
**Coated abrasives — Plain discs with holes
for dust extraction**

*Produits abrasifs appliqués — Disques simples avec trous pour extraction
de la poussière*



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Foreword

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

International Standard ISO 21951 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 5, *Grinding wheels and abrasives*.

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Coated abrasives — Plain discs with holes for dust extraction

1 Scope

This International Standard specifies the nominal dimensions of plain discs with holes for dust extraction.

Plain discs in accordance with this International Standard are intended for use on disc sanders with dust extraction.

2 Normative reference

The following normative document contains provisions which, through reference in this text, constitute provisions of this International Standard. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this International Standard 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 554:1976, *Standard atmospheres for conditioning and/or testing — Specifications*.

3 Types and dimensions

3.1 Types

See Figures 1 and 2 and Table 1.

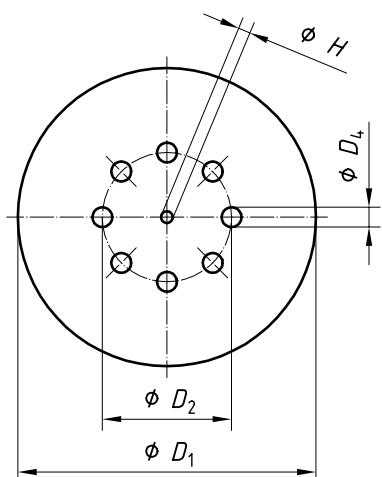


Figure 1 — Type A disc

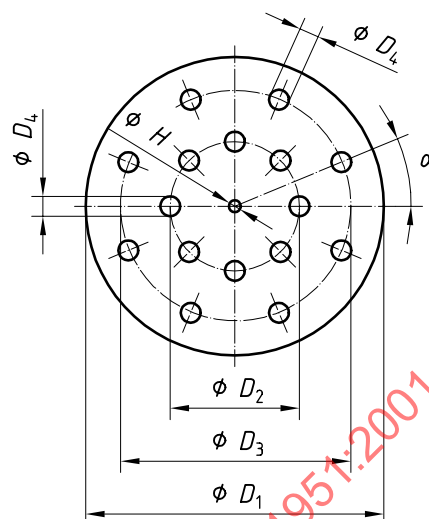


Figure 2 — Type B disc

Table 1 — Dimensions

Dimensions in millimeters

Type	Nominal code	D_1	Limit deviations	D_2 ± 1	D_3 ± 1	D_4 $\pm 0,5$	H $\pm 0,5$	α	Number of holes per circle
A	1	80	$\pm 1,5$	50	—	10	—	—	6
	2	100		65			—		8
	3	115	$\pm 1,5$	41			6		4
	4	115		65			—		8
	5	125	± 2	41			6		4
	6	125		65			—		8
	7	125		72			—		5
	8	150		65			6		8
	9	150		65			—		8
	10	150		80			—		6
	11	150		120			—		6
	12	150		120			18,5		8
	13	200		128			—		8
B	1	150	± 2	65	116	6	22,5°		
	2	180		90	140				
	3	200	± 2	105	150			12	
	4	230		105	150			14	

3.2 Test conditions

The limit deviations given in Table 1 are valid under the following conditions:

- Temperature: $20\text{ }^{\circ}\text{C} \pm 2\text{ }^{\circ}\text{C}$
 - Relative humidity: $65\text{ }\% \pm 5\text{ }\%$
- } in accordance with ISO 554

When plain discs are tested they shall be stored for at least 24 h under the above conditions.

4 Designation

A plain disc with holes for dust extraction conforming to this International Standard shall be designated by

- a) "Abrasive disc";
- b) reference to this International Standard, i.e. ISO 21951;
- c) type A or B;
- d) nominal code.

EXAMPLE A plain disc of Type A with nominal code 4 is designated as follows:

Plain disc ISO 21951 A 4

5 Marking

Plain discs with holes for dust extraction shall be marked with

- a) grain size;
- b) manufacturer, supplier, importer or their registered trademark.

Bibliography

- [1] ISO 6344-1:1998, *Coated abrasives — Grain size analysis — Part 1: Grain size distribution test*.
- [2] ISO 6344-2:1998, *Coated abrasives — Grain size analysis — Part 2: Determination of grain size distribution of macrogrits P12 to P220*.
- [3] ISO 6344-3:1998, *Coated abrasives — Grain size analysis — Part 3: Determination of grain size distribution of microgrits P240 to P2500*.

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