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Metal slitting saws with fine and coarse teeth — Metric series

Fraises-scies à dentures fine et grosse — Série métrique

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Foreword

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The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with defined cutting edges, holding tools, cutting items, adaptive items and interfaces*.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

This third edition cancels and replaces the second edition (ISO 2296:2011), of which it constitutes a minor revision.

The main changes compared to the previous edition are as follows:

— addition of Annex B;

— editorial changes to align with the ISO/IEC Directives.

Metal slitting saws with fine and coarse teeth — Metric series

1 Scope

This document specifies the dimensions and the mechanical characteristics of metal slitting saws, metric series. It applies to the following two types of metal slitting saws:

— metal slitting saws with fine teeth;

— metal slitting saws with coarse teeth.

If there is a need to extend the range or introduce other series of teeth, it is intended that such additions be according to the data given in the graph in Annex A.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 240, *Milling cutters — Interchangeability dimensions for cutter arbors or cutter mandrels*

ISO 2924, *Solid and segmental circular saws for cold cutting of metals — Interchangeability dimensions of the drive — Saw diameter range 224 to 2 240 mm*

3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at http://www.electropedia.org/

4 Dimensions and number of teeth

4.1 General

The ratio between the number of teeth for saws with coarse teeth and the number of teeth for saws with fine teeth is 0,5 and specific values are related to saw diameter and thickness.

4.2 Dimensions of metal slitting saws with fine teeth

The dimensions of metal slitting saws with fine teeth shall be in accordance with the indications given in Figure 1 and Table 1.

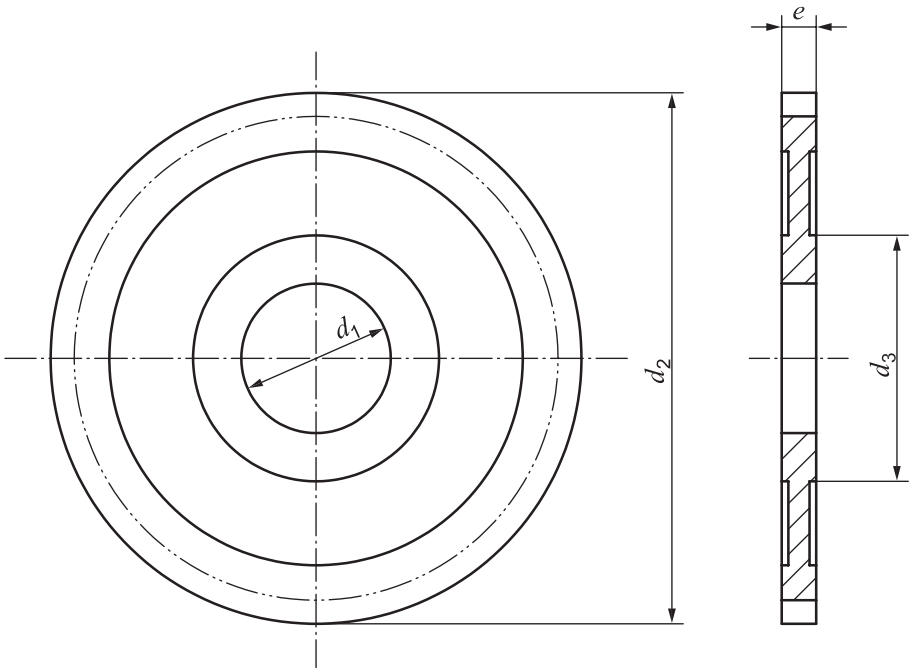

Figure 1 — Dimensions of metal slitting saws

Table 1 — Dimensions of metal slitting saws with fine teeth

Dimensions in millimetres

d_1 H7		5	8		10	13	16	22			32			40
d_2 js16		**20**	**25**	**32**	**40**	**50**	**63**	**80**	**100**	**125**	**160**	**200**	**250**	**315**
d_3 min.		Without hub						34			47	63		80
e js11	Pitch[a]	Number of teeth												
0,2	0,8	80			128									
0,25	1,0	64	80	100	100	128								
0,3				80			128							
0,4			64			100								
0,5	1,25	48			80			128	160					
0,6				64			100							
0,8	±0,030		48			80			128	160				
1,0					64			100			160			
1,2	1,6	40		48			80			128		160		
1,6			40			64			100				200	
2,0		32			48			80			128	160		200
2,5	2,0			40			64			100			160	
3,0					48	48			80			128		
4,0	±0,037				40			64		80	100			160
5,0							48							
6,0	2,5								64			100		
			3,2			4,0			5,0			6,3		

a The tooth pitch, in relation to the number of teeth of a metal slitting saw of a given diameter, is expressed as an approximate rounded value.