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

GB/T 46646-2025

**Portable brush cutters - Cutting attachments - Single-piece
metal blades**

便携式割灌机 切割附件 单片金属刀片

(English Translation)

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Foreword

This document complies with the provisions of GB/T 1.1-2020 "Standardization Work Guidelines Part 1: Structure and Drafting Rules of Standardization Documents".

This document is equivalent to ISO 7113:1999 "Portable handheld forestry machinery - brush cutter cutting accessories - single-blade metal blades".

The following minimal editorial changes have been made to this document.

---To align with existing standards, the standard name has been changed to "Portable Brush Cutter Cutting Accessory. Single-blade Metal Blade".

1 Scope

This document specifies the material and marking requirements for single-blade metal blades of portable brush cutters, as well as the basic dimensions and tolerances of circular saw blades. Require.

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are not included.

For references to documents, only the version corresponding to that date applies to this document; for undated references, the latest version (including all amendments) applies. This document. cuttersandgrass-trimmers-Vocabulary)

Note: GB/T 18961-2023 Vocabulary for Portable Brush Cutter and Lawn Mower (ISO 7112:2018, IDT)

3 Terms and Definitions

The terms and definitions defined in ISO 7112 apply to this document.

Apart from markings, the blade should not have surface defects deeper than 0.03 mm.

5.1 Requirements

The specimen should not have any visible cracks after the bending test in section 5.2.

5.2.1 Sample Preparation

Cut a blade sample, ensuring its length is perpendicular to the material grain, and that its width is $35\text{mm} \pm 5\text{mm}$, and its length is at least... The sample should be 10 mm longer than $2H$ (see Figure 1). If the material texture is not visible, take one sample every 60° along the circumference, for a total of three samples. The sample should not be lubricated during the test.

The test is conducted on a V-block, and the specimen is bent using a device, as shown in Figure 1. The width of the V-block and the device should be no less than 40 mm.

The ambient temperature should be $10^\circ\text{C}\sim 35^\circ\text{C}$, and the speed at which the load is applied should be $1\text{mm/s}\sim 10\text{mm/s}$.