INTERNATIONAL STANDARD

ISO 6753-1

Second edition
2005-08-15

Tools for pressing and moulding — Machined plates —

Part 1: Machined plates for press tools

Outillage de presse et de moulage — Plaques usinées —

Partie 1: Plaques usinées pour outillage de presse

Reference number
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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 main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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ISO 6753-1 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 8, *Tools for pressing and moulding*.

This second edition cancels and replaces the first edition (ISO 6753:1:1994), Clause 2 of which has been technically revised.

ISO 6753 consists of the following parts, under the general title *Tools for pressing and moulding — Machined plates*:

— *Part 1: Machined plates for press tools*

— *Part 2: Machined plates for moulds*

Tools for pressing and moulding — Machined plates —

Part 1: Machined plates for press tools

1 Scope

This part of ISO 6753 specifies dimensions and tolerances, in millimetres, of machined plates for press tools.

It gives guidance relative to materials and hardness and specifies the designation of machined plates in accordance with this part of ISO 6753.

2 Dimensions

See Figure 1 and Table 1.

3 Material and corresponding hardness

The material and hardness are left to the manufacturer's discretion.

4 Designation

A machined plate for press tools in accordance with this part of ISO 6753 shall be designated as follows:

a) “Machined plate”;

b) reference to this part of ISO 6753, i.e. ISO 6753-1;

c) its edge machining process (oxygen cut, water-jet cut, etc.: 1; milled: 2);

d) the grade of its thickness tolerance (1 for normal precision plates; 2 for high precision plates);

e) its length a, in millimetres;

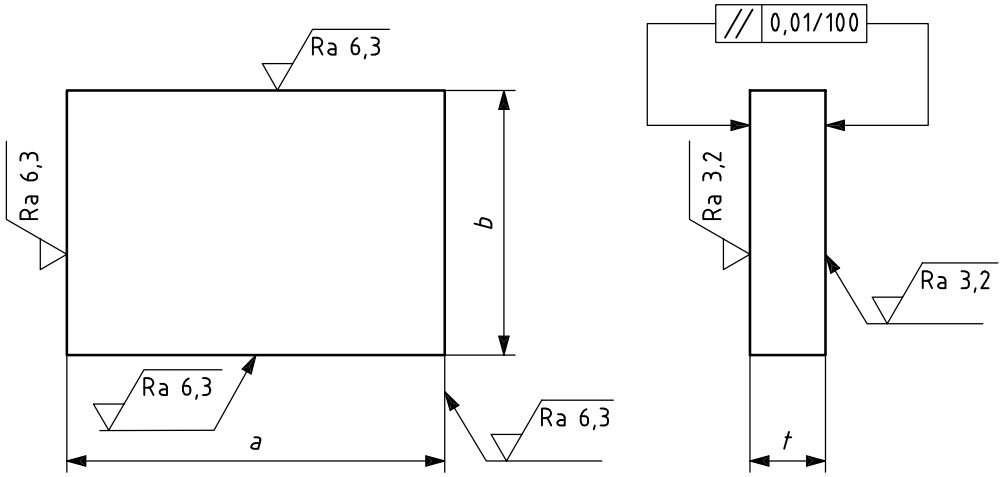
f) its width b, in millimetres;

g) its thickness t, in millimetres.

EXAMPLE A normal precision-machined plate with oxygen-cut edges (1), with length a = 160 mm, width b = 80 mm and thickness t = 20 mm is designated as follows:

Machined plate ISO 6753-1 1 - 1 - 160 × 80 × 20

Values of surface roughness in micrometres



NOTE These values of surface roughness apply only to plates with milled edges.

Figure 1 — Machined parts

Table 1— Dimensions of machined parts

$a \times b$ [a]	$t \pm 2$ [b]						
	20	25	32	40	50	63	80
160 × 80	x	x	x				
160 × 100	x	x	x				
160 × 125	x	x	x				
160 × 160	x	x	x				
200 × 100		x	x	x			
200 × 125		x	x	x			
200 × 160		x	x	x			
200 × 200		x	x	x			
250 × 125		x	x	x			
250 × 160		x	x	x			
250 × 200		x	x	x			
250 × 250			x	x	x		
315 × 160			x	x	x		
315 × 200			x	x	x		
315 × 250			x	x	x		
315 × 315			x	x	x		
400 × 200			x	x	x		
400 × 250			x	x	x		
400 × 315			x	x	x		

Table 1 (*continued*)

$a \times b$ [a]	$t \pm 2$ [b]						
	20	25	32	40	50	63	80
400 × 400			x	x	x		
500 × 250			x	x	x		
500 × 315			x	x	x		
500 × 400			x	x	x		
500 × 500			x	x	x		
630 × 315			x	x	x	x	
630 × 400			x	x	x	x	
630 × 500			x	x	x	x	
630 × 630			x	x	x	x	
710 × 400			x	x	x	x	
710 × 500			x	x	x	x	
710 × 630			x	x	x	x	
800 × 400			x	x	x	x	
800 × 500			x	x	x	x	
800 × 630			x	x	x	x	
900 × 500			x	x	x	x	
900 × 630			x	x	x	x	
900 × 710			x	x	x	x	
1 000 × 500					x	x	x
1 000 × 630					x	x	x
1 000 × 710					x	x	x
1 000 × 800					x	x	x
1 120 × 630					x	x	x
1 120 × 710					x	x	x
1 120 × 800					x	x	x

a Plates with milled edges: tolerance for dimensions a and $b \leqslant 630$ mm: $^{+0,4}_{+0,2}$ mm.

Plates with milled edges: tolerance for dimensions a and $b > 630$ mm: $^{+0,6}_{+0,2}$ mm.

Plates with oxygen-cut edges, water-jet-cut edges: tolerance for dimensions a and b: $^{+4}_{+1}$ mm.

b For grade 2, the tolerance is $^{+0,5}_{+0,3}$ mm.

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