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JIS R 6211-1 : 2003  
(GIS/JSA)

**Bonded abrasive products —  
Dimensions — Part 1: Grinding  
wheels for external cylindrical  
grinding between centres**

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ICS 25.100.70

Reference number : JIS R 6211-1 : 2003 (E)

## Foreword

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee in accordance with the proposal of revising a Japanese Industrial Standard from the Japan Grinding Wheel Association (GIS)/the Japanese Standards Association (JSA), with a draft of Industrial Standard based on the provision of Article 12 Clause 1 of the Industrial Standardization Law which shall be applied by Article 14 of the same Law. Consequently **JIS R 6211-1:1999** is replaced with **JIS R 6211-1:2003**.

In this revision, **ISO 603-1:1999 Bonded abrasive products — Dimensions — Part 1: Grinding wheels for external cylindrical grinding between centres** is used as a basis to make Japanese Industrial Standard conform to the corresponding International Standard.

Attention is drawn to the possibility that some parts of this Standard, which have technical properties, may conflict with a patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public. The Minister of Economy, Trade and Industry and the Japanese Industrial Standards Committee are not responsible for identifying the patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have the said technical properties.

**JIS R 6211** consists of the following 16 parts under the general title *Bonded abrasive products — Dimensions*.

- Part 1: Grinding wheels for external cylindrical grinding between centres*
- Part 2: Grinding wheels for centerless external cylindrical grinding*
- Part 3: Grinding wheels for internal cylindrical grinding*
- Part 4: Grinding wheels for surface grinding/peripheral grinding*
- Part 5: Grinding wheels for surface grinding/face grinding*
- Part 6: Grinding wheels for tool and tool room grinding*
- Part 7: Grinding wheels for manually guided grinding*
- Part 8: Grinding wheels for deburring and fettling/snagging*
- Part 9: Grinding wheels for high-pressure grinding*
- Part 10: Stones for honing and superfinishings*
- Part 11: Hand finishing sticks*
- Part 12: Grinding wheels for deburring and fettling on a straight grinder*
- Part 13: Grinding wheels for deburring and fettling on a vertical grinder*
- Part 14: Grinding wheels for deburring and fettling/snagging on an angle grinder*
- Part 15: Grinding wheels for cutting-off on stationary or mobile cutting-off machines*
- Part 16: Grinding wheels for cutting-off on hand held power tools*

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In the event of any doubts arising as to the contents,  
the original JIS is to be the final authority.

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## Contents

	Page
Introduction .....	1
1 Scope .....	1
2 Normative reference .....	2
3 Dimensions .....	2
3.1 Type 1: Straight grinding wheel .....	3
3.2 Type 5: Wheel recessed on one side .....	4
3.3 Type 7: Wheel recessed on both sides .....	7
3.4 Type 20: Wheel relieved on one side .....	10
3.5 Type 21: Wheel relieved on both sides .....	12
3.6 Type 22: Wheel relieved on one side and recessed on the other side .....	14
3.7 Type 23: Wheel relieved and recessed on one side .....	16
3.8 Type 24: Wheel relieved and recessed on one side and recessed on the other side .....	18
3.9 Type 25: Wheel relieved and recessed on one side and relieved on the other side .....	20
3.10 Type 26: Wheel relieved and recessed on both sides .....	22
3.11 Type 38: Hubbed wheel and Type 39: Double hubbed wheel .....	24
4 Designation .....	26
Annex (informative) Comparison table between JIS and corresponding International Standard .....	27

## **Bonded abrasive products — Dimensions — Part 1: Grinding wheels for external cylindrical grinding between centres**

**Introduction** This part of **JIS R 6211** has been prepared based on the first edition of **ISO 603-1 Bonded abrasive products — Dimensions — Part 1: Grinding wheels for external cylindrical grinding between centres** published in 1999, without modifying the technical contents of the tables in A series. The tables in B series specify the dimensions mainly used in Japanese market. However, A series shall take precedence, and B series will be restudied in five years.

The portions given sidelines or underlines with dots in this part of **JIS R 6211** are the matters not included in the original International Standard.

**1 Scope** This part of **JIS R 6211** specifies the nominal dimensions of grinding wheels for external cylindrical grinding between centres of:

- Type 1: Straight grinding wheel
- Type 5: Wheel recessed on one side
- Type 7: Wheel recessed on both sides
- Type 20: Wheel relieved on one side
- Type 21: Wheel relieved on both sides
- Type 22: Wheel relieved on one side and recessed on the other side
- Type 23: Wheel relieved and recessed on one side
- Type 24: Wheel relieved and recessed on one side and recessed on the other side
- Type 25: Wheel relieved and recessed on one side and relieved on the other side
- Type 26: Wheel relieved and recessed on both sides
- Type 38: Hubbed wheel
- Type 39: Double hubbed wheel

Remarks 1 Bonded abrasive products specified in this part of **JIS R 6211** are intended to be used for external cylindrical grinding between centres. The workpiece and the grinding wheel are mechanically guided.

2 The International Standard corresponding to this part of **JIS R 6211** is as follows:

In addition, symbols which denote the degree of correspondence in the contents between the relevant International Standard and JIS are IDT (identical), MOD (modified), and NEQ (not equivalent) according to **ISO/IEC Guide 21**.

**ISO 603-1:1999** *Bonded abrasive products — Dimensions — Part 1: Grinding wheels for external cylindrical grinding between centres* (MOD)

**2 Normative reference** The following standard contains provisions which, through reference in this part of **JIS R 6211**, constitute provisions of this part of **JIS R 6211**. The most recent edition of the standard (including amendments) shall be applied.

JIS R 6242 *Bonded abrasive products — General — Designation, marking, range of outside diameters and tolerances*

Remarks : **ISO 525:1999** *Bonded abrasive products — General requirements* is equivalent to the said standard.

**3 Dimensions** Dimensions shall be as follows: