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

**GB/T 4127.14-2025**

Replacing GB/T 4127.14-2008

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**Bonded abrasive products - Dimensions - Part 14: Grinding  
wheels for deburring and fettling/snagging on an angle grinder  
(English Translation)**

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## Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for standardization work Part 1: Structure and drafting rules for standardization documents" Drafting.

This document is Part 14 of GB/T 4127 "Dimensions of bonded abrasives". The following parts of GB/T 4127 have been published.

- Part 1: Cylindrical grinding wheels (workpiece clamped between centers);
- Part 2: Centerless external cylindrical grinding wheels;
- Part 3: Internal grinding wheels;
- Part 4: Peripheral grinding wheels for surface grinding;
- Part 5: End grinding wheels for surface grinding;
- Part 6: Grinding wheels for tool grinding and tool room use;
- Part 7: Manually operated grinding wheels;
- Part 8: Grinding wheels for deburring, rough grinding and rough grinding;
- Part 9: Heavy-duty grinding wheels;
- Part 10: Honing and superfinishing grinding stones;
- Part 11: Hand-held polishing stones;
- Part 12: Deburring and roughening wheels for straight grinders;
- Part 13: Deburring and roughening wheels for vertical grinding machines;
- Part 14: Deburring, roughing and grinding wheels for angle grinders;
- Part 15: Cutting wheels for fixed or mobile cutting machines;
- Part 16: Cutting wheels for hand-held power tools;
- Part 17: Grinding points with handle;
- Part 18: Grinding wheels for flat glass edging.

This document replaces GB/T 4127.14-2008 "Bonded abrasive tools - Dimensions - Part 14: Deburring, roughening and roughening for angle grinders" Compared with GB/T 4127.14-2008, in addition to structural adjustments and editorial changes, the main technical changes are as follows.

- a) The dimensions of the cup grinding wheel (type 6) have been changed (see 4.1, 3.1 of the 2008 edition);

- b) The dimensions of the cup grinding wheel (type 11) have been changed (see 4.2, 3.2 of the 2008 edition);
- c) The dimensions of the cymbal grinding wheel (type 27) have been changed (see 4.3, 3.3 of the 2008 edition);
- d) The dimensions of the conical cymbal grinding wheel (type 28) have been changed (see 4.4, 3.4 of the 2008 edition);
- e) Added convex cymbal grinding wheels (type 29) and their dimensions (see 4.5);
- f) Deleted the requirements (see Chapter 5 of the 2008 edition).

This document is modified to adopt ISO 603-14:2022 "Bonded abrasive tools - Dimensions - Part 14: Deburring, roughening and roughening tools for angle grinders" Abrasive Wheel.

The technical differences between this document and ISO 603-14:2022 and their reasons are as follows.

- ISO 525 (see Chapter 4) has been replaced by the normative reference GB/T 2484 to adapt to my country's technical conditions;
- Added the size series of type 6 grinding wheels with embedded threads (see Table 1) to conform to my country's actual situation;
- Added the specifications for the end face width of the type 11 grinding wheel ring with embedded threads (see Table 3) to conform to my country's actual situation;
- Added the size series of cymbal grinding wheels (type 27) and deleted the indication for cutting (see 4.3) to conform to the actual situation in my country;
- Added the size series of conical cymbal grinding wheels (type 28) (see Table 6) to conform to my country's actual situation.

The following editorial changes have been made to this document.

- Deleted the imperial size representation of the outside diameter in the international standard;
- Deleted the notes in 4.3 to 4.5 of the international standard;
- Deleted references to international standards.

## Introduction

In order to facilitate the production, trade, application and technical exchange of bonded abrasives and make rational use of resources, it is necessary to establish a standardized bonded abrasive tool scale.

Bonded abrasives have various shapes and uses. Products with the same shape may have

different uses, and products with the same use may also have different with the development of bonded abrasives industry, the advancement of technology and the change of market demand, its shapes and uses are constantly enriched, and its size is constantly increasing.

The size system of bonded abrasive tools is becoming increasingly large, and it is becoming increasingly difficult to establish a size system of bonded abrasive tools through a single standard, which is no longer realistic.

Since 1999, ISO/TC29/SC5 has established a new bonded abrasive tool size system through scientific and reasonable classification and released ISO 603 series standards. GB/T 4127 "Dimensions of bonded abrasives" has adopted ISO 603 series standards since its second revision.

It consists of 18 parts.

--- Part 1: External cylindrical grinding wheels (workpiece clamped between centers). The purpose is to specify external cylindrical grinding wheels (workpiece clamped between centers) Common nominal sizes.

--- Part 2: Centerless external cylindrical grinding wheels. The purpose is to specify the commonly used nominal dimensions of centerless external cylindrical grinding wheels.

--- Part 3: Internal grinding wheels. The purpose is to specify the commonly used nominal sizes of internal grinding wheels.

--- Part 4: Peripheral grinding wheels for surface grinding. The purpose is to specify the commonly used nominal sizes of peripheral grinding wheels for surface grinding.

--- Part 5: End grinding wheels for surface grinding. The purpose is to specify the commonly used nominal dimensions of end grinding wheels for surface grinding.

--- Part 6: Grinding wheels for tool grinding and tool room use. The purpose is to specify the commonly used nominal sizes of grinding wheels for tool grinding and tool room use.

--- Part 7: Manually operated grinding wheels. The purpose is to specify the commonly used nominal sizes of manually operated grinding wheels.

--- Part 8: Grinding wheels for deburring, roughing and rough grinding. The purpose is to specify the common nominal size.

--- Part 9: Heavy-duty grinding wheels. The purpose is to specify the commonly used nominal sizes of heavy-duty grinding wheels.

--- Part 10: Honing and superfinishing grinding stones. The purpose is to specify the commonly used nominal sizes of honing and superfinishing grinding stones.

--- Part 11: Hand-held polishing stones. The purpose is to specify the commonly used nominal sizes of hand-held polishing stones.