

Hacksaw blades —

Part 1: Specification for hand and machine hacksaw blades

Confirmed
January 2011

Committees responsible for this British Standard

The preparation of this British Standard was entrusted by the Machine, Engineers and Hand Tools Standards Policy Committee (MTE/-) to Technical Committee MTE/8, upon which the following bodies were represented:

- Association of Engineering Distributors Ltd.
- British Engineers Cutting Tools Association
- British Hacksaw and Bandsaw Manufacturers' Association
- Gauge and Tool Makers' Association
- Ministry of Defence

This British Standard, having been prepared under the direction of the Machine, Engineers and Hand Tools Standards Policy Committee, was published under the authority of the Standards Board and comes into effect on 15 November 1993

© BSI 04-1999

First published January 1953
Second edition September 1967
Third edition July 1974
Fourth edition December 1983
Fifth edition November 1993

The following BSI references relate to the work on this standard:
Committee reference MTE/8
Draft for comment 93/701076 DC

ISBN 0 580 22477 5

Amendments issued since publication

Amd. No.	Date	Comments

Contents

	Page
Committees responsible	Inside front cover
Foreword	ii
1 Scope	1
2 References	1
3 Definitions	1
4 Dimensions and number of teeth	3
5 Bend requirement for hand blades	3
6 Marking	3
Annex A (normative) Bend test for hand blades	6
Figure 1 — Elements of a hacksaw blade	1
Figure 2 — Linear dimensions	2
Figure 3 — Blade set	4
Figure A.1 — Bend test for all-hard type hand blades	6
Figure A.2 — Bend test for flexible and bi-metal type hand blades	7
Table 1 — Dimensions of hand hacksaw blades	5
Table 2 — Dimensions of machine hacksaw blades	5
List of references	Inside back cover

Foreword

This Part of BS 1919 has been prepared under the direction of the Machine, Engineers and Hand Tools Standards Policy Committee.

First published in 1953, BS 1919 was revised in 1967, partly to achieve a rationalization of sizes but also as a step towards metrication. The standard was further revised in 1974 to take into account international agreement within ISO on hacksaw blades and to add the flexible type of high speed steel hacksaw blade. BS 1919 was further revised in 1983 to include the important bi-metal types of hacksaw blade and requirements for both power and hand hacksaw blades.

The present revision of BS 1919 divides the 1983 edition into two Parts as follows. BS 1919-1 specifies the dimensions of hand and machine hacksaw blades and also includes the static bend test for hand blades only. This Part of BS 1919 has been produced in advance of the related standard ISO 2336 that is being prepared by the International Organization for Standardization (ISO).

A further Part of BS 1919 will cover the performance testing of hand and machine hacksaw blades.

BS 1919-1 and BS 1919-2 together supersede BS 1919:1983, which is withdrawn.

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, pages 1 to 8, an inside back cover and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

1 Scope

This Part of BS 1919 specifies the dimensions and static testing of hand hacksaw blades and the dimensions of machine hacksaw blades.

It is applicable to single edge blades of length not greater than 750 mm, the tooth pitch of which is not greater than 6.3 mm (or four teeth in 25 mm).

2 References

2.1 Normative references

This Part of BS 1919 incorporates, by reference, provisions from specific editions of other publications. These normative references are cited at the appropriate points in the text and the publications are listed on the inside back cover. Subsequent amendments to, or revisions of, any of these publications apply to this Part of BS 1919 only when incorporated in it by updating or revision.

2.2 Informative references

This Part of BS 1919 refers to other publications that provide information or guidance. Editions of these publications current at the time of issue of this standard are listed on the inside back cover, but reference should be made to the latest editions.

3 Definitions

For the purposes of this Part of BS 1919, the following definitions apply.

NOTE 1 The elements defined in 3.1 to 3.11 are shown in Figure 1.

NOTE 2 The linear dimensions defined in 3.12 to 3.17 are shown in Figure 2.

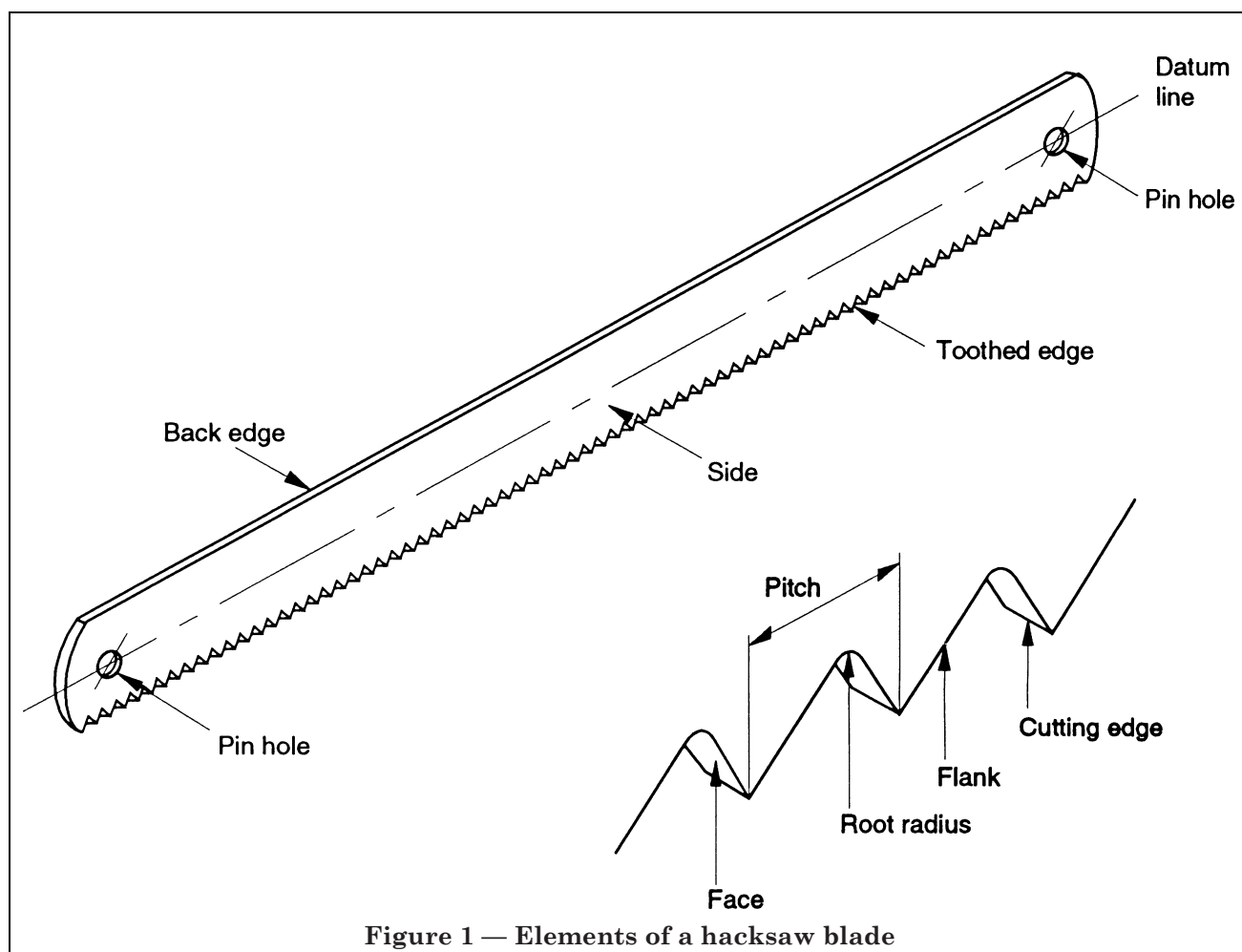


Figure 1 — Elements of a hacksaw blade