INTERNATIONAL STANDARD

ISO 15636

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Back-up pads for vulcanized fibre discs

Plateaux d'appui pour disques en fibres vulcanisées

Reference number
ISO 15636:2003(E)

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Foreword

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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*.

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

3.1 Design

See Figures 1 and 2.

Dimensions in millimetres

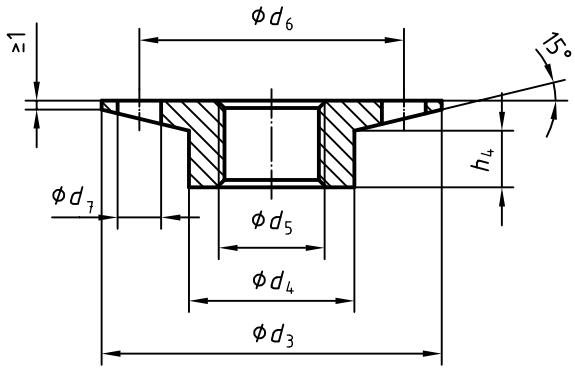

Figure 1 — Clamping nut

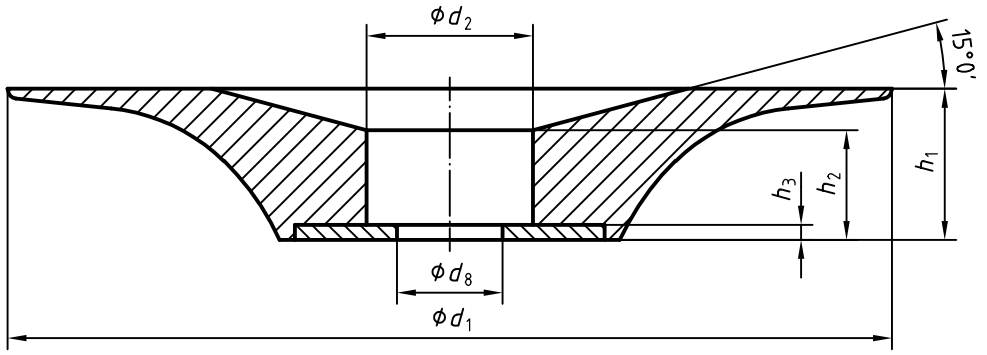

Figure 2 — Back-up pad

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

ICS 25.100.70

Price based on 3 pages