

ICS 25.100.70
CCS J 43



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

GB/T 4127.4-2008

Replacing GB/T 4127-1997

**Abrasive size -- Part 4: peripheral grinding wheel surface
grinding
(English Translation)**

Issued on: June 3, 2008

Implemented on: January 1, 2009

Issued by: Standardization Administration of China

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Foreword

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

- Part 1. Cylindrical grinding wheel (workpiece clamping between centers);
- 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. Hand 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 wheel;
- Part 15. fixed or mobile cutting machine cutting wheel;
- Part 16. Hand-held power tool with a cutting wheel.

This section GB/T 44127 Part of.

The partial modification of the use of ISO 603-4:1999 "abrasive products - Dimensions - Part 4. surface grinding/peripheral grinding wheel" (in English).

Taking into account China's national conditions, in the use of ISO 603-4:1999 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) List of very 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.

- Such products is consistent with the name of the international standards in the name of "ordinary abrasive" to "abrasive."
- Increasing the ISO 603-4:1999 type 1, type 5, type 7, type 20, type 21, type 22, Type 23, Type 24, Type 25, Type 26, 38 , 39 and the size of the wheel series.
- Increased product marking, signage requirements and regulations.

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. Suzhou Far East Wheel Co., Ltd., Shandong Luxin High-Tech Industry Co., Ltd.

1 Scope

This section specifies the basic dimensions, marking and requirements for the following models of grinding wheel.

- Type 1. flat-shaped grinding wheel
- Five types. single-sided concave grinding wheel
- Type 7. double-sided concave grinding wheel
- 20 type. single-sided cone wheel
- Type 21. Double-sided cone wheel
- 22 Type. single sided concave cone wheel
- Type 23. with tapered sided concave grinding wheel
- 24 Type. single-sided double-sided concave grinding wheel cone

--- 25 type. single sided concave cone wheel

--- Type 26. Double-sided cone concave grinding wheel

--- 38 type. single-sided convex wheel

--- 39 type. double-sided projection wheel Flat surface grinding abrasive for such a workpiece, the workpiece securely fixed to the movement of the work surface of the workpiece and the grinding wheel by a mechanical 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 See Figure 1, Table 1 and Table 2.

Figure 11 Type

3.2 5 types. single-sided concave grinding wheel

Figure 2, Table 3 and Table 4.