

ICS 25.100.70

CCS J43



**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 14319-2008

Replacing GB/T 14319-1993

**Bonded abrasive products - Vitrified stones for force-honing
and superfinishing**

固结磨具 陶瓷结合剂强力珩磨磨石与超精磨磨石

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Foreword

This standard replaces GB/T 14319 "super oil stone" and GB/T 14320 "vitrified honing stone", the main substance of the amendment as follows:

- Modify the Whetstone whetstone;
- Increasing the foreword;
- Modify the normative references;
- Modify the grindstone shape code, abrasive particle size markers;
- Modified tag example grindstone;
- Deleted kgf Rockwell hardness value of working conditions in the steel ball load will 300.25N corrected to 306N;
- Redefined grindstone inspection rules (Chapter 6 of this standard). The standard proposed by China Machinery Industry Federation. This standard by the National Standardization Technical Committee Abrasives (SAC/TC139) centralized. This standard was drafted. Zhengzhou Institute of abrasive grinding abrasive Abrasives Co., Ltd. and pigeons. The main drafters of this standard. Li Ning, Ma Jianyong, Chang Wu. This standard replaces the standards previously issued as follows:
 - GB/T 14319-1993, GB/T 14320-1993. Vitrified bonded abrasive grindstone and honing Ultra-fine grinding millstone

1 Scope

GB/T 14319-2008 is the Chinese national standard on bonded abrasive products - vitrified stones for force-honing and superfinishing, in the field of manufacturing engineering. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 3 June 2008 by the General Administration of Quality Supervision, Inspection and Quarantine of the People's Republic

of China; Standardization Administration of China, and has been in force since 1 January 2009. Classification: ICS 25.100.70, CCS J43. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This standard specifies the ultra-fine grinding grindstone and vitrified honing grindstone product classifications, technical requirements, test methods, inspection rules And signs, packaging, transportation and storage. This standard applies to a particle size of F320 ~ F1200 various common abrasives vitrified superfinishing grindstone; This standard applies to the honing process can be strong in the grinding load 7.84MPa ~ 39.2MPa ordinary abrasive vitrified Honing grindstone.

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard. GB/T 2476 abrasive code

GB/T 2481.1 Bonded abrasives grain size composition testing and labeling - Part 1. kibble F4 ~ F220 (GB/T 2481.1-1998, eqv ISO 8486-1.1998)

GB/T 2481.2 Bonded abrasives grain size composition testing and marking Part 2. Powder F230 ~ F1200 (GB/T 2481.2-1998, eqv ISO 8486-2.1998)

GB/T 2484 Bonded Abrasives - General requirements (GB/T 2484-2006, ISO 525.1999, MOD)

GB/T 2490-2007 abrasive hardness test

GB/T 2495 abrasive products packaging

GB/T 4127.10 abrasive products - Dimensions - Part 10. ultra-fine grinding and honing grindstone (GB/T 4127.10-2008, ISO 603-10.1999, MOD)

JB/T 7992 ordinary abrasive appearance, dimensions and geometric tolerances Test Method

JB/T 10450 ordinary abrasive inspection rules

3.1 Shape of the grindstone

3.1.1 rectangular shape grindstone as defined in Figure 1. Code. 5410 Figure 1