
**Blanks for superabrasive cutting-off
wheels —**

Part 2:

**Hand-held cutting-off in building and civil
engineering**

Âmes pour meules de tronçonnage superabrasives —

Partie 2: Tronçonnage tenu à la main dans le bâtiment et le génie civil

STANDARDSISO.COM : Click to view the full PDF of ISO 6105-2:2004



PDF disclaimer

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

STANDARDSISO.COM : Click to view the full PDF of ISO 6105-2:2004

© ISO 2004

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Published in Switzerland

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 2.

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 document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 6105-2 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 5, *Grinding wheels and abrasives*.

This first edition of ISO 6105-2, together with ISO 6105-1, cancels and replaces ISO 6105:1988, the content of which have been technically revised.

ISO 6105 consists of the following parts, under the general title *Blanks for superabrasive cutting-off wheels*:

- *Part 1: Manually guided cutting-off in building and civil engineering*
- *Part 2: Hand-held cutting-off in building and civil engineering*

Blanks for superabrasive cutting-off wheels —

Part 2: Hand-held cutting-off in building and civil engineering

1 Scope

This part of ISO 6105 specifies dimensions for blanks to be used for superabrasive cutting-off wheels on hand-held cutting-off machines that are designed for application in building and civil engineering (cutting of asphalt, concrete, natural or artificial stone).

2 Dimensions, designation

The dimensions of blanks with 30 mm to 40 mm lands and narrow slots (type F), blanks with 40 mm lands and wide slots (type G), blanks with 50 mm lands and narrow slots (type H) and blanks with 50 mm lands and wide slots (type I), used for superabrasive cutting-off wheels, are shown in Figures 1 and 2 and are given in Tables 1 to 4 respectively.

Details which are not specified shall be chosen according to need.

3 Designation

EXAMPLE A blank for superabrasive cutting-off wheels of Type F with $D_1 = 290$ mm, $E = 1,8$ mm and $H = 25,4$ mm is designated as follows:

Blank ISO 6105-2 F 290 × 1,8 × 25,4

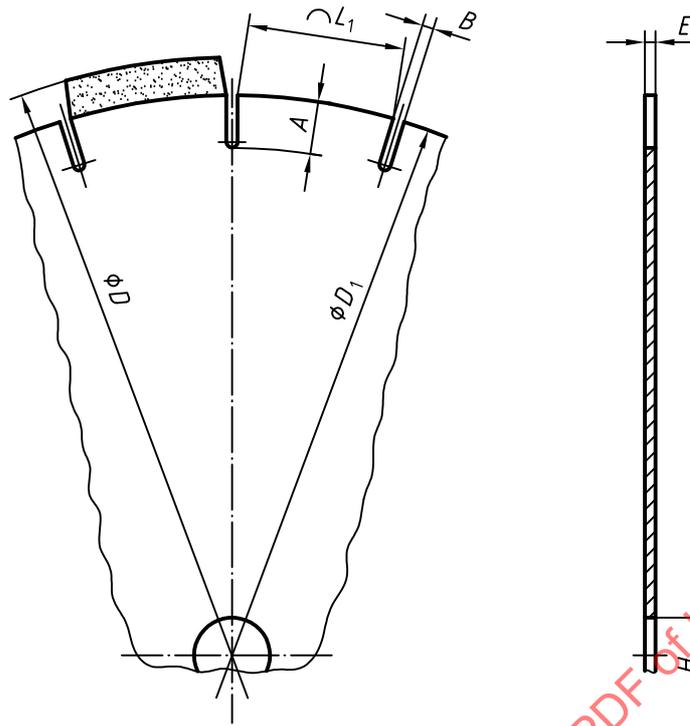
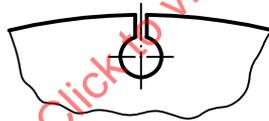


Figure 1



NOTE Alternatively, a key hole slot may be used. A different slot shape is permitted.

Figure 2

Table 1 — Type F, blank with 30 mm to 40 mm lands, narrow slots

Dimensions in millimetres

D	D ₁ ^{a, b}		E ^b	A	H ^b		B ^a	Number of lands Z	L ₁	
	Series 1	Series 2			± 0,05	± 1,0			± 0,5	nom.
100	79	85	1,2/1,3/1,5	10	15/16/20	H9	3	8	28,1	30,4
115	94	100	1,4	10	22,23	H9	3	9	29,8	31,9
125	104	110	1,4		22,23			10	29,7	31,6
150	129	135	1,5	12	22,23		3	12	30,8	32,3
180	159	165	1,8	12	22,23			14	32,7	34,0
200	179	185	1,5/1,8		22,23			16	32,1	33,3
230	209	215	1,8	22,23	16		38,0	39,2		
250	234	240	1,8	14	20/25,4		H7	3	18	33,5
						18			37,8	38,9
300	284	290	1,8/2,0/2,2/2,4	14	20/25,4	H7	3	21	39,5	40,4
350	334	340	1,8/2,0/2,2/2,4		20/25,4			25	39,0	39,7
400	384	390	2,4		20/25,4			28	40,1	40,8

^a For blanks with key hole slots at the rear, the hole diameter is 6 mm for a 3 mm slot.

^b This also applies to cutting-off wheels with continuous cutting rim.

Table 2 — Type G, blank with 40 mm lands, wide slots

Dimensions in millimetres

D	D ₁ ^a		E ^a	A	H ^a		B	Number of lands Z	L ₁	
	Series 1	Series 2			± 0,05	± 1,0			± 0,5	nom.
230	209	215	1,5/1,8	12	22,23	H9	10	13	40,5	41,9
250	234	240	1,8	14	20/25,4	H7		15	39	40,9
300	284	290	1,8/2,0/2,2/2,4	14	20/25,4		10	18	39,5	40,6
350	334	340	1,8/2,0/2,2/2,4	14	20/25,4			21	40	40,9
400	384	390	2,4	12	20/25,4		24	40,3	41	

^a This also applies to cutting-off wheels with continuous cutting rim.

Table 3 — Type H, blank with 50 mm lands, narrow slots

Dimensions in millimetres

<i>D</i>	<i>D</i> ₁		<i>E</i> +0,1 0	<i>A</i> ± 1	<i>H</i> H7	<i>B</i> ± 0,5	Number of lands <i>Z</i>	<i>L</i> ₁	
	Series 1	Series 2						Series 1	Series 2
250	234	240	1,8	14	20/25,4	3	14	49,5	50,8
300	284	290	1,8/2,0/2,2/2,4	14	20/25,4		17	49,5	50,6
350	334	340	1,8/2,0/2,2/2,4	14	20/25,4		20	49,4	50,4
400	384	390	2,2/2,4	14	20/25,4		23	49,4	50,2

Table 4 — Type I, blank with 50 mm lands, wide slots

Dimensions in millimetres

<i>D</i>	<i>D</i> ₁		<i>E</i> +0,1 0	<i>A</i> ± 1	<i>H</i> H7	<i>B</i> ± 0,5		Number of lands <i>Z</i>	<i>L</i> ₁	
	Series 1	Series 2				Series 1	Series 2		Series 1	Series 2
250	234	240	1,8	14	20/25,4	10		12	51,2	52,8
300	284	290	1,8/2,0/2,2/2,4	14	20/25,4	10		15	49,5	50,7
350	334	340	1,8/2,0/2,2/2,4	14	20/25,4	10	12	17	51,7	50,8
400	384	390	2,2/2,4	14	20/25,4			20	50,3	49,2