

KES

Hand Hacksaw Blades

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1. Scope of application

This standard shall be applied to a hand hacksaw blade (Called ‘Saw blade’ hereinafter) used for cutting metal or metal body of which central distance is 200, 250, or 300mm for attaching.

2. Types

There are three types : All hard hacksaw blade ⁽¹⁾, flexible hacksaw blade ⁽²⁾, and bimetal hacksaw blade ⁽³⁾.

Note ⁽¹⁾ Total blade is tempered uniformly in an all-hard hacksaw blade.

⁽²⁾ Only edge of blade is tempered in a flexible hacksaw blade.

⁽³⁾ Edge is made of high-speed steel and body is made of spring steel in bimetal hacksaw blade. Only its edge is tempered.

3. Quality

3.1 Appearance

Saw blade should be flat and extensive. It should not contain hazard flaw, broken tooth, twist, bending (In length or width), rolling, and rust. It should be finished well.

3.2 Bending of saw blade

Bending allowance of a saw blade is shown in table 1.

Table 1

Unit : mm

Bending	Central distance of attaching hole	200	250	300
		Within 0.6	Within 0.8	Within 1.2

3.3 Hardness of blade

Hardness of blade should be more than Hv697 (H_{RC} 60). However, the variation of hardness should be less than Hv60 (H_{RC} 3).

3.4 Bending strength

(1) Bending strength of all-hard hacksaw blade

Bending strength of all-hard hacksaw blade

When applying the load, under which the front of blade dives by 10mm with less than 10mm radius of curvature, at an arbitrary center of 100mm except attaching part shown in the figure 1, there should be no flaw and bursting. In addition, after removing the load, plastic deformation should be less than 1mm.

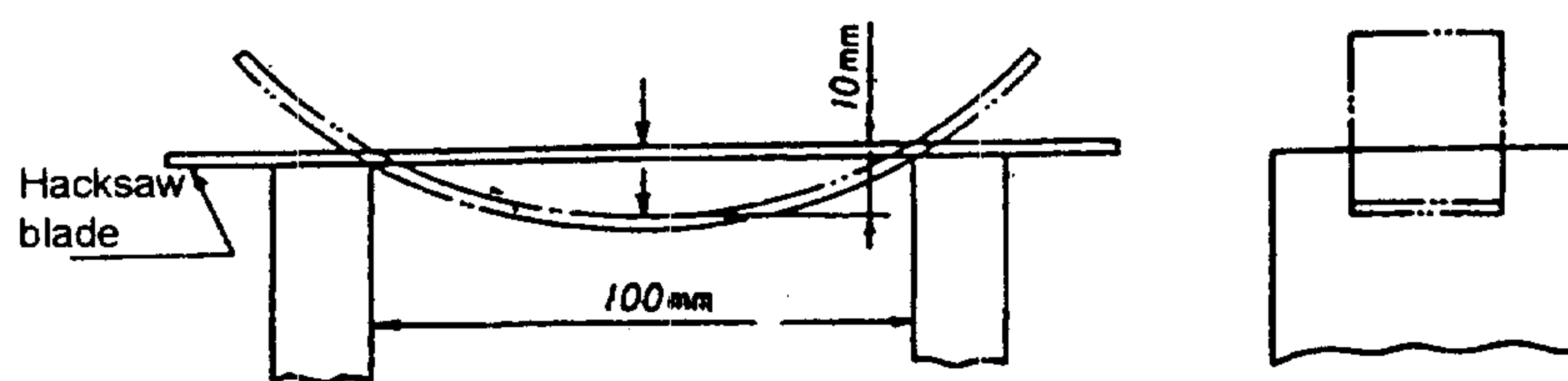


Figure 1

(2) Bending strength of flexible and bimetal hacksaw blade

When winding it around test bar with 60mm of outer diameter by 360°, removing it from test bar, and leaving it in original condition, it should contain no flaw and bursting in any part except tempered open part.