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Adhesives — Installation of floor coverings, wood flooring, levelling compounds and tiles —
Specification of trowel notch sizes

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established 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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

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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).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

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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 61, *Plastics*, Subcommittee SC 11 *Products*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 193, *Adhesives*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

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.

Introduction

For installation of floor coverings, wood flooring and ceramic tiles, adhesives, thin bed mortars and similar products are spread (combed) onto the substrate commonly using grooved (notched) spatulas or trowels. The notches of the respective tools permit flow of the substance to be applied which will then settle on the substrate in the form of strips (ridges). Consequently, the quantity of applied material per unit area essentially depends on the geometry of the notches.

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Adhesives — Trowel notch sizes for installation of floor coverings, wood flooring and tiles — Specification of trowel notch sizes

1 Scope

This document specifies the individual measurements of notches. It assigns specific codes used to label notched tools according to the measurements and tolerances specified in this document.

2 Normative references

There are no normative references in this document.

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain [terminological](#) [terminology](#) databases for use in standardization at the following addresses:

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

— IEC Electropedia: available at <https://www.electropedia.org/>

3.1 notched trowel notched spatula

rectangular or trapezoidal sheet steel, with evenly spaced grooves on at least one long side, commonly designated as "notches"

Note 1 to entry: Normally, spatulas have a hand grip opposite the grooved (notched) side.

Note 2 to entry: The hand grip of a trowel is typically attached parallel to the sheet surface.

3.2 notched strips grooved strips

rectangular, narrow sheet steel strips with evenly spaced grooves (notches) on one or both long sides

4 Shapes

Depending on the application and the desired ridge profile, notches can have a triangular, rectangular, U-shaped or [semicircular](#) [semi-circular](#) shape.

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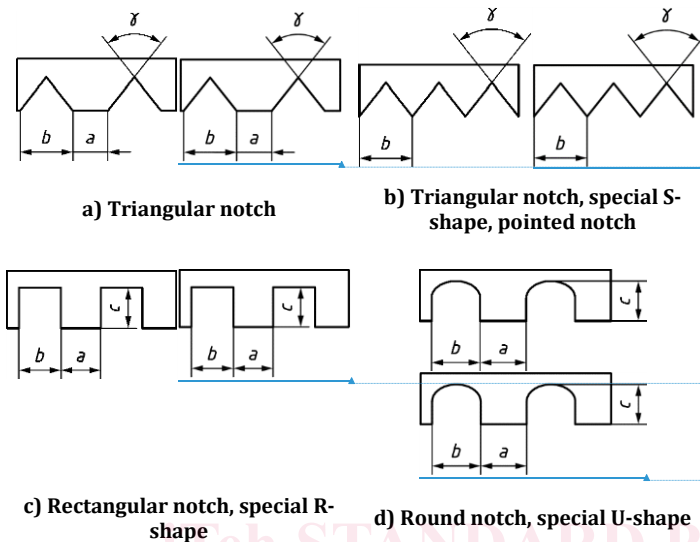
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- Key**
- a bridge width or groove clearance
 - b notch width or groove width
 - c notch depth or groove depth
 - γ notch angle

Figure 1 — Different notch geometries

For manufacturing reasons, the inner points of the triangular notches and the inner right angles of the rectangular notches are rounded off. The radius of curvature is 0,2 mm to 0,3 mm, on average 0,25 mm.

A special type of the triangular notch is the "pointed notch" with a bridge width "a" of 0 mm to 0,2 mm. Other special types of notches with rounded off tops include U-notches, where the end of the notch is a semicircle with a diameter of "b".

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Tolerances

The tolerances of the dimensional specifications specified in Figure 1 are given in Table 1.

Table 1 — Tolerances

Dimensional specifications	Tolerances
<i>a</i>	±0,1 mm
<i>b</i>	±0,1 mm
<i>(a + b)</i>	±0,1 mm
<i>c</i>	±0,1 mm
γ	±0,5 °

7.6 Material

Depending on material hardness and thickness of the sheet steel, notched strips wear out more or less quickly. Accordingly, notch area and consequently flow rate gradually decrease. To ensure long durability of the notched strips, we recommend using spring steel with a minimum hardness of 46 HRD or higher. Thickness of the sheet steel shall not fall below 0,5 mm.

7.7 Labelling

Notched trowels fully complying with specifications of this document and subject to adequate quality controls shall be labelled on the steel plate by the manufacturer as follows:

Manufacturer / notch size code / Reference to this ISO Standard document

Annex A (Table A.1) shows the assignment of common European, Japanese and US notch designations to the notch sizes codes specified in this standard document.

7.8 Trowel notch sizes — Designations, dimensional specifications and illustrations

The specified sizes in Table 2 are average values to be established by controlled sampling.

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Table 2 — Specified trowel notch sizes

ISO Notch size code	Width of separation <i>a</i> mm	Width of notch <i>b</i> mm	Depth of notch <i>c</i> mm	Notch angle γ °	Geometry/Shape "X"	Geometric factor mm	Illustration real size
01-T	1,45	1,35	0,98	55,0	T	235	
02-T	0,40	1,10	0,74	55,0	T	270	
03-T	1,30	1,70	1,31	55,0	T	372	
04-T	1,59	1,59	1,59	-	T	397	
05-T	3,00	2,00	2,00	53,0	T	400	
06-T	0,50	1,50	1,12	55,0	T	420	
07-T	2,60	2,40	1,98	55,0	T	476	
08-T	0,40	1,60	1,49	45,0	T	595	

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09-T	2,38	2,38	2,38	-	T	595	
10-T	14,30	5,70	5,15	55,0	T	734	
11-T	2,00	3,00	2,56	55,0	T	768	
12-T	4,90	4,10	3,62	55,0	T	824	
13-T	3,30	3,70	3,23	55,0	T	855	
14-T	4,40	3,60	3,90	45,0	T	878	
15-T	3,90	4,10	3,62	55,0	T	927	
16-T	9,90	6,10	5,01	60,0	T	955	

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