

Grinding wheel shapes according to DIN ISO 525



Form No.	Shape	Form No.	Shape	Form No.	Shape	Form No.	Shape			
1	Straight grinding wheel D x T x H	13	Grinding disc D/J x T/U x H - K	23	Single-sided tapered grinding wheel with recess D x T/N x H - P x F	35	Grinding wheel glued or mounted on a backing plate D x T x H			
2	Grinding cylinder glued or mounted on a backing plate D x T x W	16	Grinding body with threaded insert Cylindrical cone - Grinding cone D x T - H x L	24	Double-sided recessed and single-sided tapered grinding wheel D x T/N x H - P x F/G	36	Grinding wheel screwed to a backing plate, with threaded insert D x T x H			
3	Single-sided conical grinding wheel D/J x T x H	18	Grinding body with threaded insert Cylindrical - Grinding cone D x T - H x L	25	Double-sided tapered and single-sided recessed grinding wheel D/K x T/N x H - P x F	37	Grinding cylinder screwed to a backing plate, with threaded inserts D x T x W (D ₀)			
4	Double-sided conical grinding wheel D x T x H	18R	Grinding body with threaded insert, barrel-shaped - grinding cone D x T - H x L	26	Double-sided tapered and double-sided recessed grinding wheel D x T/N x H - P x F/G	38	Stepped grinding wheel D/J x T/U x H			
5	Single-sided recessed grinding wheel D x T x H - P x F	19	Grinding body with threaded insert, cone D x T - H x L	27	Offset grinding wheel D x U x H	39	Double-stepped grinding wheel D/J x T/U x H			
6	Cylindrical grinding head D x T x H - W x E	20	Single-sided tapered grinding wheel D/K x T/N x H	28	Offset grinding wheel, bell-shaped D x U x H	41	Straight cut-off grinding wheel D x T x H			
7	Double-sided recessed grinding wheel D x T x H - P x F/G	120	Single-sided tapered grinding wheel (with hub) D/K x T/N x H	31	Examples Grinding segment, shape 3101- B x C x L	42	Offset cut-off grinding wheel D x U x H			
9	Cylindrical double grinding head D x T x H - W x E	21	Double-sided tapered grinding wheel D/K x T/N x H		Examples Grinding segment, shape 3104- B/A x C x L/R	52	Examples Mounted points- D x T x S			
11	Conical grinding head D/J x T x H - W x E x K	121	Double-sided tapered grinding wheel (with hub) D/K x T/N x H					Examples Grinding segment, shape 3109 B/A x C x L		
12	Grinding disc D/J x T x H	22	Single-sided tapered grinding wheel with opposite recess D/K x T/N x H - P x F							
									Examples Grinding segment, shape 3109 B/A x C x L	

Form No.	Shape	Shape	Form Nr.	Shape	Shape
54	Examples Grinding stone, shape 5410 B x C x L Grinding stone, shape 5411 B x C x L	Grinding stone, shape 5420 D x T x H Grinding stone, shape 5421 D x T x H - W/E	90	Examples Grinding sticks and honing stones Shape 9010 B x C x L Shape 9011 B x L B=C	Shape 9020 B x L Shape 9030 B x L Shape 9040 B x C x L

Abbreviation	Description
A	Small width of grinding segments
B	Width of grinding segments
C	Height of grinding segments
D	Outer diameter of grinding bodies
E	Base thickness of grinding heads and discs, as well as recessed and tapered grinding wheels
F	Depth of first recess of grinding wheels
G	Depth of second recess of grinding wheels
H	Bore diameter of grinding bodies, thread diameter for grinding bodies with threaded insert
J	Small diameter of conical grinding heads, grinding discs, conical and stepped grinding wheels
K	Inner diameter of conical grinding heads and discs, diameter of taper of grinding wheels
L	Length of grinding segments Screw-in length of grinding bodies with threaded insert
L ₀	Exposed shank length of mounted points
L ₂	Shank length of mounted points
L ₃	Clamping length of shank of mounted points
L _F	Free length of grinding segments
N	Depth of taper of grinding wheels
P	Recess diameter of grinding wheels
S _d	Shank diameter of mounted points
T	Width of grinding bodies
T _D	Tolerance limits of outer diameter
T _H	Tolerance limits of bore diameter
T _T	Tolerance limits of width
U	Small width of conical, stepped, and offset grinding wheels (e.g., Type 4 or Type 38)
W	Wall thickness of grinding heads, cylinders, and discs

Edge shapes:				

1) U = 3.2 mm, unless otherwise specified in the order.
2) For edge shape N, V and X must be specified in the order.



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