
International Standard



2336

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Hand and machine hacksaw blades — Dimensions for lengths up to 450 mm and pitches up to 6,3 mm

Lames de scies droites à métaux, à main et à machine — Dimensions pour longueurs jusqu'à 450 mm et pas jusqu'à 6,3 mm

Second edition — 1980-12-15

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[ISO 2336:1980](#)

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 2336 was developed by Technical Committee ISO/TC 29, *Small tools*. The first edition (ISO 2336-1972) had been approved by the member bodies of the following countries :

Australia	India	Romania
Belgium	Ireland	South Africa, Rep. of
Czechoslovakia	Israel	Sweden
Egypt, Arab Rep. of	Italy	Switzerland
France	Japan	Thailand
Germany, F. R.	Korea, Rep. of	Turkey
Greece	Netherlands	United Kingdom
Hungary	Poland	USSR

The member body of the following country expressed disapproval of the document on technical grounds :

USA

This second edition, which supersedes ISO 2336-1972, incorporates draft Amendment 1, which was circulated to the member bodies in November 1978, and which has been approved by the member bodies of the following countries :

Austria	India	Sweden
Belgium	Israel	Switzerland
Bulgaria	Italy	Turkey
Chile	Japan	United Kingdom
Czechoslovakia	Poland	USSR
France	Romania	Yugoslavia
Germany, F. R.	South Africa, Rep. of	
Hungary	Spain	

The member body of the following country expressed disapproval of the document on technical grounds :

Australia

Hand and machine hacksaw blades – Dimensions for lengths up to 450 mm and pitches up to 6,3 mm

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1 Scope and field of application

This International Standard specifies the dimensions of hand and machine hacksaw blades.

It is valid for single edge blades of length not greater than 450 mm, the tooth pitch of which is not greater than 6,3 mm (or 4 teeth in 25 mm).¹⁾

Directives for hacksaw blades with less recommended dimensions are given in the Annex.

2 Designation

The designation of hacksaw blades includes the following dimensions, in millimetres, in the order given :

- the blade length l ;
- the width a ;
- the thickness b ;
- the tooth pitch P , which can be supplemented by the number of teeth N in 25 mm, given between parentheses.

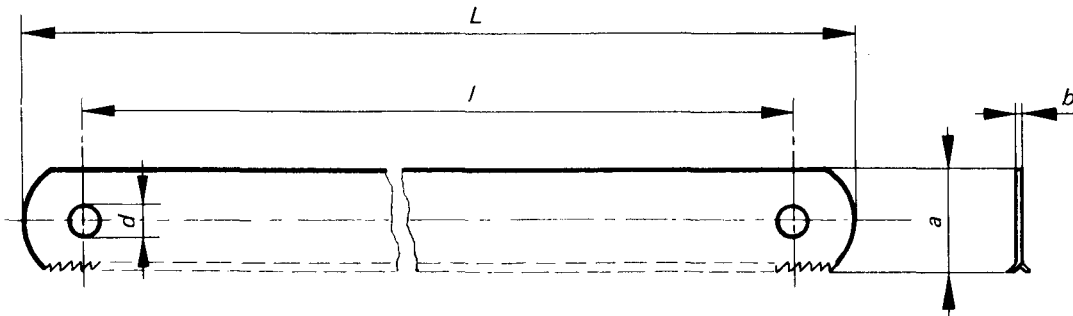
Example of designation of a blade, of length 300 mm, of width 25 mm, of thickness 1,25 mm and of tooth pitch 2,5 mm :

Hacksaw
blade : $300 \times 25 \times 1,25 \times 2,5$

 or $300 \times 25 \times 1,25 \times 2,5 (10)$

¹⁾ Blades of greater lengths or higher pitches, as well as double-edge blades, will be the subjects of further International Standards.

3 Dimensions and number of teeth



Blade length l is the distance between centres of pin holes. It is recommended that the centre of the pin hole be located on the centreline of the blade.

3.1 Hand hacksaw blades

Table 1

Dimensions in millimetres

l ± 2	a	b	Teeth spacing ¹⁾		L max.	d H 14
			P	N		
300	12,5	0,63	0,8	32	315	4
			1,0	24		
			1,4	18		

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3.2 Machine hacksaw blades

Table 2

Dimensions in millimetres

l ± 2	a	b	Teeth spacing ¹⁾		L max.	d H 14
			P	N		
300	25	1,25	1,8	14	330	8,2
			2,5	10		
350	25	1,25	1,8	14	380	8,2
			2,5	10		
	32	1,60	2,5	10		
			4,0	6		
400	32	1,60	2,5	10	430	8,2
			4,0	6		
	40	2,00	4,00	6		
			6,3	4		
450	32	1,60	2,5	10	485	10,2
			4,0	6		
	40	2,00	4,0	6		
			6,3	4		

1) P = pitch in millimetres
 N = number of teeth in 25 mm

2) The diameter d of pin holes of machine hacksaw blades as mentioned above has been unified in the United States to 0.281 in or 7,1 mm.

Annex

Less recommended dimensions

If it is necessary in national standards to retain other dimensions for which there may still be a demand, it is recommended to state that these dimensions are not in conformity with this International Standard and to limit them to combinations of the following basic elements.

- Length l : 250 – 300 – 350 – 400 – 450 mm
- Width a : 12,5 – 16 – 25 – 32 – 40 mm
- Thickness b : 0,63 – 0,80 – 1,25 – 1,60 – 2,00 mm
- Teeth spacing

Pitch P : 0,8 – 1,0 – 1,4 – 1,8 – 2,5 – 4,0 – 6,3 mm

Number of teeth N in 25 mm : 32 – 24 – 18 – 14 – 10 – 6 – 4

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