

# ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

## ADDENDUM 1 TO ISO RECOMMENDATION R 525-1966

BONDED ABRASIVE PRODUCTS – GENERAL FEATURES  
DESIGNATION – RANGES OF DIMENSIONS – PROFILES

DIMENSIONS OF THE WHEEL HOLES FOR SPECIAL APPLICATIONS  
AND TOLERANCES

1st EDITION

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## BRIEF HISTORY

Addendum 1, *Dimensions of the wheel holes for special applications and tolerances*, to ISO Recommendation R 525-1966, *Bonded abrasive products – General features – Designation – Ranges of dimensions – Profiles*, was drawn up by Technical Committee ISO/TC 29, *Small tools*, the Secretariat of which is held by the Association Française de Normalisation (AFNOR).

The ISO Recommendation R 525-1966 has been completed by the addition of two hole dimensions  $d$  (dimensions for special applications), and by the tolerances to be assigned for wheel holes. Work on this question led to the adoption of a Draft ISO Recommendation.

In July 1968, this Draft ISO Recommendation (No. 1590) was submitted to all the ISO Member Bodies for enquiry. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Australia	Ireland	Sweden
Austria	Israel	Switzerland
Belgium	Italy	Thailand
Chile	Japan	Turkey
Czechoslovakia	Netherlands	U.A.R.
France	Poland	United Kingdom
Germany	Portugal	U.S.A.
Hungary	South Africa, Rep. of	U.S.S.R.
India	Spain	Yugoslavia

No Member Body opposed the approval of the Draft.

This Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in June 1969, to accept it as ADDENDUM 1. to ISO RECOMMENDATION R 525-1966.

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**AND TOLERANCES**

**1. SCOPE**

This Addendum to ISO Recommendation R 525-1966, *Bonded abrasive products – General features – Designation – Ranges of dimensions – Profiles*, specifies

- two diameters of holes for cup wheels and depressed centre wheels with fabric reinforcements, as dimensions for special applications; these dimensions are given as "exceptions" in ISO Recommendation R 603, *Bonded abrasive products – Grinding wheel dimensions* (Part 1 and Part 2\*);
- the tolerances to be assigned for wheel holes.

**2. SPECIFICATIONS****2.1 Special holes**

Special holes shown below apply only to cup wheels and depressed centre wheels with fabric reinforcements :

mm	9.53	22.23
in	$\frac{3}{8}$	$\frac{7}{8}$

**2.2 Hole tolerances**

The tolerances given below, chosen from ISO Recommendation R 286, *ISO System of limits and fits – Part 1 : General, tolerances and deviations*, are checked with cylindrical plug gauges. These plug gauges are rejected when they reach the nominal size of the hole on account of wear.

**2.2.1 Precision wheels****2.2.1.1 GENERAL CASE**

Tolerance H12

**2.2.1.2 SPECIAL CASES**

Tolerance H11 for the standard holes listed below :

mm : 76.2 – 127.0 – 203.2 – 304.8 – 508.0  
 in : 3 – 5 – 8 – 12 – 20

\* At present Draft ISO Recommendation No. 1596.