

**Product Marking Requirements – Bonded Abrasives**

Requirements for specific products according to EN 12413:2007+A1:2011

	Abrasive wheels <sup>1</sup>	Segments	Mounted wheels and points	Wheels with D ≤ 80 mm	Cones and plugs	Magnesite bond
Trade name	X	X	X	X	X	X
Traceability code	X	X	X	X	X	X
Dimensions (mm)	X	X	X	X	X	X
MOS (rpm or 1/min)	X		X	X	X	X
MOS (m/s)	X			X	X	X
Specification mark	X	X	X	X	X	X
Restrictions to use	X			X		
Declaration of conformity	X	X	X	X	X	X
oSa Logo	X	X	X	X	X	X
Colour stripe (optional)	X			X	X	X
Private label number	<b>Must be used on all private label products bearing the oSa logo</b>					

<sup>1</sup> Abrasive wheels: straight, tapered, hubbed, recessed, relieved, depressed centre, cutting-off, semi-flexible; Cup wheels, dish and saucer wheels, disc wheels, cylinder wheels, cemented or clamped

**Trade name**

Must bear one of the following:

- Company name
- Registered brand name
- Private company's name
- Private company's registered brand name

**Traceability code number**

Although EN 12413 allows the code to be on the product or package, oSa will still require it to be on the product.

It can be either:

- Series number
- Manufacturing batch number
- Despatch or shipping number
- Expiry date

**Dimensions**

- Abrasive products: nominal dimensions in accordance with ISO 525
- Mounted wheels and points: nominal dimensions, diameter of the spindle and minimum clamping length
- Cones and plugs: nominal dimensions, thread diameter and length of insert
- Segments, disc wheels, cylinder wheels cemented, bolted or clamped to a support plate: manufacturer’s code e.g. drawing number
- Ensure correct conversion of imperial bore sizes, e.g. 7/8” is 22.23 mm not 22.2 mm or 22 mm

**MOS – Maximum operating speed**





- Should specify the maximum possible speed that the wheel can be safely used at
- This is the speed that is used to derive the test requirements
- Should be taken from the table in Annex E of EN 12413

**Specification mark**

In accordance with ISO 525. Minimum information required: Abrasive type, grain size, grade or hardness, type of bond and use of reinforcement.

**Restrictions to use**

- Shall be given in full length or by pictogram:

RE 1	RE 3	RE 4	RE 6	RE 8
<b>Not permitted for hand-held machines</b>	<b>Not permitted for wet grinding</b>	<b>Only permitted for totally enclosed working area</b>	<b>Not permitted for face grinding</b>	<b>Only permitted with back-up pad</b>
This restriction only applies to abrasive products not for use on hand-held machines but capable of being mounted on such machines	Abrasive product only suitable for dry grinding	Abrasive product only for use on stationary machines the guarding of which is accepted as totally enclosed working area	Abrasive product only for use on cutting-off. This restriction only applies to abrasive products for use on hand-held machines	Abrasive product only for use with additional appropriate back-up pad
		Currently no pictogram available		

Colour of pictograms according to ISO 3864-2 wherever possible

## Declaration of conformity

All products should be marked: **EN 12413**

## oSa Logo

All products should be marked:



By marking oSa on the product, the manufacturer is confirming that it meets the requirements of EN 12413 and the additional requirements stipulated in the Technical Annex of oSa

## Colour stripe

See EN 12413:2007+A1:2011, Annex D

## Private label number

All products bearing the oSa logo on private label products must also bear the five-digit oSa private label number.

## Additional inscriptions

- Abrasive products for hand-held machines with type of bond B and BF: date of expiry. The date of expiry shall at the longest be within 3 years from the date of manufacture. It is expressed as month and year e.g. 04/2009.
  - Oriented wheels: wheels need to be mounted in a specific position on the spindle shall be marked in such a way as to clearly indicate this position.
  - Multiple or gang mounted wheels: shall be marked in a manner to assure they are correctly mounted on the machine spindle, additionally each wheel shall be identified as being part of that set.
  - Magnesite bond: date of expiry. The date of expiry shall at the longest be within 1 year from the date of manufacture. It is expressed as month and year e.g. 04/2009.
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## Execution of the marking

- Must be legible to the naked eye.
- Must be indelible.
- Where possible the marking shall be on the abrasive product. It can be on the product itself, on a fixed blotter or on a fixed label.

- Products with diameter > 80 mm:

When it is not possible to give all specified information on the abrasive product, a blotter or label, the product itself shall at least be marked with the maximum operating speed in so far as the surface and shape of the product permits.

- Products with diameter ≤ 80 mm, mounted points and wheels and segments:

The specified information can appear on a label fixed to the smallest packaging unit.