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Bonded abrasive grain sizes

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R 6001 : 1998

Foreword

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of International Trade and Industry through deliberations at the Japanese Industrial Standards Committee in accordance with the Industrial Standardization Law. Consequently **JIS R 6001 : 1987** is replaced with **JIS R 6001 : 1998**.

The purposes of this revision are to make the standards on the macrogrit and the microgrit for general bonded abrasives conform to the corresponding International Standards.

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In the event of any doubts arising as to the contents,
the original JIS is to be the final authority.

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Bonded abrasive grain sizes

Introduction This Japanese Industrial Standard has adopted the grain sizes of the macrogrit and the microgrit for general bonded abrasives, which have been specified in the first edition of ISO 8486-1, *Bonded abrasives—Determination and designation of grain size distribution—Part 1 : Macrogrits F4 to F220*, and of ISO 8486-2, *Bonded abrasives—Determination and designation of grain size distribution—Part 2 : Microgrits F230 to F1200* published in 1996, without any modification of technical contents, and additionally has specified the grain size of fine powder for precision polishing which has not been specified in the corresponding International Standards.

In this Standard, the “portions” underlined with dots are the items which are not specified in the corresponding International Standards.

1 Scope This Japanese Industrial Standard specifies the grain sizes of abrasives for grinding wheel and for other general use, which are artificial abrasives as specified in JIS R 6111.

Remarks : The International Standards corresponding to this Standard are as follows.

ISO 8486-1 : 1996 *Bonded abrasives—Determination and designation of grain size distribution—Part 1 : Macrogrits F4 to F220*

ISO 8486-2 : 1996 *Bonded abrasives—Determination and designation of grain size distribution—Part 2 : Microgrits F230 to F1200*

2 Normative references The following standards contain provisions which, through reference in this Standard, constitute provisions of this Standard. The most recent editions of the standards indicated below shall be applied.

JIS R 6002 *Testing method for bonded abrasive grain size*

JIS R 6111 *Artificial abrasives*

3 Classification of grain sizes Grain sizes are classified as shown in Table 1 to Table 3 in accordance with their ranges and grain size distribution.

Table 1 Class of macrogrit

Division	Class of grain size								
Macrogrit	F 4	F 5	F 6	F 7	F 8	F 10	F 12	F 14	F 16
	F 20	F 22	F 24	F 30	F 36	F 40	F 46	F 54	F 60
	F 70	F 80	F 90	F 100	F 120	F 150	F 180	F 220	

Remarks : Grain size is designated as “F ○○”.

Table 2 Class of microgrit for general abrasives

Division	Class of grain size					
Microgrit	F 230	F 240	F 280	F 320	F 360	F 400
	F 500	F 600	F 800	F 1000	F 1200	



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