

Product Marking Requirements – Superabrasives

Requirements for specific products according to EN 13236:2010 (published 11-2010)

The provisions of this European Standard shall not be mandatory to superabrasive products manufactured the first 12 months after publication of this European Standard. The standards EN 13236:2001 and EN 13236/A1:2005 are applicable until 30 November 2011.

	Grinding wheels		Diamond saws	Mounted points	Diamond wires	Other products
	vitrified	other				
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
Colour stripe (optional)	X					
Direction of run			X		X	
Restrictions to use	X	X	X	X		X
Declaration of conformity	X	X	X	X	X	X
oSa Logo	X	X	X	X	X	X
Private label number	Must be used on all private label products bearing the oSa logo					

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 13236 allows the code to be on the product or package, oSa will still require it to be on the product. It can be either:

- Order number
- Manufacturing batch number
- Despatch or shipping number
- Date of manufacture

Dimensions

- Should state diameter, thickness & bore in mm, e.g.: 300 x 20 x 50.80 mm
- ISO Standard dimensions should be used wherever the application permits (ISO 22917)
- 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 D of EN 13236:2001 (Annex E of EN 13236:2010)

Colour stripe

See EN 13236, Annex B

Direction of run

Wheels should be marked with a direction of run arrow





Restrictions to use

Grinding wheels:

- RE1 – Not permitted for hand-held or manually-guided grinding
- RE3 – Not permitted for wet grinding
- RE4 – Only permitted for totally enclosed working area

Cutting-off wheels (diamond saws):

- RE2 – Not permitted for hand-held cutting-off
- RE3 – Not permitted for wet cutting-off
- RE4 – Only permitted for totally enclosed working area
- RE10 – Only permitted for wet cutting-off
- RE11 – Not permitted for hand-held or manually guided cutting-off

RE 1 / RE 11	RE 3	RE 4	RE 6	RE 10
Not permitted for hand-held grinding / cutting-off	Not permitted for wet grinding	Only permitted for totally enclosed working area	Not permitted for face grinding	Only permitted for wet cutting
This restriction only applies to abrasive products not for use on handheld 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 suitable for wet cutting
		Currently no pictogram available		

Colour of pictograms according to ISO 3864-2 wherever possible

Declaration of conformity

All products should be marked: **EN 13236**

oSa Logo

All products should be marked:



By marking oSa on the product, the manufacturer is confirming that it meets the requirements of EN 13236 and the additional requirements stipulated in the Technical Annex of oSa

Private label number

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

Execution of the marking

- Must be legible to the naked eye
- Must be indelible
- All marking must appear on the product itself, either:
 - Etched, engraved, embossed or laser cut onto the surface (for superabrasive products with metal blanks)
 - Stamped or punched onto the surface
 - Sprayed, stencilled or printed onto the surface
 - Printed on a fixed label

- Products with diameter > 80 mm:

When it is not possible to give all specified information on the superabrasive 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:

The specified information can appear on a label which accompanies the superabrasive up to its final point of use.

- If package contains < 1000 identical products: 1 label per 25 products
- If package contains over 1000 identical products: 1 label per 100 products

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

List of major changes in the revised edition of EN 13236:2010:

- The new edition will supersede EN 13236:2001.
- The provisions of this European Standard shall not be mandatory to superabrasive products manufactured the first 12 months after publication of this European Standard.
- Significant changes against EN 13236:2001 are as follows:
 - a) The standard was technically and editorially revised and partly adapted to EN 12413:2007 about bonded abrasive products and EN 13743:2009 about coated abrasive products;
 - b) The term "burst speed factor" was included in Table 2, Table 5, Table 7 and Table 12;
 - c) In the requirements it is now distinguished between precision and non-precision cutting-off wheels;
 - d) New restrictions to cuts and openings in the metal blank have been introduced (new clause 5.3.5.3 "Design and position of cuts and openings in the metal blank of cutting-off wheels for hand-held applications")
 - e) Restrictions to segment height and bending strength values have been revised;
 - f) Requirements for reconditioned non-precision cutting-off wheels were included in new 5.3.6.4 and new normative Annex D;
 - g) Clause 6 was shortened to verification of safety requirements. The scope of inspection and testing has been deleted because it is the responsibility of the manufacturer to put in place respective test procedures that give them the confidence that all safety requirements defined in this standard are respected.
 - h) The requirements for colour code stripes were deleted in Annex A and are now presented in new Annex B;
 - i) Table A.3 and Table A.4 about restrictions for use were combined to one table and thereby adapted to EN 12413 and EN 13743;
 - j) Clause A.2 about execution of the marking was simplified;
 - k) Annex B about blotters was deleted and part of its content was included in 5.2.5;
 - l) Annex C about mounted points was completely revised and shortened;
 - m) Annex D with the speed conversion table (now Annex E) was editorially revised and maximum operating speeds above 320 m/s were deleted;
 - n) Annex E about shapes and dimensions of grinding wheels and cutting-off wheels had become obsolete with publication of ISO 6104 and was therefore deleted;
 - o) Annex F about grain sizes and concentration for diamond and cubic boron nitride had become obsolete with publication of ISO 6106 and was therefore deleted.