Grinding wheel shapes according to DIN ISO 525

Last revision date: November, 2025



Form No.	Shape	Form No.	Shape	Form No.	Shape	Form No.	Shape	
	Straight grinding wheel D x T x H		Grinding disc D/J x T/U x H - K		Single-sided tapered grinding wheel with recess D x T/N x H - P x F		Grinding wheel glued or mounted on a backing plate D x T x H	
1	H D	13		23		35	<u>+</u>	
2	Grinding cylinder glued or mounted on a backing plate	16	Grinding body with threaded insert Cylindrical cone – Grinding cone DxT-HxL	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 DXTXH	
3	Single-sided conical grinding wheel D/J x T x H	18	Grinding body with threaded insert Cylindrical – Grinding cone	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 DxTxW (0) W W	
4	Double-sided conical grinding wheel DxTxH	18R	Grinding body with threaded insert, barrel-shaped – grinding cone	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 DxTxH-PxF	19	Grinding body with threaded insert, cone DxT-HxL	27	Offset grinding wheel	39	Double-stepped grinding wheel D/J x T/U x H	
6	Cylindrical grinding head DxTxH-WxE	20	Single-sided tapered grinding wheel D/K x T/N x H	28	Offset grinding wheel, bell-shaped	41	Straight cut-off grinding wheel	
7	Double-sided recessed grinding wheel DXTXH-PXF/G	120	Single-sided tapered grinding wheel (with hub) D/K x T/N x H		Examples Grinding segment, shape 3101- B x C x L	42	Offset cut-off grinding wheel DxUxH	
9	Cylindrical double grinding head DxTxH-WxE	21	Double-sided tapered grinding wheel D/K x T/N x H	31	Grinding segment, shape 3104-B/A x C x L R		Examples Mounted points- D x T x S shape zy	
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		Grinding segment, shape 3109	52	shape wk	
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		A B		shape KE shape KU shape SP shape TO	

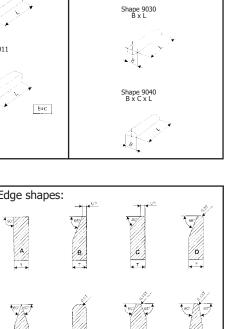
110.				141.					
54	4	imples prinding stone, shape 5410 B x C x L prinding stone, shape 5411 B x C x L	Grinding stone, shape 5420 D x T x H Grinding stone, shape 5421 D x T x H - W/E	90	Shap	e 9010 C x L		* >	
	orevia-		Description			Edge shapes:	→ (^{U9}	→ ∢ ^{⊥2)}	
	A	Small width of grinding s	100	4657	1 457	7			
	В	Width of grinding segme		A T	B	G T			
	С	Height of grinding segme	ents				_s ⁵ /		
	D	Outer diameter of grindi	ng bodies		eo Aco		(6) (6)	1 00	
	E	Base thickness of grindir grinding wheels	ng heads and discs, as well as re	cs, as well as recessed and tapered			Ţ 1 → 1	G / ↑	
	F	Depth of first recess of g	rinding wheels						
	G	Depth of second recess of	of grinding wheels			<u> </u>		7	
	Н	Bore diameter of grinding threaded insert	oodies with	T	<u> </u>				
	J	Small diameter of conica grinding wheels	l grinding heads, grinding discs	130. 130. 100.	**************************************	\\ \tag{\tag{\tag{\tag{\tag{\tag{\tag{			
	K	Inner diameter of conica ding wheels	taper of grin-		3	P			
	L	Length of grinding segminsert	l ↓ ↓ ↓ 1) U = 3.2 mr	n, unless	< ¯ ▶				
	Lo	Exposed shank length of		specified in the order. 2) For edge shape N, V and X must be					
	L ₂	Shank length of mounted	d points			specified in th	e order.		
	L ₃	Clamping length of shan			1FI	FIC			
	L _F Free length of grinding segments							-10(
	N	Depth of taper of grindin	g wheels		THELE	ICO So	chleiftec	hnik	
	Р	Recess diameter of grind	ling wheels		GmbH & Co. KG Lagerstraße 3–5				
	Sd	Shank diameter of moun	ted points			9872 M	eschede		
	Т	Width of grinding bodies				Germ	•		
-	То	Tolerance limits of outer		Tel. +49 (0) 291 / 9901 - 0 Fax +49 (0) 291 / 9901 - 28					
_	Тн	Tolerance limits of bore of	diameter				O THE		
-	Тт	Tolerance limits of width		DIN EN 180 9001					

Small width of conical, stepped, and offset grinding wheels (e.g., Type 4 or

Wall thickness of grinding heads, cylinders, and discs

Shape

Shape



Shape

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