



JAPANESE
INDUSTRIAL
STANDARD

Translated and Published by
Japanese Standards Association

JIS R 6251 : 2006

(ACPA/JSA)

Abrasive cloths

ICS 25.100.70

Reference number : JIS R 6251 : 2006 (E)

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Foreword

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee as the result of proposal for revision of Japanese Industrial Standard submitted by Abrasive Cloth and Paper Association (ACPA)/ Japanese Standards Association (JSA) with the draft being attached, based on the provision of Article 12 Clause 1 of the Industrial Standardization Law applicable to the case of revision by the provision of Article 14.

Consequently JIS R 6251:1999 is replaced with this Standard.

This Standard has been made based on ISO 3366:1999 *Coated abrasives—Abrasive rolls* and ISO 21948:2001 *Coated abrasives—Plain sheets* for the purpose of making it easier to compare this Standard with International Standard; to prepare Japanese Industrial Standard conforming with International Standard; and to propose a draft of an International Standard which is based on Japanese Industrial Standard.

Attention is drawn to the possibility that some parts of this Standard may conflict with a patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have technical properties. The relevant Minister and the Japanese Industrial Standards Committee are not responsible for identifying the patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have the said technical properties.

Date of Establishment: 1952-04-14

Date of Revision: 2006-03-25

Date of Public Notice in Official Gazette: 2006-03-27

Investigated by: Japanese Industrial Standards Committee
Standards Board
Technical Committee on Ceramics

JIS R 6251 : 2006, First English edition published in 2006-11

Translated and published by: Japanese Standards Association
4-1-24, Akasaka, Minato-ku, Tokyo, 107-8440 JAPAN

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

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Printed in Japan

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Abrasive cloths

Introduction This Japanese Industrial Standard has been prepared based on the second edition of ISO 3366 *Coated abrasives—Abrasive rolls* published in 1999 and the first edition of ISO 21948 *Coated abrasives—Plain sheets* published in 2001. This Standard covers only abrasive cloths among the coated abrasives specified in the said original International Standards and adopts the corresponding parts (class, size, tolerance and marking) of the said International Standards with some modifications of the technical contents, while adding some requirements (quality, materials, test methods and inspection) that are unique to Japanese Industrial Standard.

The portions given continuous sidelines or dotted underlines are the matters in which the original International Standard has been modified. A list of modifications with explanations is shown in Annex (informative).

1 Scope This Standard specifies the abrasive cloths to be used for grinding and polishing process of metal, wood, and the others.

NOTE : The International Standards corresponding to this Standard are as follows :

In addition, symbols which denote the degree of correspondence between the relevant International Standards and JIS are IDT (identical), MOD (modified), and NEQ (not equivalent) according to ISO/IEC Guide 21.

ISO 3366 : 1999 *Coated abrasives—Abrasive rolls* (MOD)

ISO 21948 : 2001 *Coated abrasives—Plain sheets* (MOD)

2 Normative references The following standards contain provisions which, through reference in this text, constitute provisions of this Standard. The most recent editions of the standards (including amendments) indicated below apply.

JIS L 1096 *Testing methods for woven fabrics*

JIS R 6010 *Coated abrasive grain sizes*

JIS R 6111 *Artificial abrasives*

JIS Z 8401 *Guide to the rounding of numbers*

3 Classification Abrasive cloths shall be classified as shown in table 1 according to shape, material of abrasives, and grain size of abrasives.

Table 1 Classification of abrasives

Type by shape	Type by material of abrasives (symbol)	Type by grain size of abrasives
Sheet	Alumina abrasives (A, WA, PA, HA, AZ)	P24, P30, P36, P40, P50, P60, P80, P100, P120, P150, P180, P220, P240,
Roll	Silicon carbide abrasives (C, GC) Garnet (G)	P280, P320, P360, P400, P500, P600, P800, P1 000

NOTES 1 See JIS R 6111 for the requirements of the material of abrasives.

2 See JIS R 6010 for the requirements of the grain size of abrasives.

4 Quality

4.1 Appearance On abrasive cloths, there shall be no flaws, wrinkles, breaks, holes, and coating unevenness, which are detrimental to use.

4.2 Characteristics The characteristics of abrasive cloths shall be as shown in table 2. Carry out the test for characteristics according to clause 7.

Table 2 Characteristics of abrasive cloths

Unit : N/25 mm

Type by shape	Type by grain size	Characteristics		
		Tensile strength		Flexibility
		Widthwise	Lengthwise	
Sheet	P24 to P60	147 min.	441 min.	The width of a break shall not exceed 1.5 times of the thickness of abrasive cloths.
	P80 to P1 000	98 min.	196 min.	
Roll	P24 to P60	—	539 min.	
	P80 to P1 000	—	196 min.	

5 Dimensions and tolerances

5.1 Dimensions The dimensions of abrasive cloths shall be generally as shown in table 3.

Table 3 Dimensions of abrasive cloths

Unit : mm

Type by shape	Dimensions	
Sheet	Width × length	70 × 115, 70 × 230, 93 × 230, 115 × 140, 115 × 280, 140 × 230, 230 × 280
Roll	Width	12.5, 15, 25, 35, 40, 50, 75, 80, 93, 100, 115, 120, 125, 150, 200, 300, 600
	Length	25 000, 36 500, 50 000

5.2 Tolerances The dimensional tolerances of abrasive cloths shall be as shown in table 4.