
Holding fixtures of cylindrical abrasive sleeves —

**Part 2:
Holding fixtures for stationary machines**

*Porte-manchons pour manchons abrasifs cylindriques —
Partie 2: Porte-manchons pour machines fixes*

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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 3.

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 part of ISO 15637 may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 15637-2 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 5, *Grinding wheels and abrasives*.

ISO 15637 consists of the following parts, under the general title *Holding fixtures of cylindrical abrasive sleeves*:

- *Part 1: Holding fixtures with shank for hand-held grinding machines*
- *Part 2: Holding fixtures for stationary machines*

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Holding fixtures of cylindrical abrasive sleeves —

Part 2:

Holding fixtures for stationary machines

1 Scope

This part of ISO 15637 applies to holding fixtures for use with cylindrical abrasive sleeves with $D > 100$ mm in accordance with ISO 2421. These holding fixtures clamp the cylindrical abrasive sleeves using different systems, e.g. with a lamellar core or using a pneumatic system, which are used on stationary grinding machines.

2 Normative reference

The following normative document contains provisions which, through reference in this text, constitute provisions of this part of ISO 15637. For dated references, subsequent amendments to, or revisions of, this publication do not apply. However, parties to agreements based on this part of ISO 15637 are encouraged to investigate the possibility of applying the most recent edition of the normative document indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 2421:—¹⁾, *Coated abrasives — Cylindrical sleeves*, ISO 15637-2:2002
http://www.iso.org/iso/catalogue_detail.htm?csnumber=45554
standards/sist/d55baa62-a36a-44ee-b60c-7851c0aa04ce/iso-15637-2-2002

3 Design and dimensions

3.1 Design

The shape and design of the holding fixtures with shank are at the manufacturer's discretion; only the specified dimensions and tolerances shall be observed. See Figure 1.

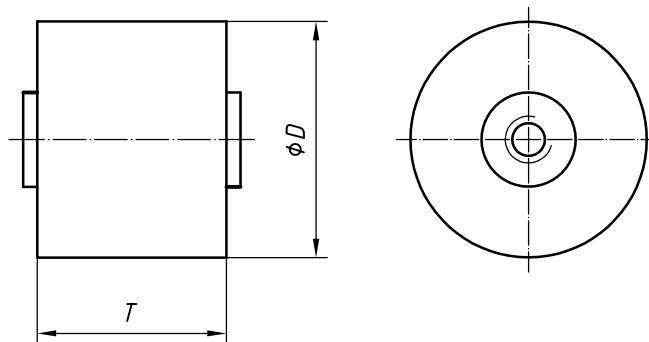


Figure 1

1) To be published. (Revision of ISO 2421:1972)

3.2 Dimensions

See Table 1.

Table 1 — Dimensions

		Dimensions in millimetres	
Nominal	<i>D</i>	<i>T</i> ± 2	
	Limit deviations		
125	−0,1 −0,8	150	
		200	
150	−0,1 −0,8	215	
		225	
		300	
160	−0,1 −0,8	150	
		200	
		250	
175	−0,1 −0,8	100	
		150	
		200	
		250	
200	−0,2 −0,9	150	
		200	
		250	
250	−0,2 −0,9	150	
		200	
		250	
315	−0,2 −1,0	250	
		300	

4 Requirements

Requirements shall be at the manufacturer's discretion.

5 Designation

A holding fixture conforming to this part of ISO 15637 shall be designated by

- a) "Holding fixture";
- b) reference to this part of ISO 15637, i.e. ISO 15637-2;
- c) its dimensions *D* and *T* in millimetres;
- d) its maximum operating speed v_s in meters per second.

EXAMPLE A holding fixture with diameter $D = 200$ mm, thickness $T = 150$ mm and maximum operating speed $v_s = 40$ m/s is designated as follows:

Holding fixture ISO 15637-2 - 200 × 150/40

6 Marking

Holding fixtures in accordance with this part of ISO 15637 shall be marked with:

- dimensions D and T ;
- name of manufacturer or supplier or importer or their registered trademark;
- maximum permissible speed of rotation.

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