
Back-up pads for vulcanized fibre discs

Plateaux d'appui pour disques en fibres vulcanisées

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ISO 15636:2003

<https://standards.iteh.ai/catalog/standards/sist/e393040a-47c2-43a3-ad8c-85eded84a6bb/iso-15636-2003>



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Published in Switzerland

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established 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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 15636 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 5, *Grinding wheels and abrasives*.

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Back-up pads for vulcanized fibre discs

1 Scope

This International Standard specifies the design and dimensions of back-up pads intended for the fixing or clamping of vulcanized fibre discs in accordance with ISO 16057, or comparable grinding tools on hand-held grinding machines, e.g. angle grinders.

The connecting dimensions of support discs and clamping units are matched for spindle ends with the common practice of this kind of hand-held machine.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 16057, *Coated abrasives — Vulcanized fibre discs*

3 Design and dimensions

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3.1 Design

See Figures 1 and 2.

Dimensions in millimetres

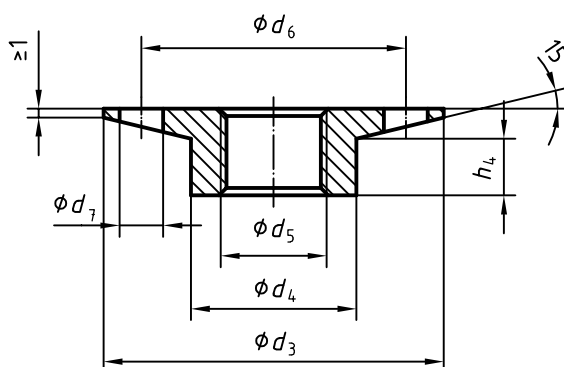


Figure 1 — Clamping nut

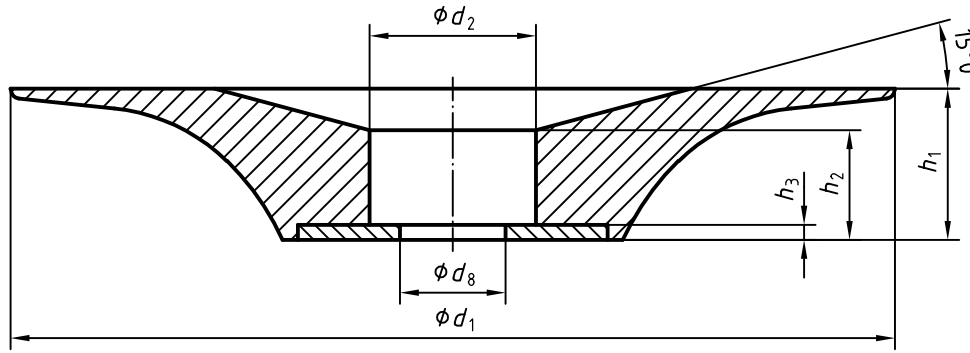


Figure 2 — Back-up pad

3.2 Dimensions

See Table 1.

Table 1 — Dimensions of back-up pads and nuts

Dimensions in millimetres

Vulcanized fibre discs ^a		Back-up pads							Nuts								
		d_1	d_2	d_8	h_1	h_2	h_3	d_3	d_4	Thread (d_5)	d_6	d_7	h_4				
D		± 1	$+0,5$ 0	H11	$\pm 0,4$	$\pm 0,4$	min.	$\pm 0,2$	0 $-0,3$		$\pm 0,1$	H12					
100	$\pm 1,5$	92,5	16	10	16	16	1,5	40	16	M10	20	4,5	$h_4 < h_2 - h_3$				
			22	14 5/8"	20	14,5	2	45	22	M14 5/8 UNC	35	5,8					
115	$\pm 1,5$	107,5	22	14	20	14,5	2	45	22	M14 5/8 UNC	35	5,8					
				5/8"	14,5	2	45	22	M14 5/8 UNC	35	5,8						
125	± 2	117	22	14	20	14,5	2	45	22	M14	35	5,8					
5/8"				M14 5/8 UNC													
150				142						22				14	12	55	M14 5/8 UNC
180				172						22				14	14,5	40	M14
5/8"										14			12	22	M14 5/8 UNC		
235	227	22	14	12	22	M14 5/8 UNC											

^a In accordance with ISO 16057.

4 Requirements

4.1 Material

4.1.1 Back-up pad

The back-up pad shall be of polymer, the type of which shall be determined at the manufacturer's discretion.

4.1.2 Clamping nut

The clamping nut material shall be established at the manufacturer's discretion.

4.2 Scope of delivery

The scope of delivery comprises back-up pads and appropriated clamping nut.

5 Designation

A back-up pad conforming to this International Standard shall be designated by

- a) "Back-up pad";
- b) reference to this International Standard, i.e. ISO 15636;
- c) the outside diameter of the disc, d_1 , in millimetres;
- d) screw thread (the thread diameter of the nut d_5);
- e) maximum permissible frequency of rotation, minute to the power minus one (min^{-1}).

EXAMPLE A back-up pad with a diameter, $d_1 = 107,5$ mm, diameter, $d_5 = 5/8$ UNC and a maximum permissible frequency of rotation of $13\,300 \text{ min}^{-1}$ is designated as follows:

Back-up pad ISO 15636 — 107,5 × 5/8 UNC/13300

6 Marking

A back-up pad in accordance with this International Standard shall be marked with:

— manufacturer or supplier or importer or their registered trademark,

and

— maximum permissible speed of rotation.

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ICS 25.100.70

Price based on 3 pages