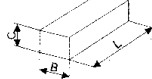
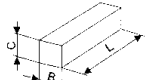
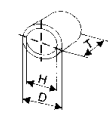
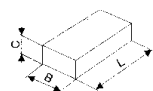
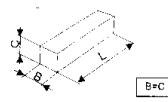
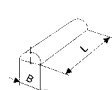


Grinding wheel shapes according to DIN ISO 525

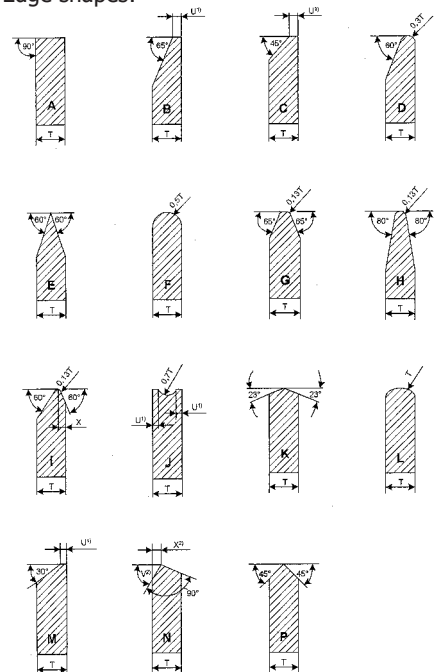


Form No.	Shape	Form No.	Shape	Form No.	Shape	Form No.	Shape
1	Straight grinding wheel $D \times T \times H$ 	13	Grinding disc $D/J \times T/U \times H - K$ 	23	Single-sided tapered grinding wheel with recess $D \times T/N \times H - P \times F$ 	35	Grinding wheel bonded or mounted on a backing wheel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

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

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) $U = 3.2 \text{ mm}$, unless otherwise specified in the order.
- 2) For edge shape N, V and X must be specified in the order.



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