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

GB/T 21954.2-2008

**Metal cutting band saw blades -- Part 2: Characteristics and
dimensions**

金属切割带锯条 第2部分：特性和尺寸

(English Translation)

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Foreword

GB/T 21954 "metal cutting band saw blades" is divided into two parts.

--- Part 1. Terminology;

--- Part 2. Characteristics and dimensions.

This section GB/T 21954 Part 2. The partial modification of the use of ISO 4875-2:2006 (E) "metal cutting band saw blade Part 2 Score. characteristics and dimensions "(in English), and ISO 4875-2. The main difference between 2006 (E) as follows.

--- According to Chinese customs for some formatting has been modified;

--- Some of the statements apply to international standards to apply to our standard formulation;

--- Delete ISO foreword, preface to increase;

--- Normative references to international standards in the use of alternative national standards, and to increase the corresponding national standards;

--- The "3 Terms and definitions" to "3 band saw blade type";

--- The "3.4 compositesteelbandsawblade (composite steel blade)" meaning translated as "carbide band saw blade";

--- The "4.1 Usualsection (usually cross-section)" meaning translated as "basic cross-section";

--- In Table 5, "and pitch", add "teeth per 25.4mm Length 1 'specifications;

--- In Table 6, "change pitch", the pitch "4 ~ 9", "3 ~ 9" mm, pitch modify "4 ~ 2.5", "3 ~ 2" mm. While increasing "Every 25.4mm length of 1 to 1.5 teeth" variable pitch sizes and increased Notes to Table;

--- The "4.5 Flatness (flatness)" to the term "horizontal straightness" term;

--- Increase in Appendix A;

--- Appendix A of this section is an informative annex.

This part is proposed by China Machinery Industry Federation.

This part of the tool by the National Standardization Technical Committee (SAC/TC91) centralized.

This section is drafted. Hunan Techno New Material Technology Co., Ltd. (Hunan Machine Tool Plant).

1 Scope

This section GB/T 21954 specifies the various types of metal cutting band saw blades features and basic dimensions.

This section applies to metal cutting band saw blades.

2 Normative references

The following documents contain provisions which, through reference GB/T 21954 in this section constitute provisions of this section. For dated reference documents Member, all subsequent amendments (not including errata content) or revisions do not apply to this section, however, encouraged to reach under this section Parties to research agreement to use the latest versions of these documents. For undated reference documents, the latest versions apply to this section.

GB/T 230.1 Metallic Rockwell hardness test - Part 1. Test methods (A, B, C, D, E, F, G, H, K, N, T scale) (GB/T 230.1-2004, ISO 6508-1:1999, MOD) Test methods. Part 1 GB/T 4340.1 Vickers hardness test (GB/T 4340.1-1999, eqv ISO 6507-1:1997) JB/T 6050 General heat treatment of steel parts hardness test

3 Types of band saw blades

Carbon steel blade

The carbon content higher than 1.0%, with a blade less than 1.5% of the low alloy steel, the total content of manganese, silicon, chromium should not be less than 0.5%.

Bi-metal band saw blade Serrated blade with a blade made of a material different from the body is made.

Friction band saw blades the fatigue of steel, heat generated by the friction of the cutting band saw blades.

Carbide band saw blades with carbide cutting edge materials, commonly used alloy steel blade body with blade.

4.1 Basic sectional

The basic cross section is composed of the width and thickness of band saw blades.

4.1.1 Carbon steel blade (see table 1)

Table 1 Carbon steel blade basic cross section in millimeters

Width 35 68 101 131 162 2025 Thickness 0.65 0.8 0.9