

INTERNATIONAL STANDARD

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Coated abrasives — Vulcanized fibre discs

Produits abrasifs appliqués — Disques en fibres vulcanisées

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this International Standard may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 16057 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 5, *Grinding wheels and abrasives*.

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Coated abrasives — Vulcanized fibre discs

1 Scope

This International Standard specifies the nominal dimensions of vulcanized fibre discs. These vulcanized fibre discs are intended for use on hand-held grinding machines. Vulcanized fibre discs are for use with support discs in accordance with ISO 15636.

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this International Standard. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 554:1976, *Standard atmospheres for conditioning and/or testing — Specifications*

ISO 15636, *Support discs for vulcanized fibre discs*

3 Profiles and dimensions

3.1 Profiles

For profiles A1 and A2, see Figures 1 and 2. For further profiles, see clause 4.

3.2 Test conditions

The limit deviations given in Table 1 are valid under the following conditions:

- | | |
|---|------------------------------|
| — Temperature: $20\text{ °C} \pm 2\text{ °C}$ | } in accordance with ISO 554 |
| — Relative humidity: $65\% \pm 5\%$ | |

When vulcanized fibre discs are tested they shall be stored for at least 24 h under the above conditions.

Profile A1

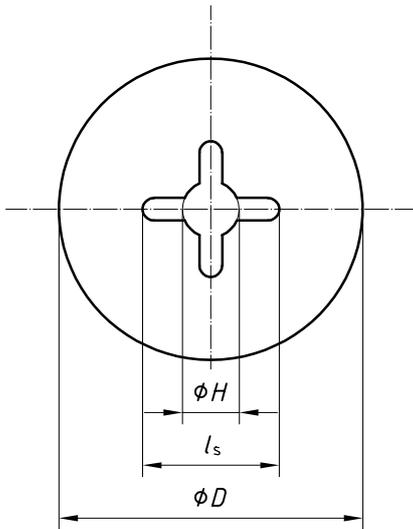


Figure 1

Profile A2

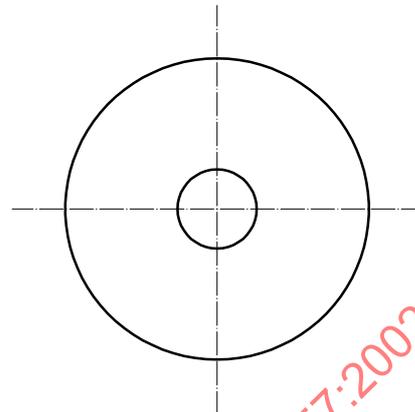


Figure 2

Table 1 — Dimensions

		Dimensions in millimetres						
D	Nominal	80	100	115	125	150	180	235
	Limit deviations	$\pm 1,5$			± 2			
	H_0^{+1}	16	16/22	22			22/40 ^a	22
	l_s	$l_s \leq 0,44 D$ and ≤ 80 mm						
^a Should not be used for new designs.								

4 Design

The profiles A1 and A2 are the standard designs of vulcanized fibre discs, see Figures 1 and 2.

The profiles B1, B2, C1 and C2 are possible variations of the standard designs for vulcanized fibre discs, see Figures 3 to 6.

All profiles A1 to C2 may be flat or moulded, see Figures 7 and 8.

Instead of 4 slots, profiles A1, B1 and C1 may also be manufactured with 6 or 8 slots.

Design is left to the manufacturer's discretion.

Profile B1

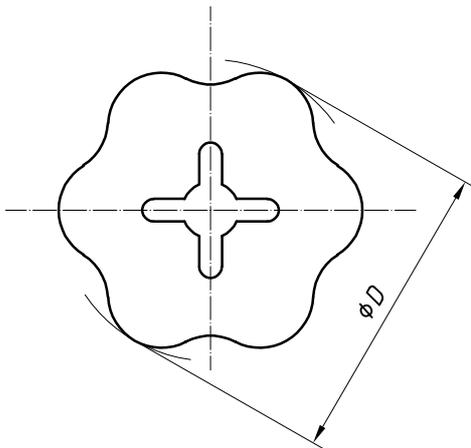


Figure 3

Profile B2

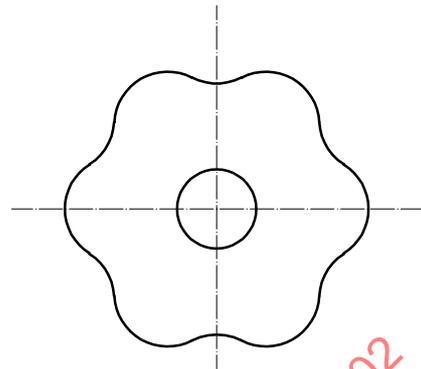


Figure 4

Profile C1

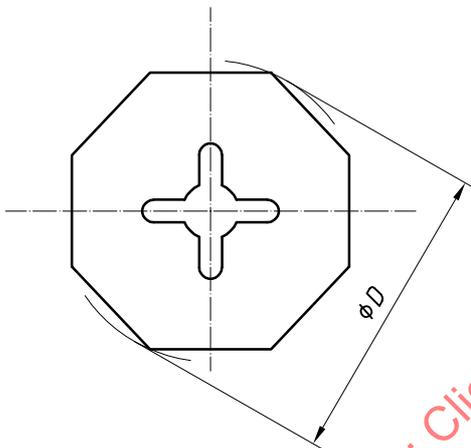


Figure 5

Profile C2

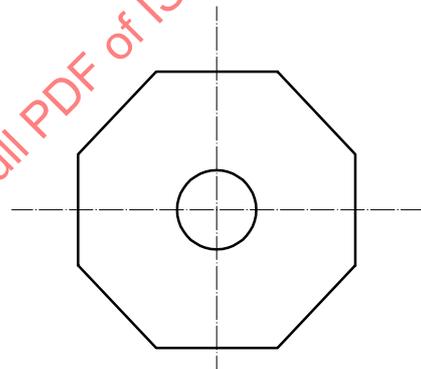


Figure 6

EXAMPLE Flat (see Figure 7) or moulded (see Figure 8) vulcanized fibre discs

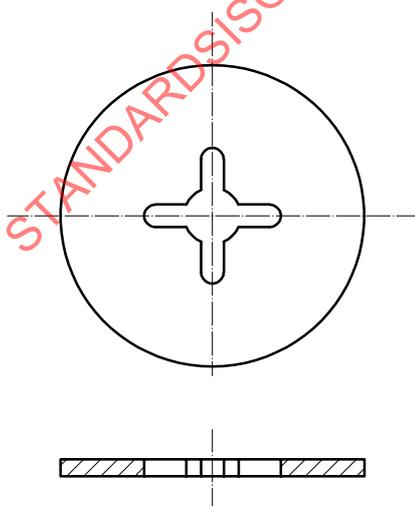
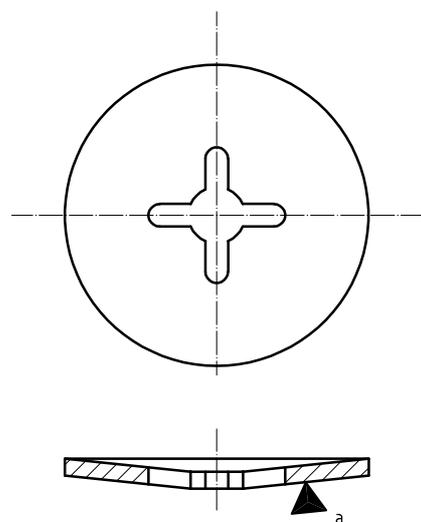


Figure 7



^a This symbol shows the grinding face

Figure 8

5 Designation

A vulcanized fibre disc conforming to this International Standard shall be designated by

- a) "Vulcanized fibre disc";
- b) reference to this International Standard, i.e. ISO 16057;
- c) profile A1, A2, B1, B2, C1 or C2;
- d) diameter D , in millimetres;
- e) hole diameter H ;
- f) symbol for flat (F) or moulded (M);
- g) symbol for 6 (6) or 8 (8) slots.

EXAMPLE 1 A vulcanized fibre disc with profile A1, diameter $D = 100$ mm, hole diameter $H = 22$ mm, moulded (M) is designated as follows:

Vulcanized fibre disc ISO 16057 A1 × 100 × 22 M

EXAMPLE 2 A vulcanized fibre disc with profile C1, diameter $D = 180$ mm, hole diameter $H = 22$ mm, flat (F) and 8 slots is designated as follows:

Vulcanized fibre disc ISO 16057 C1 × 180 × 22 F 8

6 Marking

Vulcanized fibre discs shall be marked with the following information:

- a) grain size;
- b) manufacturer, supplier, importer or their registered trademark;
- c) maximum operating speed.