
Hacksaw blades —

**Part 2:
Dimensions for machine blades**

Lames de scies droites à métaux —

Partie 2: Dimensions des lames à machine

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Reference number
ISO 2336-2:2006(E)

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Foreword

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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.

ISO 2336-2 was prepared by Technical Committee ISO/TC 29, *Small tools*.

This second edition cancels and replaces the first edition (ISO 2336-2:1996), which has been technically revised.

ISO 2336 consists of the following parts, under the general title *Hacksaw blades*:

- *Part 1: Dimensions for hand blades*
- *Part 2: Dimensions for machine blades*

Hacksaw blades —

Part 2: Dimensions for machine blades

1 Scope

This part of ISO 2336 specifies the dimensions of machine hacksaw blades. It is applicable to single-edge blades of lengths from 300 mm up to 700 mm, the tooth pitch of which is no greater than 8,5 mm.

2 Normative references

The following referenced documents are indispensable for the application 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 2768-1, *General tolerances — Part 1: Tolerances for linear and angular dimensions without individual tolerance indications*

3 Dimensions

3.1 General

All dimensions and tolerances are given in millimetres. Tolerances not specified shall be of tolerance class “m” in accordance with ISO 2768-1.

3.2 Dimensions

The dimensions shown in Figure 1 are given in Table 1, with tooth pitch, P , and the number of teeth, N , in 25 mm. The blade length, l_1 , is the distance between centres of pin holes of diameter d . It is recommended that the centre of the pin hole be located on the centreline of the blade.

4 Designation

Machine hacksaw blades according to this part of ISO 2336 shall be designated as follows:

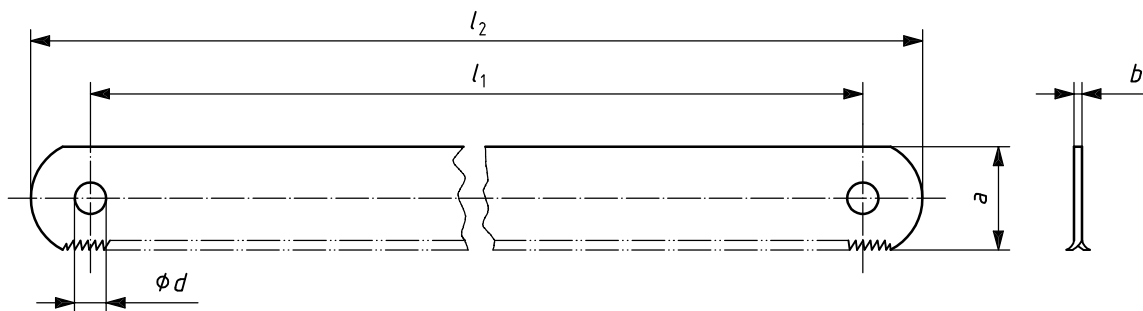
- a) “Saw blade”;
- b) reference to this part of ISO 2336 (i.e. “ISO 2336-2”);
- c) the blade length, l_1 , in millimetres;
- d) the width, a , in millimetres;

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- e) the thickness, b , in millimetres;
- f) the number of teeth, N , in 25 mm.

EXAMPLE A machine hacksaw blade, of length $l_1 = 300$ mm, of width $a = 25$ mm, of thickness $b = 1,25$ mm and number of teeth in 25 mm, $N = 10$, is designated as follows:

Saw blade ISO 2336-2 - 300 × 25 × 1,25 × 10



NOTE The shape of the end blade is left to the manufacturer's discretion.

Figure 1 — Machine hacksaw blade

Table 1 — Dimensions of machine hacksaw blade

l_1 ± 2	a $\begin{matrix} 0 \\ -1 \end{matrix}$	b	Tooth spacing		l_2 max.	d H14	
			P	N			
300	25	1,25	1,8	14	330	8,4	
			2,5	10			
		1,5	1,8	14			
			2,5	10			
			4	6			
350	25	1,25	1,8	14	380		
			2,5	10			
		1,5	1,8	14			
			2,5	10			
			4	6			
	30	1,5	1,8	14			
			2,5	10			
			4	6			
		2	1,8	14			
			2,5	10			
400	25	1,5	1,8	14	430		
			2,5	10			
			4	6			
		30	1,8	14			
			2,5	10			
	4		6				
	2		2,5	10			
			4	6			
		6,3	4				
	40	2	4	6		440	10,4
6,3			4				
450	30	1,5	2,5	10	490	8,4	
			4	6			
	40	2	2,5	10		540	10,4
			4	6			
			6,3	4			
500	40	2	2,5	10	540	10,4	
			4	6			
			6,3	4			
575	50	2,5	4	6	615	10,4/12,9	
			6,3	4			
			8,5	3			
600	50	2,5	4	6	640	10,4/12,9	
			6,3	4			
700	50	2,5	4	6	745	10,4/12,9	
			6,3	4			
			8,5	3			

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