This in particular allows ensuring high strength of the roughing disc the higher the hardness of the additive is.

In another preferred embodiment of the roughing disc according to the invention, the mineral additive has a grain size of 30 to 1000 µm, preferably 200 to 500 µm.

In another preferred embodiment of the roughing disc according to the invention, the grain of the mineral additive is covered in phenolic resin systems comprising a resol/novolak mixture. Resols are meltable soluble phenolic plastics that contain reactive methylol groups and are obtained when phenols are condensed with formaldehyde under basic conditions. The benzene rings are connected via methylene groups and via ether bridges. Novolaks are phenolic resins having a formaldehyde/phenol ratio of less than 1:1 and are obtained by acidic condensation of the educts.

In another preferred embodiment of the roughing disc according to the invention, the resol has a viscosity of 1000 to 5000 mPa·s, preferably 1200 to 3500 mPa·s.

In another preferred embodiment of the roughing disc according to the invention, the novolak has a hexamethylenetetramine content of at least 9 vol%, preferably 12 to 16 vol%, and a flow length of 15 to 35 mm, preferably 17 to 26 mm. Moreover, the novolak can be modified novolak.

In another preferred embodiment of the roughing disc according to the invention, additional defined amounts of other additives and/or aggregates of less than 20 vol% can be added to the novolak.

Other advantages and advantageous embodiments of the subject-matter of the invention are apparent from the description, the drawing, and the claims.

An embodiment of a roughing disc according to the invention is illustrated in a schematically simplified manner in the drawing and will be explained in more detail in the following description.

Figure 1 of the drawing shows a section through a roughing disc according to the invention.