

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION

R 693

DIMENSIONS OF SEAM WELDING WHEEL BLANKS

1st EDITION

March 1968

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BRIEF HISTORY

The ISO Recommendation R 693, *Dimensions of seam welding wheel blanks*, was drawn up by Technical Committee ISO/TC 44, *Welding*, the Secretariat of which is held by the Association Française de Normalisation (AFNOR).

Work on this question by the Technical Committee began in 1958 and led, in 1965, to the adoption of a Draft ISO Recommendation.

In May 1966, this Draft ISO Recommendation (No. 976) was circulated 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	Spain
Belgium	Israel	Sweden
Brazil	Japan	Switzerland
Chile	Korea, Rep. of	Turkey
Czechoslovakia	Netherlands	U.A.R.
Denmark	Norway	United Kingdom
Finland	Poland	U.S.A.
France	Portugal	U.S.S.R.
Germany	Romania	Yugoslavia
Hungary	South Africa,	
India	Rep. of	

One Member Body opposed the approval of the Draft :

Canada

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council which decided, in March 1968, to accept it as an ISO RECOMMENDATION.

DIMENSIONS OF SEAM WELDING WHEEL BLANKS

INTRODUCTION

In this ISO Recommendation, the preferred sizes of the nominal outside diameters of the finished wheels have been taken from the R 10 series of preferred numbers and the non-preferred sizes from the R 20 series. The five preferred widths have also been chosen from the R 10 series.

1. SCOPE

This ISO Recommendation gives the outside diameters and widths of a series of preferred and non-preferred blanks for seam welding wheels which are rough machined on the circumference and finished to size on the width.

2. DIMENSIONS OF BLANKS

The outside diameters of the blanks should not be less than the values given in column 2 of the Table. The corresponding finished widths should be as given in column 3 of the Table, and are subject to a tolerance of ± 0.20 mm (± 0.008 in).

TABLE - Dimensions of seam welding wheel blanks

1		2	3					
Nominal outside diameter of finished wheel		Minimum outside diameter	Preferred finished widths					
mm	in	mm	mm	mm	mm	in	in	in
100	4	103	10	12.5	16.0	0.393	0.492	0.630
112	4 $\frac{1}{2}$	116	10	12.5	16.0	0.393	0.492	0.630
125	5	129	10	12.5	16.0	0.393	0.492	0.630
140	5 $\frac{1}{2}$	144	10	12.5	16.0	0.393	0.492	0.630
160	6 $\frac{1}{4}$	164	12.5	16.0	20.0	0.492	0.630	0.787
180	7 $\frac{1}{4}$	185	12.5	16.0	20.0	0.492	0.630	0.787
200	8	205	12.5	16.0	20.0	0.492	0.630	0.787
224	9	230	12.5	16.0	20.0	0.492	0.630	0.787
250	10	256	16.0	20.0	25.0	0.630	0.787	0.984
280	11 $\frac{1}{4}$	286	16.0	20.0	25.0	0.630	0.787	0.984
315	12 $\frac{1}{2}$	321	16.0	20.0	25.0	0.630	0.787	0.984

NOTE. - Preferred values of nominal outside diameter are in bold type.