



Standard Specification for Steel Blades Used with the Photovoltaic Module Surface Cut Test¹

This standard is issued under the fixed designation E2685; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification specifies the recommended physical characteristics of the steel blades required for the surface cut test described in ANSI/UL 1703 (Section 24) and IEC 61730-2 (Paragraph 10.3).

1.2 ANSI/UL 1703 and IEC 61730-2 are standards for photovoltaic module safety testing.

1.3 This standard provides additional fabrication details for the surface cut test blades that are not provided in ANSI/UL 1703 or IEC 61730-2. Surface cut test blades that have out-of-tolerance corner radii or burrs are known to cause erroneous test results, either passes or failures.

1.4 The values stated in SI units are to be regarded as standard. No other units of measurement are included in this standard.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.6 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[A506 Specification for Alloy and Structural Alloy Steel, Sheet and Strip, Hot-Rolled and Cold-Rolled](#)

¹ This specification is under the jurisdiction of ASTM Committee E44 on Solar, Geothermal and Other Alternative Energy Sources and is the direct responsibility of Subcommittee E44.09 on Photovoltaic Electric Power Conversion.

Current edition approved April 1, 2019. Published April 2019. Originally approved in 2009. Last previous edition approved in 2015 as E2685-15. DOI: 10.1520/E2685-15R19.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

[A684/A684M Specification for Steel, Strip, High-Carbon, Cold-Rolled](#)

[E772 Terminology of Solar Energy Conversion](#)

2.2 *International Electrotechnical Commission Standards*³

[IEC 61730-2 Photovoltaic \(PV\) Module Safety Qualification – Part 2: Requirements for Testing](#)

2.3 *American National Standard:*⁴

[ANSI/UL 1703 Flat-Plate Photovoltaic Modules and Panels](#)

3. Terminology

3.1 *Definitions*—Definitions of terms used in this specification may be found in [A506](#), [A684/A684M](#), [E772](#), ANSI/UL 1703, and IEC 61730-2.

4. Materials and Manufacture

4.1 Surface cut test blades are fabricated from hardened steel strips. The minimum hardness of the steel is 24 as measured using the Rockwell scale. Fully hardened and tempered steel of at least 0.50 weight percent carbon as specified in Specifications [E772](#) or [A506](#) will meet this requirement.

4.2 Other materials besides hardened steel may be used provided they have sufficient hardness.

NOTE 1—Steel hacksaw blades commonly available at hardware stores are acceptable materials of the correct thickness and hardness.

5. Dimensions and Permissible Variations

5.1 Blade thickness: 0.64 ± 0.05 mm.

5.2 Corner angle: $90 \pm 2^\circ$ (see [Fig. 1](#))

5.3 Corner radius: 0.115 ± 0.025 mm (see [Fig. 1](#))

6. Workmanship, Finish, and Appearance

6.1 The corner contact area of the blade is intended to be a cylindrical surface of the required radius; any burrs or sharp points are removed using a steel file.

7. Number of Tests and Retests

7.1 The surface cut test blade may be reused until the radius is outside the specified limits (see [5.3](#)).

³ Available from International Electrotechnical Commission (IEC), 3 rue de Varembe, Case postale 131, CH-1211, Geneva 20, Switzerland, <http://www.iec.ch>.

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.