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International Standard



603/2

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INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

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**Bonded abrasive products — Grinding wheel  
dimensions —  
Part 2 : Cutting-off wheels, type 1**

*Produits abrasifs agglomérés — Dimensions des meules — Partie 2 : Meules plates de tronçonnage, type 1*

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Descriptors : tools, abrasives, parting tools, grinding wheels, parting tools.

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up 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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 603/2 was developed by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the member bodies in March 1979.

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It has been approved by the member bodies of the following countries :

Australia	Germany, F.R.	Poland
Austria	Hungary	Romania
Belgium	India	South Africa, Rep. of
Bulgaria	Israel	Spain
Canada	Italy	Sweden
Chile	Korea, Dem. P. Rep. of	Switzerland
Czechoslovakia	Korea, Rep. of	United Kingdom
France	Netherlands	USSR

The member bodies of the following countries expressed disapproval of the document on technical grounds :

Japan  
USA

# Bonded abrasive products – Grinding wheel dimensions –

## Part 2 : Cutting-off wheels, type 1

### 0 Introduction

International Standard 603 gives a general table of grinding wheel dimensions in millimetres. ISO 603 consists of several parts, corresponding to the different kinds of grinding wheels.

These parts are as follows :

Part 1 : Plain grinding wheels for fettling, and general sharpening, types 1, 5 and 7.

Part 2 : Cutting-off wheels, type 1.

Part 3 : Cylinder grinding wheels, type 2.

Part 4 : Depressed centre wheels, type 27.

Part 5 : Cup grinding wheels, types 6 and 11, dish wheel, type 12.

Part 6 : Threaded insert.

Part 7 : Segments of grinding wheels.

Part 8 : Mounted wheels.

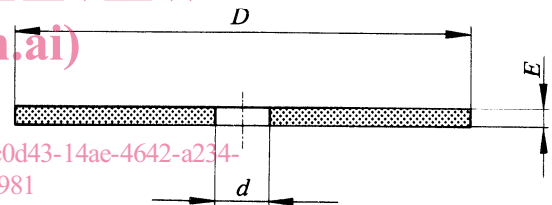
### 1 Scope and field of application

This part of ISO 603 specifies the dimensions, in millimetres, of cutting-off wheels, type 1.

### 2 Reference

ISO 525, *Bonded abrasive products – General features – Designation, ranges of dimensions, and profiles.*

### 3 Dimensions



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Dimensions in millimetres

D	E		d										
	min.	max.	9,53 <sup>1)</sup>	10	13	16	20	22,23 <sup>1)</sup>	25,4 <sup>2)</sup>	32	40	60	76,2
63	0,8	3,2	X	X	X								
80	0,8	3,2	X	X	X								
100	0,8	3,2	X	X		X	X						
125	0,8	3,2						X					
150	0,8	3,2				X	X			X			
180	0,8	3,2				X		X		X			
200	0,8	3,2				X	X			X			
230	1,6	4,0						X					
250	1,6	4,0				X			X	X			
300	1,6	4,0						X	X	X			
350	2,5	4,0							X	X			
400	2,5	5,0							X	X	X		
500	3,2	6,0							X	X	X		X
600	4,0	8,0							X	X		X	X

1) The grinding wheels with the hole diameter values are intended to be mounted on portable machines only.

2) This value of 25,4 is maintained for a temporary period, the value of 32 will replace it in the future.

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