

INTERNATIONAL STANDARD

ISO 15635

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Coated abrasives — Flap discs

Produits abrasifs appliqués — Disques à lamelles



Reference number
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Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.ch
Web www.iso.ch

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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 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 15635 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 5, *Grinding wheels and abrasives*.

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Coated abrasives — Flap discs

1 Scope

This International Standard specifies the nominal dimensions, tolerances and designations of flap discs.

It applies to flap discs intended for use on hand held grinding machines without support discs.

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 Requirements

3.1 Types and dimensions

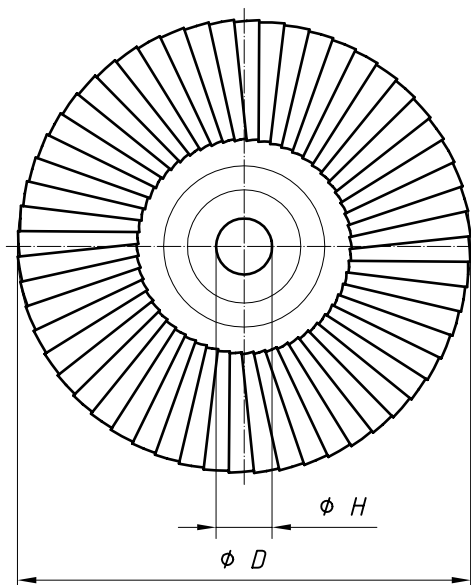
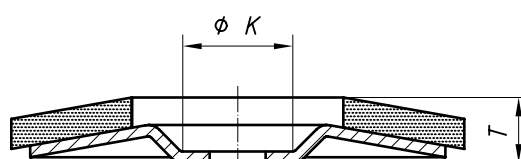
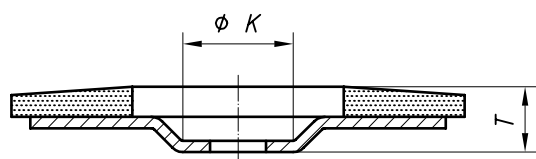


Figure 1 — Type A disc

Figure 2 — Type B disc

Table 1 — Dimensions

Dimensions in millimeters

D	± 3	100	115	125	150	180	200	230
H	$\begin{matrix} +0,16 \\ 0 \end{matrix}$	16	22,23					
K	min.	35,5	45					
T		≤ 22						

3.2 Test conditions

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

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

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

4 Designation

A flap disc conforming to this International Standard shall be designated by

- a) "Flap disc";
- b) reference to this International Standard, i.e. ISO 15635;
- c) Type A or B;
- d) outside diameter, D , in millimetres.

EXAMPLE A flap disc Type A with outside diameter $D = 180$ mm is designated as follows:

Flap disc ISO 15635 A 180

5 Marking

Flap discs shall be marked with:

- a) grain size;
- b) manufacturer, supplier, importer or their registered trademark;
- c) outside diameter;
- d) maximum operating speed;
- e) maximum permissible speed of rotation.

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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