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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 11270.1-2021

Replacing GB/T 11270.1-2002

**Superabrasive products - Diamond circular saw blade - Part 1:
Welded saw blades**

超硬磨料制品 金刚石圆锯片 第1部分：焊接锯片

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Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for Standardization Work Part

1. Structure and Drafting Rules of Standardization Documents" Drafting. This document is the first part of GB/T 11270 "Diamond Circular Saw Blade for Super Abrasive Products". GB/T 11270 has been released to the next part.

1. Welding saw blades;

2. Sintered saw blade. This document replaces GB/T 11270.1-2002 "Superhard Abrasive Products Diamond Circular Saw Blade Part

1. Welded Saw Blade", and Compared with GB/T 11270.1-2002, in addition to structural adjustments and editorial changes, the main technical changes are as follows:

a) The code for the shape of the sawtooth section and the code for the modification of the matrix have been changed (see 4.1.1, 4.1.3, 3.5.1,

3.5.2 of the 2012 edition);

b) The code of the serrated surface shape has been added (see 4.1.2);

c) The shape code of the saw blade is changed (see 4.1.4,

3.5.3 of the 2002 edition)

d) Abrasive code is deleted (see

3.1 in 2002 edition);

e) Changed the abrasive particle size number (see 4.3,

3.2 in the 2002 edition);

1 Scope

GB/T 11270.1-2021 is the Chinese national standard on superabrasive products - diamond circular saw blade - part 1: welded saw blades, in the field of manufacturing engineering. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 21 May 2021 by the State Administration for Market Regulation; Standardization Administration of China, and has been in force since 1 December 2021. Classification: ICS 25.100.70, CCS J43. This

page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This document specifies the codes and markings of the welded diamond circular saw blades, the basic dimensions of the substrate and the teeth, technical requirements, test methods, and inspection gauges. Rules, signs, packaging, transportation and storage. This document is applicable to welded diamond circular saws for cutting stone, concrete, refractory materials, asphalt, carbon, ceramics, glass and other materials. Blade (hereinafter referred to as saw blade).

2 Normative references

The contents of the following documents constitute the indispensable clauses of this document through normative references in the text. Among them, dated quotations Only the version corresponding to that date is applicable to this document; for undated reference documents, the latest version (including all amendments) is applicable to This document.

GB/T 2493 Rotation test method of grinding wheel

GB/T 6406 Super-hard abrasive particle size inspection

GB/T 11270.2 Diamond circular saw blades for superabrasive products-Part

3 Terms and definitions

There are no terms and definitions that need to be defined in this document.

4.1 Shape code

4.1.1 Shape code of sawtooth section See Table 1 for the shape and code of the sawtooth section.