## Product Marking Requirements – Bonded Abrasives

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

<table>
<thead>
<tr>
<th></th>
<th>Abrasive wheels</th>
<th>Segments</th>
<th>Mounted wheels and points</th>
<th>Wheels with D ≤ 80 mm</th>
<th>Cones and plugs</th>
<th>Magnesite bond</th>
</tr>
</thead>
<tbody>
<tr>
<td>Trade name</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
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</tr>
<tr>
<td>Traceability code</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
</tr>
<tr>
<td>Dimensions (mm)</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
</tr>
<tr>
<td>MOS (rpm or 1/min)</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
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<tr>
<td>MOS (m/s)</td>
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<tr>
<td>Restrictions to use</td>
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<td></td>
<td></td>
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<td>X</td>
</tr>
<tr>
<td>Declaration of conformity</td>
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<td>X</td>
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<td>X</td>
</tr>
<tr>
<td>oSa Logo</td>
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<td>Colour stripe (optional)</td>
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<td></td>
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<tr>
<td>Private label number</td>
<td></td>
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<td></td>
</tr>
</tbody>
</table>

1. 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:

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

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: ![oSa Logo]

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**

**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.

**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.