



**SLOVENSKI STANDARD**  
**SIST EN 13236:2001/A1:2005**  
**01-julij-2005**

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**Varnostne zahteve za superabrazive**

Safety requirements for superabrasives

Sicherheitsanforderungen für Schleifwerkzeuge mit Diamant oder Bornitrid

Prescriptions de sécurité pour les produits superabrasifs

**Ta slovenski standard je istoveten z: EN 13236:2001/A1:2005**

**ICS:**

25.100.70      Brusiva      Abrasives

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 13236:2001/A1**

March 2005

ICS 25.100.70

English version

## Safety requirements for superabrasives

Prescriptions de sécurité pour les produits superabrasifs

Sicherheitsanforderungen für Schleifwerkzeuge mit  
Diamant oder Bornitrid

This amendment A1 modifies the European Standard EN 13236:2001; it was approved by CEN on 17 February 2005.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for inclusion of this amendment into the relevant national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This amendment exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

Management Centre: rue de Stassart, 36 B-1050 Brussels

**EN 13236:2001/A1:2005 (E)****Foreword**

This document (EN 13236:2001/A1:2005) has been prepared by Technical Committee CEN/TC 143 "Machine tools - Safety", the secretariat of which is held by SNV.

This Amendment to the European Standard EN 13236:2001 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by August 2005, and conflicting national standards shall be withdrawn at the latest by August 2005.

This document can be applied only in conjunction with EN 13236: 2001 *Safety requirements for superabrasives*. Except for the following amendments the content of EN 13236: 2001 remains untouched.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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## 1 Modification to sub-clause 5.2.8.1.2

### 5.2.8.1.2 Material and hardness of blanks for laser welded cutting-off wheels

Replace the 1<sup>st</sup> paragraph by:

“The material used for the blank shall be steel which shall have the necessary properties enabling it to produce adequate joint strength when welding it to the segments. For example, alloyed cold worked steels having a maximum carbon content of 0,27 % are suitable.”

Replace the last paragraph by:

“Blanks shall be hardened and tempered: — hardness 36 ( $\pm$  3) HRC; or

Blanks may be strain-hardened: — minimum hardness 20 HRC for a diameter  $\leq$  230 mm;

— minimum hardness 24 HRC for a diameter  $>$  230 mm.”

## 2 Modification to sub-clause 5.2.8.1.3

### 5.2.8.1.3 Material and hardness of blanks for sintered cutting-off wheels

Delete the last paragraph.

## 3 Modification to sub-clause 6.2.4.1

### 6.2.4.1 Non destructive bending test

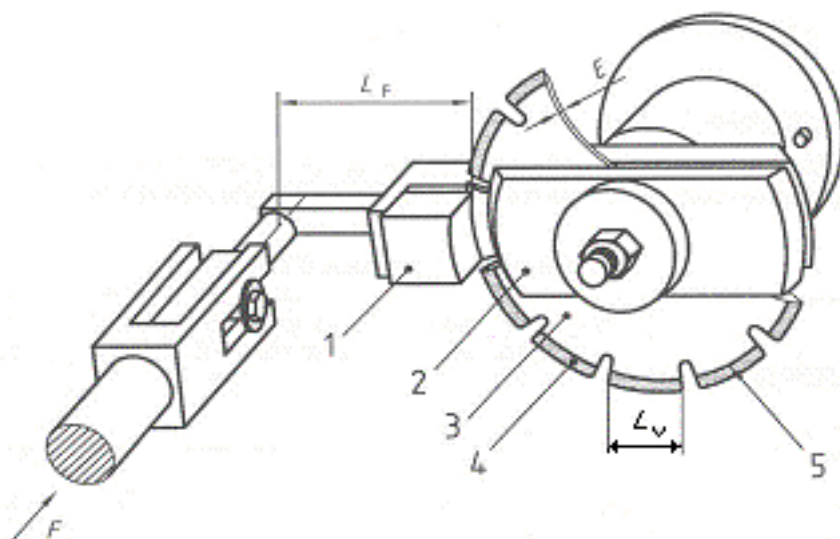
Replace the 1<sup>st</sup> paragraph by:

“In bending test the cutting-off wheel is held in the area of the blank in such a way to guarantee that the required minimum bending strength is applied. The distance between the outer edge of the holding device of the blank and the blank/segment interface is approximately 2 mm. The segment to be tested is held up to the depth corresponding to the depth  $X$  of the segment by either a clamping piece or a device fitted with a gauged slot corresponding to the width  $T$  of the segment with a maximum limit deviation of + 0,5 mm. The clamping piece and the device with the gauged slot have approximately the same length as the segment and a profile similar to the periphery of the blank (Figure 1).”

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**Key**

- 1 Clamping piece
- 2 Clamping plate
- 3 Blank
- 4 Segment
- 5 Blank/segment interface

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**Figure 1 — Example of a bending test device for segmented cutting-off wheels**

Replace the 2<sup>nd</sup> paragraph by:

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Load is applied to the clamping piece or the device fitted with a gauged slot at a distance  $L_F$  from the blank/segment interface. The force,  $F$ , applied is measured and recorded.”