 P120	ø 115 mm ø 115 mm ø 115 mm ø 115 mm ø 115 mm	•	Back plate flexible for siafast 0020.0172.01 (T8584) M14 0020.2325.01 (T8604) 5/8"	ø 115 mm ø 115 mm
6260 scm ultradisc discs 6723.5318.2921 (N6711) 6723.5318.4921 6723.5318.5921	coarse medium fine	ø 115 mm ø 115 mm ø 115 mm	•	Back plate flexible for scm 0020.0396.02 (T6977) M14	ø 115 mm

Other dimensions and grit numbers upon request

Coarse sanding

	Kind of work	Application	recommendation	sia product
	 Removal of old paint Removal of stone protection Grinding, cleaning of rabbets, edges and hard to-get-at areas 	ø 100 mm	Ideal cutting speed 3'500 UPM Max. cutting speed 6'000 UPM	0
TIES TO	 Removal of old paint Removal of stone protection 	ø 115 mm	Ideal cutting speed 6'000 UPM Max. cutting speed 8'000 UPM	©
	 Removal of old paint Removal of stone protection Grinding, cleaning of rabbets, edges and hard to-get-at areas (high flexibility) 	ø 100 mm	Ideal cutting speed 3'500 UPM Max. cutting speed 6'000 UPM	
	Removing masking film	ø 88 mm	Ideal cutting speed 2'000 UPM Max. cutting speed 4'000 UPM	00

Notes:

- Aluminium: Treat using at least one grit size finer than for steel.Contact corrosion: Never use the same abrasive carrier on different metallic surfaces.

Art.-no Grit Dimensions **sia accessories** Art.-no Dimensions

6300 siastrip discs

4329.5929.1721 (N3010) K040 ø 100 mm / 6 mm



Mandrel fitted from the front 0029.0287.01 (N3866) 6 mm shaft

6300 sia Powerstrip

1733.1719.1721 (N2065) K040 ø 115 mm / 22 mm

6140 siavlies sd (super duty)

0996.9356.3911 (N2008) heavy medium \emptyset 100 mm / 12 mm



Mandrel fitted from the back 0029.0009.01 (N3843) 6 mm shaft

9999 strip eraser siarad

0020.3983.01 (T7812)

ø 88 mm x 15 mm 5/16" 6 mm shaft

Other dimensions and grit numbers upon request

Fine sanding - machine sanding

	Kind of work	Application recommendation	sia product
	Sanding down of oxidised top coatsKeying and feathering edges	K060 K080 - P150 Orbit for dual action disc sander: 10.0 - 5.0 mm	
	 Flatting of body filler Final sanding of body filler 	K080 - P150 K180 - P280 Orbit for dual action disc sander: 10.0 - 5.0 mm	0
	Keying of factory primers	P240 Orbit for dual action disc sander: 10.0 - 5.0 mm	
	Flatting of primerFine sanding of primer	P280 - P360 P400 - P600 Orbit for dual action disc sander: 5.0 - 2.5 mm	0
	Keying of old paint	P500 - P800 Orbit for dual action disc sander: 5.0 - 2.5 mm	
100	Cleaning/refining after primer sanding	ultra fine Orbit for dual action disc sander: 7.0 - 5.0 mm	•
	Producing a matt finish on new components and factory primers	very fine Orbit for dual action disc sander: 10.0 - 5.0 mm	
	Blacking prior to sanding of body filler and primer filler		<u>و</u>

Grit Dimensions sia accessories Art.-no Dimensions Art.-no

1950 siaspeed siafast discs 7 holes

8438.1710 (T2021) K060 - K080 ø 150 mm

P100 - P280 ø 150 mm

1950 siaspeed siafast discs 9 holes

2237.4737 (T2022) K060 - K080 ø 150 mm

P100 - P280 ø 150 mm

1950 siaspeed siafast discs 15 holes

7546.2948 (T2023) K060 - K080 ø 150 mm

P100 - P280 ø 150 mm Air chamber backing pad 15 holes (5/16" + M8)

Air chamber backing pad 15 holes (5/16" + M8)

Air chamber backing pad 7 holes (5/16" + M8)

Aerodynamic pad 7 holes (5/16" + M8)

ø 150 mm

soft

soft

hard

soft

0020.2296.01 (T7200)

0020.2334.01 (T7201)

0020.3509.01 (T7206)

0020.4091.01 (T7203)

0020.4092.01 (T7204)

0020.4091.01 (T7203) ø 150 mm hard

0020.4092.01 (T7204) ø 150 mm soft

1950 siaspeed siafast discs 7 holes

8438.1710.0280 (T2021) P280 - P600 ø 150 mm

P280 - P600

Air chamber backing pad 7 holes (5/16" + M8)

0020.2334.01 (T7201) ø 150 mm soft 0020.2335.01 (T7202) ø 150 mm extra soft

Aerodynamic pad 7 holes (5/16" + M8)

0020.3509.01 (T7206) ø 150 mm soft 0020.3510.01 (T7207) ø 150 mm extra soft

Air chamber backing pad 15 holes (5/16" + M8) ø 150 mm 0020.4092.01 (T7204) ø 150 mm 0020.4093.01 (T7205) ø 150 mm extra soft

1950 siaspeed siafast discs 9 holes

(T2022)

2237.4737

Air chamber backing pad 15 holes (5/16" + M8)

0020.4092.01 (T7204) ø 150 mm soft ø 150 mm 0020.4093.01 (T7205) extra soft

1950 siaspeed siafast discs 15 holes

7546.2948 (T2023) P280 - P600 ø 150 mm

6120 siavlies speed siafast discs

7866.2539.8715 (N8996) ultra fine (grey) ø 150 mm

Aerodynamic pad 7 holes (5/16" + M8)

0020.3509.01 (T7206) ø 150 mm soft 0020.3510.01 (T7207) ø 150 mm extra soft

Air chamber backing pad 15 holes (5/16" + M8)

0020.4092.01 (T7204) ø 150 mm soft 0020.4093.01 (T7205) ø 150 mm extra soft

6120 siavlies speed siafast discs

0020.2302.01

7866.2539.6921 (N8996) very fine (red) ø 150 mm

Air chamber backing pad 7 holes (5/16" + M8)

0020.4092.01 (T7204) ø 150 mm soft 0020.4093.01 (T7205) ø 150 mm extra soft

Aerodynamic pad 7 holes (5/16" + M8)

0020.3509.01 (T7206) ø 150 mm soft extra soft

0020.3510.01 (T7207) ø 150 mm

Sanding guide powder set Replacement cartridges

0020.2301.01 (T9032) 6 cartridges à 30 g

Set incl. 2 cartridges à 30 g

(T9032)

Fine sanding — hand sanding

	Kind of work	Application recommendation	sia product
	Flatting of body filler	K040 - P150	
	 Flatting of body filler Flatting of primer Fine sanding of primer 	K080 - P180 P240 - P360 P400 - P600	
	Flatting of body filler and primer on convex and concave parts	K080 - P360	
	Flatting of body fillerFlatting of primer	K080 - P360 P400 - P600	
The same	Sanding of primer and old paint	Application of previously used ø 150 mm discs as an enhancement to mechanical sanding	

Grit Dimensions sia accessories Art.-no Dimensions Art.-no 1950 siaspeed siafast strips 14 holes Body file 14 holes 5618.8422 (T2043) K040 + K06070 x 420 mm 0020.3924.01 (T7046) 70 x 400 mm 5618.8422 (T2043) K080 - P150 70 x 420 mm Connector for extraction system Hard cellular rubber siaklett Hand sanding block 8 holes 1950 siaspeed siafast strips 8 holes 0020.3926.01 (T7046) 70 x 125 mm 8457.3676 (T2040) K080 - P600 70 x125 mm Connector for extraction system Hard cellular rubber siaklett Hand sanding block 8 holes 1950 siaspeed siafast strips 8 holes 0020.3922.01 (T7046) 0062.9565 (T2041) K080 - P600 70 x198 mm 70 x 198 mm Connector for extraction system Hard cellular rubber siaklett Hand sanding block flexible 18 holes 1950 siaspeed siafast strips 18 holes 0020.3923.01 (T7046) 115 x 230 mm 5348.63 (T2042) K080 - P600 115 x 228 mm Connector for extraction system flexible plate siaklett 1950 siaspeed siafast strips 18 holes Hand sanding block flexible 18 holes 5348.6389 (T2042) K080 - P360 115 x 228 mm 0020.39xx.01 (T7046) 115 x 228 mm Connector for extraction system flexible plate siaklett **Dust extraction hose for hand sanding tools** 0020.3925.01 (T7046) ø 25 mm / ø 21 mm x 4500 mm Adapter for dust extraction hose 0020.4349.01 (T7046) ø 29 mm / ø 21 mm x 47 mm 1950 siaspeed siafast strips without holes Hand sanding block for dry sanding 70 x 125 mm without holes 6783.9190 (T2050) K080 - P400 70 x 125 mm 0020.0342.01 (T7055) double-sided medium hard / extra soft siaklett

Round hand sanding block

ø 150 mm without holes

soft siaklett

0020.0364.02 (T7060)

Other dimensions and grit numbers upon request

ø 150 mm

1950 siaspeed siafast discs

Fine sanding — hand sanding

Kind of work	Application recomme	endation	sia product
 Initial sanding of curves, edges and rounded shapes Final sanding of filler in hard-to-reach areas Sanding for blending 	P150 - P320 P320 - P500 P500 - P600	Type of sanding: dry	
 Initial sanding of curves, edges and rounded shapes Final sanding of filler in hard-to-reach areas Sanding for blending 	medium - fine fine - extra fine super fine - micro fine	Type of sanding: dry Type of sanding: dry Type of sanding: dry	
 Final sanding of filler in hard-to-reach areas Producing a matt finish on lacquer surfaces in hard-to-reach areas 	K600 - K800 K800 - K1000	Type of sanding: wet Type of sanding: wet	
Flatting of filler, producing a matt finish on lacquers prior to final lacquering	P600 - P1200	Type of sanding: wet	

Artno		Grit	Dimensions	sia accessories	Artno	Dimensions
1950 siaspeed 2237.4334	siasoft rol (T2150)	lls perforated P150 - P600	115/125 mm x 25 m			
1950 siaspeed 4564.0566	siasoft str (T2151)	r ips P150 - P600	115 x 140 mm			
9214 Flat Pad 0020.3794.01 0020.3795.01 0020.3796.01 0020.3797.01 0020.3798.01	(T2275)	medium fine extra fine super fine micro fine	115 x 140 mm 115 x 140 mm 115 x 140 mm 115 x 140 mm 115 x 140 mm			
7940 siaair vel 6329.7598	vet siafast (T3308)	t strips K600 K800 K1000	115 x 140 mm 115 x 140 mm 115 x 140 mm			
1913 siawat fc 3100.3713	sheets (T6021) (T6021) (T6021) (T6021)	P600 P800 P1000 P1200	230 x 280 mm 230 x 280 mm 230 x 280 mm 230 x 280 mm		Hand sanding block with 0020.0389.01 (T8184) Flexible hand sanding to 0020.3713.01 (T5099)	70 x 125 mm

Other dimensions and grit numbers upon request

Fine sanding — hand sanding

Kind of work	Application recommendation	sia product
Scuffing of new components and factory primers before applying primer filler	very fine	0
		4
Scuffing of lacquers before painting	ultra fine	9
		*
Scuffing of lacquers, possible to polish-up after blending	micro fine	9
		-

Artno	Grit	Dimensions	sia accessories	Artno	Dimensions
6120 siavlies speed rolls 9327.7238.6921 (N7056) 3144.5052.6921 (N7900) 2344.9555.6921 (N7013)	very fine (red) very fine (red) very fine (red)	100 mm x 10 m 115 mm x 10 m 125 mm x 10 m			
6120 siavlies speed strips 0055.7679.6921 (N7002)	very fine (red)	115 x 152 mm			
6120 siavlies speed strips 4132.9840.6921 (N7058)		115 x 229 mm			
6120 siavlies speed rolls 9327.7238.8715 (N7056) 3144.5052.8715 (N7900) 2344.9555.8715 (N7013)	ultra fine (grey) ultra fine (grey) ultra fine (grey)	100 mm x 10 m 115 mm x 10 m 125 mm x 10 m		Matting paste siamat 0020.4174.01 (T7026)	500 ml
6120 siavlies speed strips 0055.7679.8715 (N7002)	perforated ultra fine (grey)	115 x 152 mm			
6120 siavlies speed strips 4132.9840.8715 (N7058)	ultra fine (grey)	152 x 229 mm			
6120 siavlies speed rolls 3144.5052.9913 (N7900)	micro fine (gold)	115 mm x 10 m			
6120 siavlies speed strips 0055.7679.9913 (N7002)	perforated micro fine (gold)	115 x 152 mm			
6120 siavlies speed strips 4132.9840.9913 (N7058)	micro fine (gold)	115 x 229 mm			

Other dimensions and grit numbers upon request

Fine sanding – Lacquer repair

	Kind of work	Application recommendation	sia product
	Scuffing of old and new paint for blending	P800 - P1000 Orbit for dual action disc sander: 3.0 - 2.5 mm	
	Producing a matt finish on conventional lacquers prior to application of filler	K360 - K500 Type of sanding: wet	
	 Producing a matt finish on conventional lacquers for blending Producing a matt finish on areas to be sprayed 	K600 - K800 Type of sanding: wet K1000 - K2000 Type of sanding: wet	•
	 Producing a matt finish on scratch-resistant lacquers prior to application of filler Producing a matt finish on scratch-resistant lacquers for blending 	K500 Type of sanding: wet K1000 Type of sanding: wet	
-03	Producing a matt finish on old lacquer	very fine ultra fine micro fine Orbit for dual action disc sander: 5.0 - 2.5 mm	
	• Producing a matt finish for blending	very fine ultra fine micro fine Orbit for dual action disc sander: 5.0 - 2.5 mm	

Artno		Grit	Dimensions	sia accessories	Artno	Dimensions
1990 siamic sia	fast discs (T3585)	7 holes P800	ø 150 mm	(6)	Air chamber backing pa 0020.2335.01 (T7202)	ad 7 holes (5/16" + M8) ø 150 mm extra soft
		P1000	ø 150 mm		Aerodynamic pad 7 hol 0020.3510.01 (T7207)	es (5/16" + M8) ø 150 mm extra soft
					Air chamber backing pa 0020.4093.01 (T7205)	ad 15 holes (5/16" + M8) ø 150 mm extra soft
1990 siamic sia	ıfast discs	9 holes		_	Intermediate Pad with	Microklett
3100.8914	(T9002)	P800	ø 150 mm	100.00	0020.2615.01 (T6740)	ø 150 mm 7 holes
		P1000	ø 150 mm		0020.4546.01 (T6744)	ø 150 mm 15 holes
7940 siaair vel	vet siafast	t discs			Air chamber backing pa	ad 7 holes (5/16" + M8)
5163.3687	(T3307)	K600 - K2000	ø 150 mm	(0)	0020.2335.01 (T7202)	ø 150 mm extra soft
					Air chamber backing na	ad 15 holes (5/16" + M8)
					0020.4093.01 (T7205)	ø 150 mm extra soft
7940 siaair vel	vet siafast	t discs			Aerodynamic pad 7 hol	es (5/16" + M8)
3647.2462	(T3306)	K1000 K2000	ø 80 mm ø 80 mm	9	0020.3510.01 (T7207)	ø 150 mm extra soft
7240 siacarat s	iafast disc	rs			Backing pad 7 holes (5/	16" , MO\
9967.9911	(T5096)	K500	ø 150 mm		0020.1988.01 (T9012)	ø 77 mm soft
9967.9911	(T5096)	K1000	ø 150 mm	9	,	
7240 siacarat s	infact dis				Protection Disc	
8451.8686	(T5095)	K500	ø 80 mm		0020.3453.01 (T3309)	ø 150 mm
8451.8686	(T5095)	K1000	ø 80 mm			
6120 siavlies s	peed discs	siafast		100	Matting paste siamat	
7866.2539.6921	(N8996)	very fine (red)	ø 150 mm	A	0020.4174.01 (T7026)	500 ml
7866.2539.8715	(N8996)	ultra fine (grey)	ø 150 mm			
7866.2539.9913	(N8996)	micro fine (gold)	ø 150 mm			



Protection Disc 0020.3453.01 (T3309) ø 150 mm

Micro-finishing – refinishing of lacquers

Kind of work	Application recommendation	sia product
Scuffing of old and new paint for blending	P1200 - P1500 Type of sanding: dry Orbit for dual action disc sander: 3.0 - 2.5 mm	
 Sanding out of paint runners Sanding out of orange-peel effects and dust inclusions 	P1200 - P1500 P1500 - P2500 Type of sanding: nass	
Sanding out of dust inclusions in conventional lacquers (siafast)	P1500 - P2500 Type of sanding: wet	•
Fine sanding of flatted surfaces as a preliminary step prior to polishing	K2000 Type of sanding: wet K3000 Type of sanding: wet K4000 Type of sanding: wet Orbit for dual action disc sander: 3.0 - 2.5	

Artno		Grit	Dimensions	sia accessories	Artno Dimensions
1990 siamic si 9301.5854 1990 siamic si 3100.8414	(T3585)	P1200 P1500	ø 150 mm ø 150 mm ø 150 mm ø 150 mm		Air chamber backing pad 7 holes (5/16" + M8) 0020.2335.01 (T7202) ø 150 mm extra soft Aerodynamic pad 7 holes (5/16" + M8) 0020.3510.01 (T7207) ø 150 mm extra soft Air chamber backing pad 15 holes (5/16" + M8) 0020.4093.01 (T7205) ø 150 mm extra soft Intermediate Pad with Microklett 0020.2615.01 (T6740) ø 150 mm 7 holes 0020.4546.01 (T6744) ø 150 mm 15 holes
1913 siawat f 5980.9923	c siafast st (T4827)	rips P1200 P1500 P2000 P2500	70 x 125 mm 70 x 125 mm 70 x 125 mm 70 x 125 mm		Hand sanding block for dry/wet sanding 0020.0343.01 (T7053) 70 x 125 mm 2 Seiten hard/soft Microklett
1913 siawat f 9219.5517	c sheets (T6140)	P1200 P1500 P2000 P2500	140 x 230 mm 140 x 230 mm 140 x 230 mm 140 x 230 mm		Hand sanding block with slit, no klett 0020.0389.01 (T8184) 70 x 125 mm
1913 siawat f 3100.3713	c sheets (T6021)	P1200 P1500 P2000 P2500	230 x 280 mm 230 x 280 mm 230 x 280 mm 230 x 280 mm	*	Flexible hand sanding block 0020.3713.01 (T5099) 60 x 128 x 15 mm
1913 siawat f 4269.7970	c siafast Da (T8168)	P1500 P2000 P2500	ø 37 mm ø 37 mm ø 37 mm	1	Finiblock for siafast 0020.3285.01 (T8550) ø 30 mm round hard/soft Mikroklett
7940 siaair ve 3647.2462	(T3306)	K2000 K3000 K4000	ø 80 mm ø 80 mm ø 80 mm	9	Air chamber backing pad 7 holes (5/16" + M8) 0020.2335.01 (T7202) Ø 150 mm extra soft Air chamber backing pad 15 holes (5/16" + M8) 0020.4093.01 (T7205) Ø 150 mm extra soft
5163.3687	(T3307)	K2000 K3000 K4000	ø 150 mm ø 150 mm ø 150 mm		Aerodynamic pad 7 holes (5/16" + M8) 0020.3510.01 (T7207) Ø 150 mm extra soft Protection Disc 0020.3453.01 (T3309) Ø 150 mm Backing pad (5/16" + M8) 0020.1988.01 (T9012) Ø 77 mm soft

Sanding system for micro-finishing - Polishing system

10 helpful polishing tips

- 1. We recommend using siashine magic at every stage of the process to give surfaces the most brilliant finish possible.
- 2. Use the recommended pad and polish combinations to achieve the best possible results.
- 3. Apply the polishing compound to an area slightly smaller than the area to be polished!
- 4. Clean pads = glistening results dirty pads cause scratches!
- 5. Cleaning pads regularly with water will prolong their life time considerably.
- 6. Dry polishing "burns" the surface do not allow the polishing compound to dry out 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.

Typical applications



- Buffing up old lacquer
- After sanding surfaces use 7940 siaair velvet K2000



- Polishing of sanded out orange peel effects (sanded with 1990 siamic P1500 and refined using 7940 siaair velvet K2000/K3000)
- Polishing of sanded out paint runners (sanded with 1913 siawat P1200 and refined using 7940 siaair velvet K2000/K3000)
- Polishing of sanded out dust inclusions (sanded with 1913 siawat P2000, then refine using 7940 siaair velvet K3000)
- Polishing of sanded surfaces with 7940 siaair velvet K4000



- Removing overspray
- Removing fine scratches
- Finishing of bright colours after use of lambskin
- Intermediate step for dark and sensitive colours



- Removal of holograms
- Finishing of dark and sensitive colours

Accessories



siashine magic* 0020.3917.01 (T6420)

- siashine magic* Effortless to use
 - Removes and prevents holograms
 - Non-streak shine on all paints
 - * siashine magic supplied without spray head



Spray head for siashine magic 0020.3618.01 (T6420)

• High-quality spray head with Viton seal

Polishing paste



siashine speed 0020.3615.01 (T6420)



siashine finish 0020.3616.01 (T6420)

Polishing discs



Cambskin disc 0020.0154.01 ø 100 mm (T8559) 0020.0265.01 ø 170 mm (T8426)



0020.2018.01 ø 170 mm (T8427)

Foam disc hard

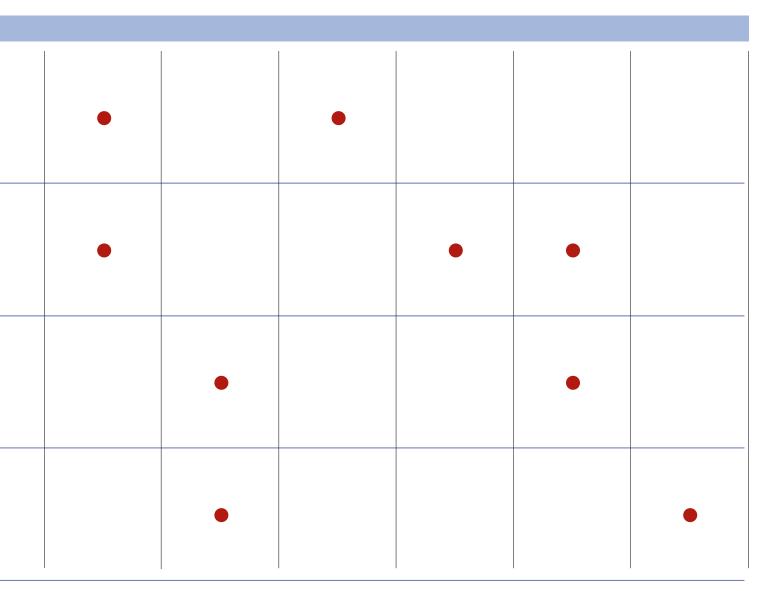


0020.0154.01 ø 100 mm (T8559) 0020.0264.01 ø 170 mm (T8427)

Foam disc soft



Foam disc extrasoft 0020.0261.01 ø 100 mm (T8971) 0020.0262.01 ø 170 mm (T8970)





Micro fibre cloth sia Policloth 0020.3185.01 (T8496) 380 x 380 mm



Back plate with siaplast 0020.1907.01 (T8425) M14

Cutting speed recommendation

ø 100 mm = Ideal cutting speed 2'200 rpm, max. cutting speed 3'000 rpm ø 170 mm = Ideal cutting speed 1'200 rpm, max. cutting speed 1'800 rpm



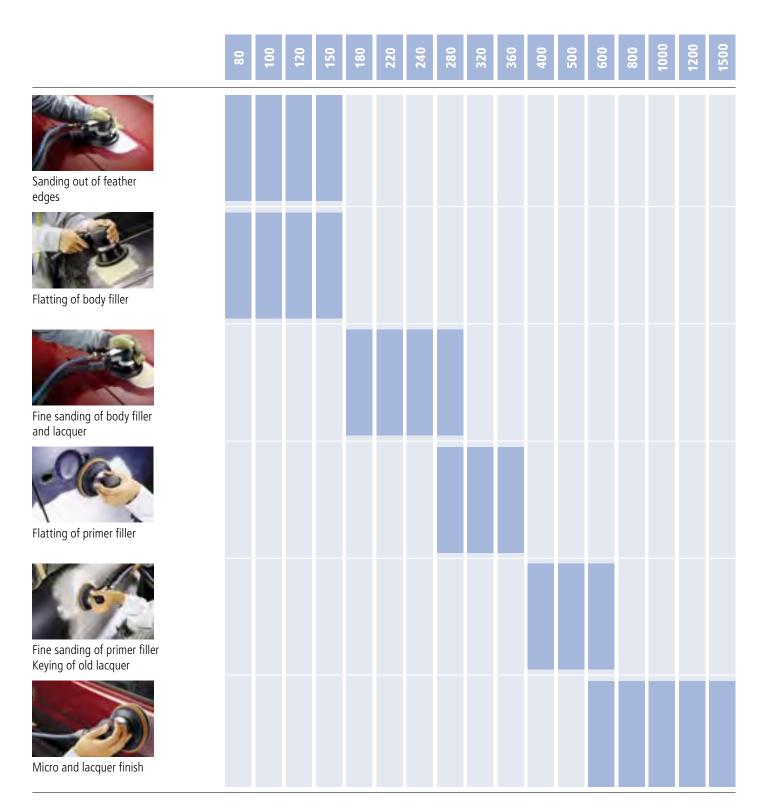


Sanding Technology

The variety of potential applications for flexible abrasives has led to the development of numerous sanding technologies. In order to achieve perfect surface results, sanding and grinding must be considered as part of a complete system, which requires workpieces, machines, tools and applications to be optimally matched to each other.

- Selecting the right grit
- Comparison of wet and dry sanding
- Backing pad/orbit recommendations

Selecting the right grit



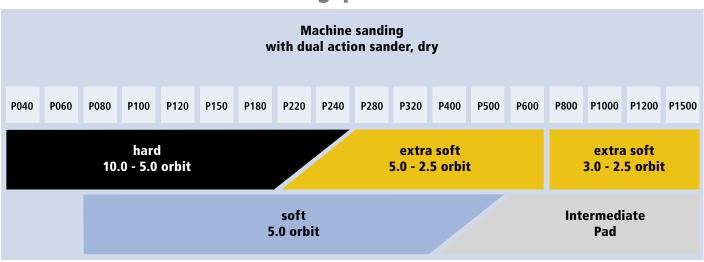
Grit size recommendations at a glance (machine sanding)

Grit size	Application	Orbit for dual action disc sander
P60	Removal of weathered lacquers	10 - 5 mm
P80 + P150	Sanding out of feather edges and flatting of body filler	10 - 5 mm
P240	Final sanding of body filler, final sanding of lacquer	
	Keying of factory primers, fine sanding of body fillers	10 - 5 mm
P320	Flatting of primer filler	5 - 2.5 mm
P400	Fine sanding of primer filler, keying of old lacquer	5 - 2.5 mm
P600	Cleaning, refining after flatting of primer filler	5 - 2.5 mm
P600 - P1500	Flatting of fresh lacquer	5 - 2.5 mm

Comparison of wet and dry sanding

Machine sanding		Manual sanding					
dry 1950 siaspeed siafast 1990 siamic siafast	dry 1940 siacar siafast	dry 1950 siaspeed siasoft 1990 siamic siasoft	dry 9214 Flat Pad	wet 1913/1951 siawat			
P1500				P2500			
P1200			micro fine	P2000 - P2500			
P1000				P1500 - P2000			
P800	P600		super fine	P1200 - P1500			
P600	P500		extra fine	P1000 - P1200			
P500	P400	P600		P800 - P1000			
P400	P320	P500	fine	P600 - P800			
P320	P280	P400		P500 - P600			
P280	P240	P320		P400 - P500			
P240	P220	P280	medium	P320 - P400			
P220	P180	P240		P240 - P280			
P180	P150	P220		P220 - P240			
P150	P120	P180		P150 - P180			
P120	P100	P150		P120 - P150			
P100	P080			P100 - P120			
К080	P060						
К060	P040						
K040							

Backing pad/orbit recommendations







sia Products

The comprehensive range of sia products extends from coated abrasives, through microabrasives and nonwoven abrasives, to foam abrasives.

- √ 1950 siaspeed
- 6120 siavlies speed
- ▼ 1913 siawat fc
- 7940 siaaiar velvet
- 7240 siacarat velvet
- Aerodynamic pad
- Air chamber backing pad
- Hand sanding blocks
- ▼ siastar adapter system
- ▼ siafast fastening system

1950 siaspeed



High performance abrasive

Thanks to the innovative abrasive structure and very high quality materials, significantly better removal values are obtained. The consistently impressive results are characterised by maximising stock removal.

Maximum service life

The ingenious stearate coating greatly reduces jamming and clogging of the abrasive. The net result is a far longer service life.

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 benefiting from Swiss quality

The complete product range, in various shapes and hole patterns, is available in a range of grit sizes from 40 to 1500, all featuring the practical siafast self-adhesive fastening system.

1950 siaspeed – the complete product range for every application

Material/ Treatment	Coar	se san	ding			Fine sanding						Micro-Finish						
Grit range	40	60	80	100	120	150	180	220	240	280	320	400	500	600	800	1000	1200	1500
Steel																		
Aluminium																		
Plastics																		
Primer (KTL und epoxy)																		
Bodyfiller																		
Primer filler																		
Paints and lacquers																		
Glass fibre- reinforced plastic																		
Gelcoat																		
Solid surface																		
Acrylic glass (Plexiglass)																		

Accessories									
Backing pad Inter- mediate									
hard	soft	Pad							

1950 siaspeed

Applications

- Sanding of body filler, polyester, composites
- Sanding new components, factory primers
- Sanding out of feather edges, rust spots and stone chips
- Shaping of primer filler
- Producing a matt finish on lacquers

Structure

Grit: Mixed grain, semi-friable aluminium

oxide, aluminium oxide

Coating: Electrostatic
Bonding: Synthetic resin
Additional coating: Stearate
Backing: Paper or film
Grit range: K040 - P1500

Description	Perforation	Grit	Dimensions	Catalogue-No.	ArtID
Discs siafast	no holes		Ø 150 mm	T2020.xxxx.x	7332.9183.xxxx
	7 holes		Ø 150 mm	T2021.xxxx.x	8438.1710.xxxx
	9 holes		Ø 150 mm	T2022.xxxx.x	2237.4737.xxxx
	15 holes	K040 - P1500	Ø 150 mm	T2023.xxxx.x	7546.2948.xxxx
	no holes		Ø 125 mm	T2030.xxxx.x	6783.7705.xxxx
	5 holes		Ø 125 mm	T2031.xxxx.x	0845.6297.xxxx
	6 holes		Ø 125 mm	T2032.xxxx.x	3031.0713.xxxx
	8 holes		Ø 125 mm	T2033.xxxx.x	8286.8318.xxxx
	9 holes		Ø 125 mm	T2034.xxxx.x	3560.7130.xxxx
	no holes		Ø 80 mm	T2026.xxxx.x	5816.8425.xxxx
	9 holes		Ø 203 mm	T2029.xxxx.x	5002.6471.xxxx
	1	1			
Strips siafast	8 holes		70 x125 mm	T2040.xxxx.x	8457.3676.xxxx

Strips siafast	8 holes		70 x125 mm	T2040.xxxx.x	8457.3676.xxxx
	8 holes		70 x 198 mm	T2041.xxxx.x	0062.9565.xxxx
	18 holes		115 x 228 mm	T2042.xxxx.x	5348.6398.xxxx
	14 holes	K040 - P1500	70 x 420 mm	T2043.xxxx.x	5618.8422.xxxx
	8 holes		93 x 180 mm	T2044.xxxx.x	8801.7879.xxxx
	no holes		70 x 125 mm	T2050.xxxx.x	6783.9190.xxxx
	no holes		115 x 230 mm	T2051.xxxx.x	0465.4240.xxxx
	no holes		70 x 420 mm	T2052.xxxx.x	3210.1376.xxxx

Perforated rolls siasoft		115/125 x 25 mm	T2150.xxxx.1	2237.4334.xxxx
Sheets siasoft	P150 - P600	115 x 140 mm	T2151.xxxx.6	4564.0566.xxxx
Rolls siasoft without perf.		115 x 25 m	T2152.xxxx.1	3973.1827.xxxx

6120 siavlies speed



Advantages

- Improved flexibility for hard to reach areas
- Consistent scratch pattern due to improved grain consistency
- Increased lifetime as a result of the grain distribution through the fleece
- Can be used wet or dry
- For manual or machine use
- Improved tear resistance

Applications

- Keying of e-coats very fine
- Keying of solid colour paint very fine
- Final sanding of primer filler (with D/A sander) ultra fine
- Matting of lacquer or metallic colour coats ultra fine
- Matting of water miscible lacquers and bright metallic micro fine
- Matting of sensitive paint and lacquer

Structure

Grit: aluminium oxide, silicone carbide

Bonding: synthetic resin

Pad: siafast

Grade range: very fine, ultra fine, micro fine

Form: nylon fleece, open

Description	Dimensions	Grade range	Catalogue-No.	Description-ID
Rolls	100 mm x 10 m 115 mm x 10 m 125 mm x 10 m	very fine ultra fine micro fine	N7056.6921.1 N7900.8715.1 N7013.9913.1	9327.7238.xxxx 3144.5052.xxxx 2344.9555.xxxx
Width: 100 mm = N7056	115 mm = N7900	125 mm = N7013		
Discs without holes	Ø 150 mm	very fine ultra fine micro fine	N8996.6921.3 N8996.8715.3 N8996.9913.3	7866.2539.xxxx
Z-folded, perforated	115 x 152 mm	very fine ultra fine micro fine	N7002.6921.8 N7002.8715.8 N7002.9913.8	0050.7679.xxxx
Handpads	152 x 229 mm	very fine ultra fine micro fine	N7058.6921.3 N7058.8715.3 N7058.9913.3	4132.9840.xxxx



Advantages

- Very uniform surface finish
- Very adaptable to contours and shaped sections
- Available in grits up to P2500
- Highly water resistant
- Suitable for wet or dry sanding
- High removal rate with good finish

Applications

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

Construction

Grit: semi-friable aluminium oxide P060 – P1200

silicon carbide P1500—P2500

Adhesive: synthetic resin

Backing: c-wt paper, water resistant

Grit range: P060-P2500

Coating: closed

Description	Dimensions	Grit	Catalogue-No.	Description-ID
Sheet plain	230 x 280 mm	P60 - P2500	T6021.xxxx.6	3100.3713.xxxx
Sheet plain	140 x 230 mm	P1500 P2000 P2500	T6140.xxxx.x	9219.5517.xxxx
Strips siafast	70 x 125 mm	P180 - P2500	T4827.xxxx.6	5980.9923.xxxx
Strips siafast	20 x 70 mm	P2000	T3882.2000.8	8792.1350.2000
Daisy Disc	Ø 37 mm	P1500 - P2500	T8168.xxxx.7	4269.7970.xxxx
Disc siafast	Ø 80 mm	P2000	T5126.2000.6	5013.8691.2000

7940 siaair velvet



Advantages

- Very high durability
- Low scratch depth with high removal rate
- No bold spots thanks to pressure-compensating foam
- Waterproof, can be washed out
- Very flexible around edges and contours
- Absorbs water
- Reusable
- Permeable to air and other fluids

Applications

- Producing a matt finish on conventional lacquers
- Final sanding of filler in hard-to-reach areas
- Fine sanding of flatted surfaces prior to polishing
- Final sanding of solid surface



for the perfect Swiss finish

- velvet net-backed abrasive
- foam cushioning
- siafast fastening system



Construction

Grit: white aluminium oxide

Adhesive: synthetic resin

Backing: knitted fabric with foam backing

Grit range: P240 – P4000 Coating: special process

Description	Grit	Dimensions	Catalogue-No.	Description-ID
Discs	K1000, K2000, K3000, K4000	Ø 80 mm	T3306	3647.2462
Discs	K240, K360, K500, K600, K800, K1000, K1500, K2000, K3000, K4000	Ø 150 mm	Т3307	5163.3687
Strips	K600, K800, K1000, K1500, K2000	115 x 140 mm	T3308	6329.7598



Advantages

- High-performance diamond abrasive minerals ensure maximum durability
- Lasts up to 40 times longer than conventional abrasives
- Waterproof and washable
- Highly adaptable when sanding around contours
- Low scratch depth with high removal rate
- Does not undercut thanks to foam that equalises application pressure
- Reusable

Applications

- Sanding of scratch-resistant lacquer systems
- Micro-sanding of solid surface
- Treatment of epoxy-based materials
- Producing a matt finish on and refining very hard surfaces



for finishing scratch-resistant surfaces

- velvet net-backed abrasive
- foam cushioning
- siafast fastening system



Construction

Grit: diamond
Adhesive: synthetic resin

Backing: knitted fabric with foam backing

Grit range: P500, P1000 Coating: special process

Description	Grit	Dimensions	Catalogue-No.	Description-ID
Discs	K500, K1000	Ø 80 mm	T5095	8451.8686
Discs	K500, K1000	Ø 150 mm	T5096	9967.9911

7-hole Aerodynamic pad



Advantages

- Aerodynamic extraction system
- Universal star adapter for M8
- Outstanding dust extraction
- Flexible, high-tech backing pad
- 7-hole technology for maximum durability
- Safety and continuity for your application

- Cost savings thanks to process optimisation
- Up to 12,000 rpm

Application

- Can be used on all standard dual action disc sanders
- Pad hardness optimised for target application







Description	Perforation	Grade range	Dimensions	Catalogue-No.	Description-ID
Backing pad incl. cog adapter	7 holes, 5/16" + M8	soft	Ø 150 mm	T7206.0000.1	0020.3509.01
Backing pad incl. cog adapter	7 holes, 5/16" + M8	extra soft	Ø 150 mm	T7207.0000.1	0020.3983.01

The following items are supplied with the 7-hole aerodynamic pad:

- Assembly kit including Festo adapter and spacer discs
- 5/16" + M8 screws with Allen key
- Assembly instructions in several languages

Available exclusively from sia Abrasives.

15-hole Air chamber backing pad



Advantages

- Suitable for use with 6-, 7-, 9- and 15-hole discs
- Simplified stock management (particularly for dealers)
- Outstanding dust extraction thanks to high-vacuum centre hole
- Low vibration (pad and adapter are perfectly balanced)
- Small hole provided for disc positioning
- Every pad hardness in the air-chamber system

Applications

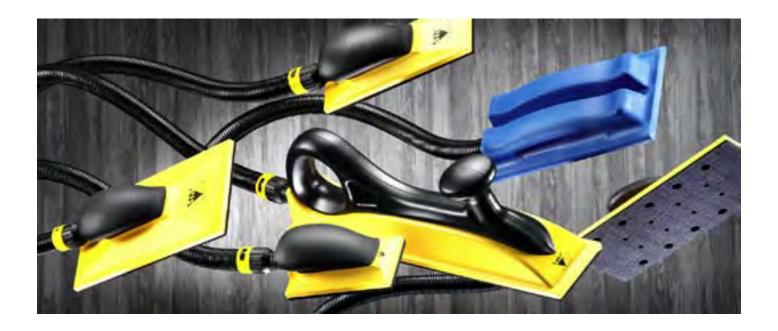
- Coarse sanding, fine sanding and micro-finishing with dual action disc sanders
- Pad hardness optimised for target application

Description	Perforation	Grade range	Dimensions	Catalogue-No.	Description-ID
Air chamber backing pad	15 holes	hard	Ø 150 mm	T7203.0000.1	0020.4091.01
Air chamber backing pad	15 holes	soft	Ø 150 mm	T7204.0000.1	0020.4092.01
Air chamber backing pad	15 holes	extra-soft	Ø 150 mm	T7205.0000.1	0020.4093.01

The following items are supplied with the 15-hole air chamber backing pad:

- Assembly kit including Festo adapter and spacer discs
- 5/16" + M8 screws
- Assembly instructions in several languages

Hand sanding blocks



Advantages

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

Applications

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

Description	Perforation	Dimensions	Catalogue-No.	Description-ID
Adaptable hand-sanding block	18 holes	115 x 228 mm	T7046.0000.1	0020.0263.01
Block	8 holes	70 x 125 mm	T7046.0001.1	0020.3926.01
Block	8 holes	70 x 125 mm	T7046.0002.1	0020.3922.01
Block	18 holes	115 x 228 mm	T7046.0003.1	0020.3923.01
File	14 holes	70 x 420 mm	T7046.0004.1	0020.3924.01
Extraction hose		4500 x 25 mm	T7046.0005.1	0020.3925.01
Connecting piece		Ø 29 / Ø 21 / 47 mm	T7046.0006.1	0020.4349.01

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



The centrepiece of siastar® is the quick release adapter which fits any conventional angle and straight grinders.



Your benefit

- Modular and quick
- Minimal conversion times for all types of grinding and sanding machine
- Saves time and money

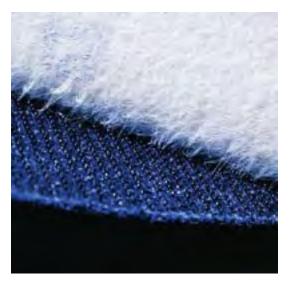
- Tool change without additional key
- Simpler handling improves safety
- Specially developed for heavy-duty requirements on stainless steel
- Unrestricted use of tools, even on normal steel

The quick and time-saving fastening system



Your solution with siafast:

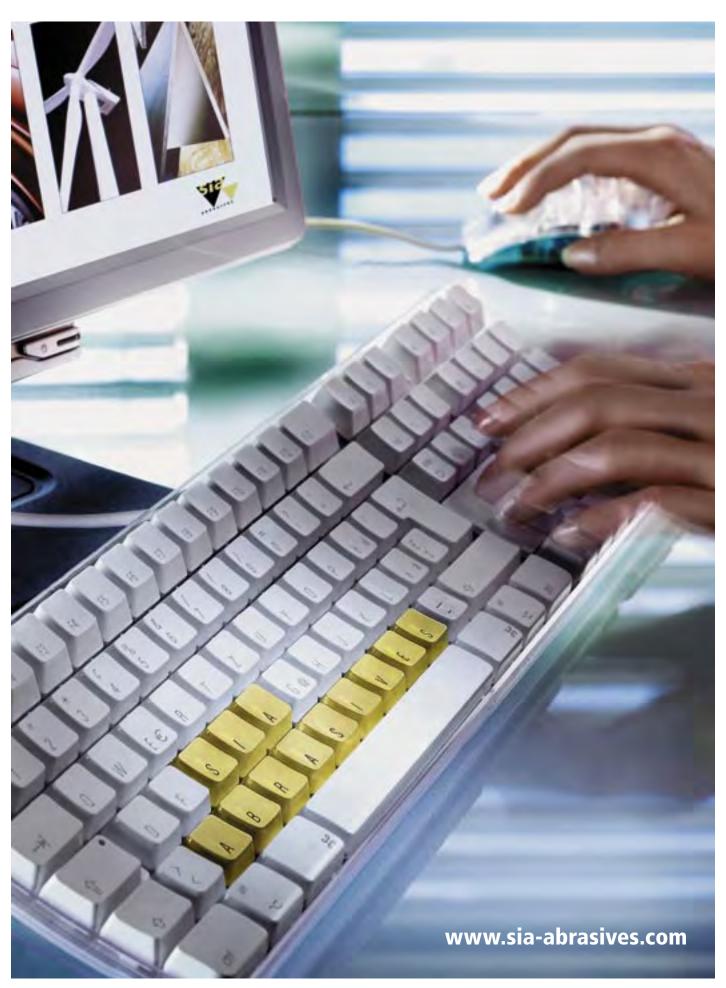
- Economical and cost saving, as the abrasive can be re-used several times
- Highly resistant with long lifetime; endures dust, humidity and changes in temperature
- Cooler cut, less clogging, thanks to the ventilation through the fastening system
- More security in the final sanding on flats and contours thanks to the cushion effect between the hooks and loops.







sia Online



sia Abrasives - Your Key to a Perfect Surface

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 1150 people and is represented in more than 80 countries.







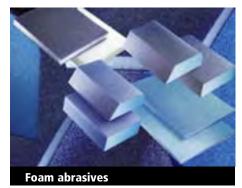
Classic flexible abrasives and systems for conventional surface treatment on all types of material.



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



Products on special polyester film to give defined surface structures in the areas of graphics, optics and the auto industry.



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

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