
International Standard



6168

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Abrasive products — Diamond or cubic boron nitride grinding wheels — Dimensions

Produits abrasifs — Meules à base de diamant ou de nitrure de bore cubique — Dimensions

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FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up 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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 6168 was developed by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the member bodies in March 1979.

It has been approved by the member bodies of the following countries :

Australia	India	Spain
Austria	Israel	Sweden
Belgium	Italy	Switzerland
Bulgaria	Japan	United Kingdom
Canada	Korea, Rep. of	USA
Chile	Netherlands	USSR
France	Poland	Yugoslavia
Germany, F.R.	Romania	
Hungary	South Africa, Rep. of	

The member body of the following country expressed disapproval of the document on technical grounds :

Czechoslovakia

Abrasive products — Diamond or cubic boron nitride grinding wheels — Dimensions

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions of diamond or cubic boron nitride grinding wheels of which the multilingual nomenclature and dimension designation are specified in ISO 6104.

The diamond or cubic boron nitride concentration and the grain size of the diamond section of the grinding wheels shall be specified in accordance with ISO 6104 and ISO 6106 respectively.

2 REFERENCES

ISO 6104, *Abrasive products — Diamond or cubic boron nitride grinding wheels and saws — General, designation and multilingual nomenclature.*

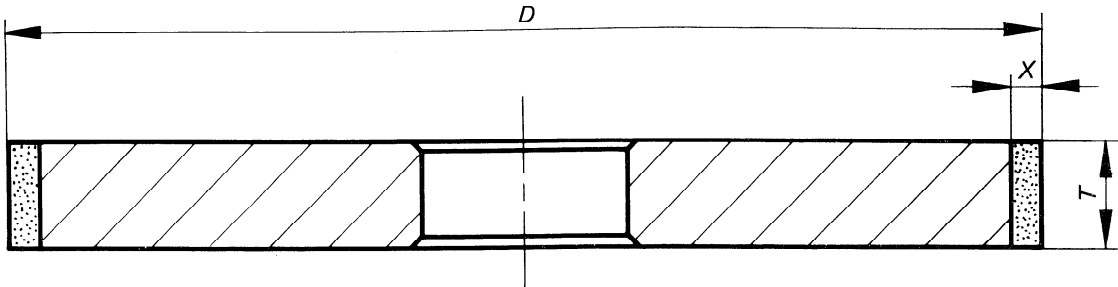
ISO 6105, *Abrasive products — Diamond or cubic boron nitride saws — Dimensions.*¹⁾

ISO 6106, *Abrasive products — Grain sizes of diamond or cubic boron nitride.*

1) At present at the stage of draft.

3 DIMENSIONS

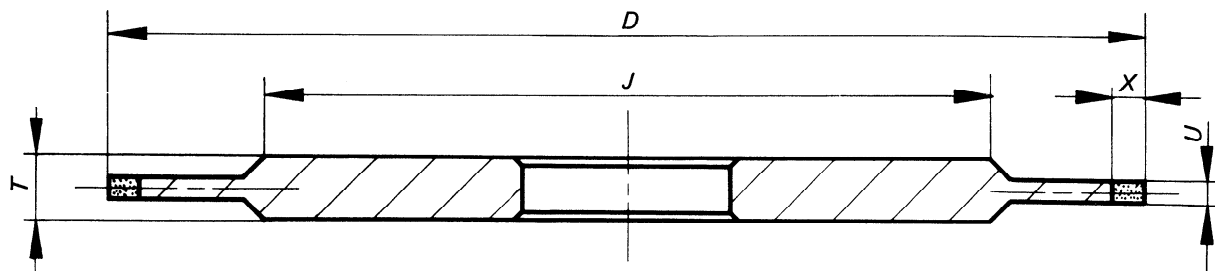
3.1 Plain wheel – Type 1A1



Dimensions in millimetres

<i>D</i>	<i>T</i>											
	3	4	5	6	8	10	12	15	20	40	60	100
20	—	X	—	X	X	X	X					
25	—	X	—	X	X	X	X					
40	—	X	—	X	X	X	X					
50	—	X	—	X	X	X	X					
75	X	X	X	X	—	X	X					
100	X	X	X	X	—	X	X					
125	X	X	X	X	—	X	X	X				
150	X	X	X	X	—	X	X	X	X			
175	—	—	—	X	—	X	X	X	X			
200	—	—	—	X	—	X	X	X	X			
250	—	—	—	X	—	X	X	X	X	X	X	
300	—	—	—	—	—	X	X	X	X	X	X	
350	—	—	—	—	—	—	X	X	X	X	X	X
400	—	—	—	—	—	—	X	X	X	X	X	X
450	—	—	—	—	—	—	X	X	X	X	X	X
500	—	—	—	—	—	—	X	X	X	X	X	X
600	—	—	—	—	—	—	X	X	X	X	X	X
750	—	—	—	—	—	—	—	X	X	X	X	X
<i>X</i> = 1,5 – 3 – 6												

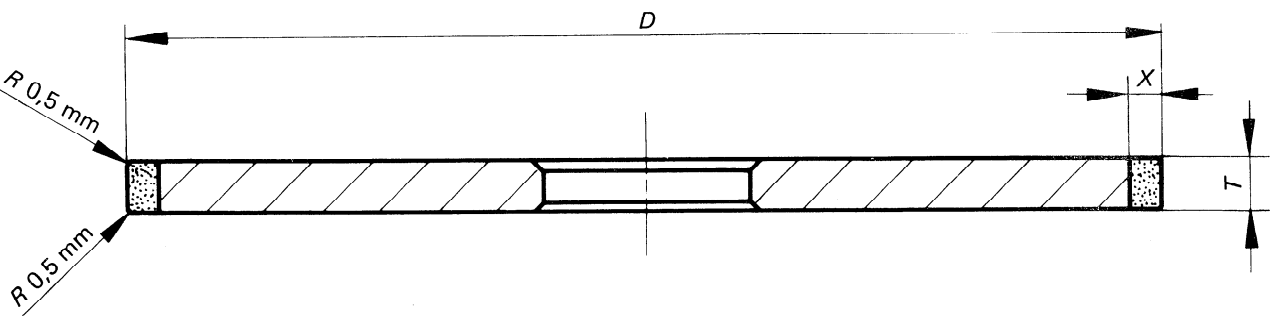
3.2 Plain wheel reinforced – Type 14A1



Dimensions in millimetres

D	J	T	U
75	50	6	1 – 2
100	70		1 – 2
		8	3
125	100	6	1 – 2
		8	3
150	120	10 – 12	1 – 2
175	140	10 – 12	1 – 3 – 6
200	160	12 – 15	3 – 6
250	200	12 – 15 – 20	6 – 10
300	250	15	6 – 10
		20	15
350	300	15	6 – 10
		20	15
400	350	20	6 – 10 – 15
500	400	20	10 – 15
600	500	20	10 – 15
750	600	20	10 – 15
$X = 3 - 6$			

3.3 Plain wheel – Type 1L1



Dimensions in millimetres

<i>D</i>	<i>T</i>			
	3	4	5	6
75	X	X	X	
100	X	X	X	
125	X	X	X	X
150	X	X	X	X
<i>X</i> = 1,5 – 3 – 6				