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

GB/T 39169-2020

**Blanks for diamond circular saw blade - Mounting and fixing
bores - Building construction and civil engineering**

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard uses the redrafting method to modify and adopt ISO 21538:2016

“Super-abrasive cutting wheel substrate installation and fixed hole construction

Construction and Civil Engineering.

Compared with ISO 21538:2016, there are technical differences between this standard and the clauses involved in these differences have been passed on the outer margins.

The set vertical single line (?) is marked, and a list of the corresponding technical differences and their reasons is given in Appendix A.

This standard also made the following editorial changes.

---Modified the standard name.

This standard was proposed by China Machinery Industry Federation.

This standard is under the jurisdiction of the National Abrasives Standardization Technical Committee (SAC/TC139).

Drafting organizations of this standard. Zhengzhou Abrasives Grinding Research Institute Co., Ltd., Heixuanfeng Saw Industry Co., Ltd., Beijing Antai Steel Research Super

Hard Material Products Co., Ltd., Boshen Co., Ltd., Guangdong Benlang New Materials Co., Ltd., Quanzhou Wanlong Stone Industry Co., Ltd., Fujian Province

Limited company, Quanzhou Zhongzhi New Material Technology Co., Ltd.

1 Scope

This standard specifies the type, size and mark of the mounting and fixing holes of the diamond circular saw blade base.

This standard applies to the installation and fixing holes of the diamond circular saw blade

substrate for construction and civil engineering.

2 Normative references

The following documents are indispensable for the application of this document. For dated reference documents, only the dated version applies to this article

Pieces. For undated references, the latest version (including all amendments) applies to this document.

GB/T 1804 General tolerance The tolerance of linear and angular dimensions without tolerance (GB/T 1804-2000, eqvISO 2768-1.1989)

GB/T 39140.2 Clamping chuck for diamond circular saw blade Part 2.Construction and civil engineering (GB/T 39140.2-2020, ISO 21537-2..2004, MOD)

3 Type and size

There are 5 types of mounting and fixing holes for the diamond circular saw blade base. only the center hole (Type A), and there is a drive pin hole outside the center hole (B Type), there are up to 2 sets of ring-shaped drive pin holes (C type) outside the center hole, and up to 2 sets of ring-shaped mounting holes (D type) outside the center hole.

There is a drive pin hole and a group of ring-shaped mounting holes (E type) outside the hole, as shown in Figure 1 to Figure 5, and their dimensions are shown in Table 1 to Table 5.

The dimensions of these mounting and fixing holes are consistent with the relevant dimensions of the clamping chuck specified in GB/T 39140.2.

Other requirements not specified should be selected according to needs.

Figure 1 Type A mounting and fixing holes