
**Bonded abrasive products —
Dimensions —**

Part 15:

Grinding wheels for cutting-off on stationary
or mobile cutting-off machines

Produits abrasifs agglomérés — Dimensions —

Partie 15: Meules pour tronçonnage sur machines fixes ou mobiles



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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.

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.

International Standard ISO 603-15 was prepared by Technical Committee ISO/TC 29, *Small tools*, subcommittee SC 5, *Grinding wheels and abrasives*.

This first edition, together with ISO 603-1:1999 to ISO 603-14:1999 and ISO 603-16:1999, cancels and replaces ISO/R 603:1967, ISO 603-2:1981, ISO 1117:1975, ISO 2220:1972, ISO 2933:1974, ISO 3290:1976 and ISO 3921:1976 as a technical revision of these standards.

ISO 603 consists of the following parts, under the general title *Bonded abrasive products — Dimensions*:

- *Part 1: Grinding wheels for external cylindrical grinding between centres*
- *Part 2: Grinding wheels for centreless external cylindrical grinding*
- *Part 3: Grinding wheels for internal cylindrical grinding*
- *Part 4: Grinding wheels for surface grinding/peripheral grinding*
- *Part 5: Grinding wheels for surface grinding/face grinding*
- *Part 6: Grinding wheels for tool and tool room grinding*
- *Part 7: Grinding wheels for manually guided grinding*
- *Part 8: Grinding wheels for deburring and fettling/snagging*
- *Part 9: Grinding wheels for high-pressure grinding*
- *Part 10: Stones for honing and superfinishings*
- *Part 11: Hand finishing sticks*
- *Part 12: Grinding wheels for deburring and fettling on a straight grinder*
- *Part 13: Grinding wheels for deburring and fettling on a vertical grinder*
- *Part 14: Grinding wheels for deburring and fettling/snagging on an angle grinder*
- *Part 15: Grinding wheels for cutting-off on stationary or mobile cutting-off machines*
- *Part 16: Grinding wheels for cutting-off on hand held power tools*

Bonded abrasive products — Dimensions —

Part 15:

Grinding wheels for cutting-off on stationary or mobile cutting-off machines

1 Scope

This part of ISO 603 specifies the nominal dimensions, in millimeters, of:

- Type 41: Flat cutting-off wheel
- Type 42: Depressed centre cutting-off wheel

These bonded abrasive products are intended to be used for cutting-off or slotting of any part of a workpiece. The workpiece is firmly clamped or is stabilized by its own weight. If the cutting-off wheel is guided by hand the workpiece is fixed and vice versa. The cutting-off machine is fixed during the operation.

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this part of ISO 603. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of ISO 603 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 525:1999, *Bonded abrasive products — General requirements*.

ISO 6103:1999, *Bonded abrasive products — Static balancing of grinding wheels — Testing*.

ISO 13942:—¹⁾, *Bonded abrasive products — Limit deviations and run-out tolerances*.

¹⁾ To be published.

3 Dimensions

3.1 Type 41: Flat cutting-off wheel

See Figure 1 and Table 1.

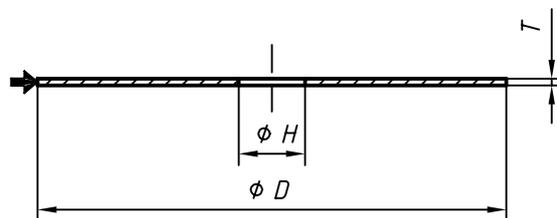


Figure 1 — Type 41

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Table 1 — Dimensions of Type 41

D	T															H
	0,6	0,8	1,25	1,6	2	2,5	3,2	4	5	6	8	10	13	16	20	
63	X	X	X	X	X	—	—	—	—	—	—	—	—	—	—	10
																13
80	X	X	X	X	X	—	—	—	—	—	—	—	—	—	—	10
																13
100	X	X	X	X	X	—	—	—	—	—	—	—	—	—	—	10
																13
																20
125	X	X	X	X	X	X	—	—	—	—	—	—	—	—	—	13
																20
150	X	X	X	X	X	X	—	—	—	—	—	—	—	—	—	13
																20
200	—	—	—	X	X	X	X	—	—	—	—	—	—	—	—	20
																32
250	—	—	—	X	X	X	X	—	—	—	—	—	—	—	—	20
																25,4
300	—	—	—	—	—	X	X	X	—	—	—	—	—	—	—	32
																25,4
350/356	—	—	—	—	—	X	X	X	—	—	—	—	—	—	—	32
																40
400/406	—	—	—	—	—	—	X	X	X	—	—	—	—	—	—	25,4
																32
450/457	—	—	—	—	—	—	X	X	X	—	—	—	—	—	—	40
																60
																25,4
500/508	—	—	—	—	—	—	—	X	X	X	—	—	—	—	—	32
																40
600/610	—	—	—	—	—	—	—	—	X	X	X	—	—	—	—	60
																60
750/762	—	—	—	—	—	—	—	—	—	X	X	—	—	—	—	76,2
																60
																80
																100
800	—	—	—	—	—	—	—	—	—	X	X	X	—	—	—	152,4
																60
																80
1 000	—	—	—	—	—	—	—	—	—	—	X	X	X	—	—	100
																100
1 250	—	—	—	—	—	—	—	—	—	—	—	X	X	—	—	152,4
																100
1 500	—	—	—	—	—	—	—	—	—	—	—	—	X	X	—	152,4
																203,2
1 800	—	—	—	—	—	—	—	—	—	—	—	—	—	X	X	152,4
																203,2
																304,8

3.2 Type 42: Depressed centre cutting-off wheel

See Figure 2 and Table 2.

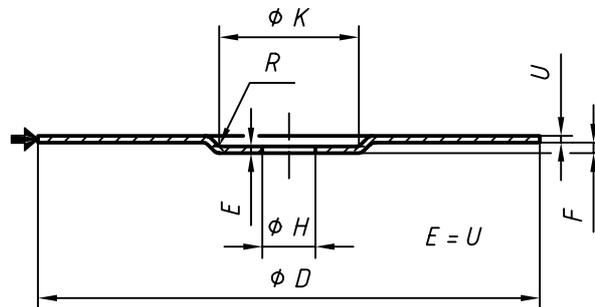


Figure 2 — Type 42

Table 2 — Type 42

D	U							H	K	F min.	R max.
	4	5	6	8	10	13	16				
400/406	X	X	X	—	—	—	—	40	122	7,5	10
450/457	X	X	X	—	—	—	—				
500/508	—	X	X	—	—	—	—	40	210	13	
								60			
600/610	—	—	X	X	—	—	—	60	325	18	
								76,2			
800	—	—	—	X	X	—	—	60	127	12	
								80			
								100			
1 000	—	—	—	—	X	X	—	127	325	18	
1 250	—	—	—	—	—	X	X				

4 Designation

A complete designation of a bonded abrasive product in accordance with this part of ISO 603 shall be consist of the following information:

- a) designation of the bonded abrasives, e.g. "Flat cutting-off wheel";
- b) reference of this part of ISO 603;
- c) type (shape);
- d) dimensions;
- e) specifications of an internal nature;
- f) the maximum operating speed.

In accordance with ISO 525 and this part of ISO 603

EXAMPLE

A flat cutting-off, Type 41, D = 400 mm, T = 3,2 mm, H = 32 mm, nature of abrasive A, grain size 24, nature of bond resinoid reinforced BF and a maximum operating speed of 100 m/s is designated as follows:

Flat cutting-off wheel ISO 603-15 - 41 - 400 × 3,2× 32 - A 24 BF - 100 m/s

5 Specifications

The specifications are left to the manufacture's discretion, see ISO 525.

5.1 Tolerances

Limit deviations and run-out tolerances in accordance with ISO 13942.

5.2 Balancing

Balancing is in accordance with ISO 6103.

5.3 Marking

Marking of bonded abrasive products is in accordance with ISO 525.

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