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

GB/T 4127.12-2008

Replacing GB/T 4127-1997

**Bonded abrasive products -- Dimensions -- Part 12: Grinding
wheels for deburring and fettling on a straight grinder**

固结磨具 尺寸 第12部分：直向砂轮机用去毛刺和荒磨砂轮

(English Translation)

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Foreword

GB/T 4127 "ordinary abrasive Size" is divided into 16 parts.

- Part 1. Cylindrical grinding wheel;
- Part 2. centerless cylindrical grinding wheel;
- Part 3. inner circle grinding wheel;
- Part 4. Surface grinding with peripheral grinding wheel;
- Part 5. Surface grinding end face grinding wheel;
- Part 6. Tools and tool room grinding wheels for;
- Part 7. manually operated grinding wheel;
- Part 8. deburring, snagging and rough grinding with a grinding wheel;
- Part 9. heavy-duty grinding wheel;
- Part 10. ultra-fine grinding and honing grindstone;
- Part 11. manual polishing grindstone;
- Part 12. vertical grinder deburring and shortage of scrub round;
- Part 13. Vertical grinder deburring and shortage of scrub round;
- Part 14. angle grinder deburring, snagging and rough grinding with a grinding wheel;
- Part 15. fixed or mobile cutting machine cutting wheel;
- Part 16. Hand-held power tool with a cutting wheel.

This section GB/T Part of 124,127.

The partial modification using ISO 603-12:1999 "abrasive products - Dimensions - Part 12. vertical grinder deburring and barren scrub Wheel "(in English).

Taking into account China's national conditions, in the use of ISO 603-12:1999 when this

part has made several modifications. About the technical differences have been incorporated into the text in which they are involved and the terms of the margin of a single vertical line identification. It gives a technical difference in Appendix A (Informative appendix) its list of different reasons for reference.

For ease of use, this section also made the following editorial changes.

- The "this part of ISO 603" with the words "this section";
- With a decimal point instead of a comma as the decimal point, ",";
- Delete international standards foreword.

This Part replaces GB/T 4127-1997 "bonded abrasive grinding wheel shape and size" section of content. The modifications are the following.

- In order to be consistent with international names such products, the standard of "ordinary abrasive" to "abrasive";
- Added "Type 4. double hypotenuse Wheel", "16. with tapered core grinding", "18. with cylindrical grinding core", "18R. with half core Spherical grinding", "19. with an elliptical cone grinding core" provisions;
- Original Type 53 grinding are defined as "16a type. elliptical cone grinding", "17a type. 60° cone grinding", "17b type. round cone grinding", "17c type. truncated cone grinding", "18a type. cylindrical grinding", "18b Type. hemispherical grinding", "19a Type. spherical grinding."
- Increase the marked products, technical requirements and marking requirements.

This part is proposed by China Machinery Industry Federation.

This part of the National Standardization Technical Committee Abrasives (SAC/TC139) centralized.

This section is drafted. Chengdu Wheel Co., Ltd.

1 Scope

This section GB/T 4127 provisions of the following abrasive dimensions, marking and requirements.

- Type 1. flat-shaped grinding wheel
- 4 types. double bevel wheel
- 16. cored conical grinder
- Type 18. with a core cylindrical grinding
- 18R Type. hemispherical grinding tape core

- 19 type. cored elliptical cone grinding
- 16a type. elliptical cone grinding
- 17a Type. 60 ° cone grinding
- 17b type. round cone grinding
- 17c type. truncated cone grinding
- 18a type. cylindrical grinding
- 18b Type. hemispherical grinding
- 19a Type. spherical grinding
- Model 52. Petiole grinding this class is suitable for ordinary abrasive handheld vertical grinder deburring and snagging any workpiece surface. Work fixing, by the hand-held grinder manipulate.

2 Normative references

The following documents contain provisions which, through reference in this part of the GB/T 4127, constitute provisions of this part. For dated reference documents Member, all subsequent amendments (not including errata content) or revisions do not apply to this section, however, encouraged to reach under this section Parties to research agreement to use the latest versions of these documents. For undated reference documents, the latest versions apply to this section.

GB/T 2484 Bonded Abrasives - General requirements (GB/T 2484-2006, ISO 525:1999, MOD) GB/T 2485 abrasive technical conditions

3 Dimensions

Type 1 3.1. flat-shaped grinding wheel

Figure 1 and Table 1.

Figure 11 Type