

PRODUCT TECHNICAL DATA SHEET

FLEXIBLE BIMETAL HAND HACKSAW BLADE

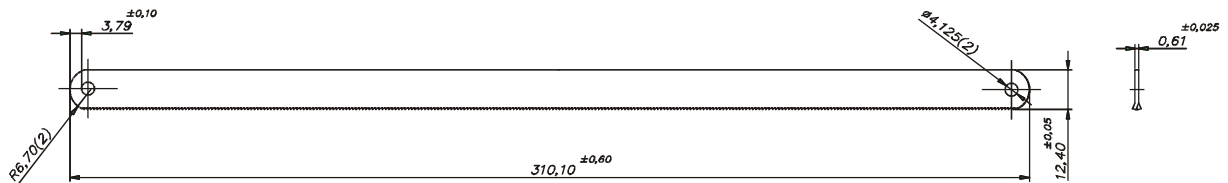
1. PRODUCT : Hand Hacksaw Blade – CAT. BS1218, BS1224, BS1232

2. DESCRIPTION : Flexible Bi-metal Hand Hacksaw Blade

3. UTILIZATION : Product for manual use on workbench or other place for cutting several types of material

4. TECHNICAL STANDARDS: ABNT NBR ISO 2336 Parte1, ISO 2336-1, BS1919 and NF E 73-072.

5. DIMENSIONS : General dimensions of the finished product



6. RAW MATERIAL:

Bimetal Unique™ Steel combines SAE-6150+Mo or D6a back and AISI M-2 edge, back hardness 81 – 86 HR15N and edge hardness 92 – 93 HR15N. This blade is flexible and shatter resistant.

7. FINISHING:

- Regular tooth form and wavy setting.
- Starrett standard yellow painting, using water-based paint, heavy metals free and totally nontoxic
- Red colour printing

8. Image of the finished product



9. Packing:

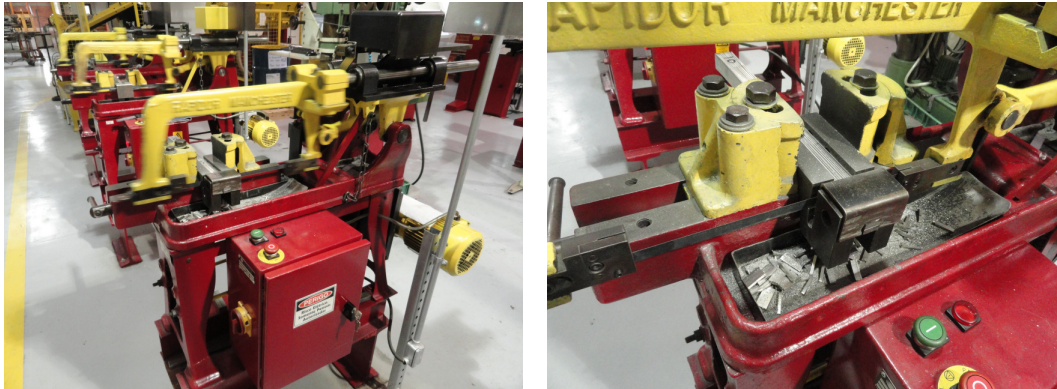
Packed in plastic box, with 10 blades or 50 blades;
Clear display box with 50 or 100 blades;
Plastic box with 10 blister cards, 2 blades each card

For further information please visit the Starrett website: www.starrett.com

10. PERFORMANCE CUTTING TESTS:

The tests report were prepared in accordance with **British standard 1919 - part 2**. The Starrett blades is in accordance to these requirements.

British standard 1919 - part 2.



Machine calibrated according following requisites:

- in good conditions, particularly in respect of stroke alignment and freedom from excessive vibration;
- with main slides sufficiently free from friction to prevent variations in dynamic loads;
- with the main pivot on the same axis as the crank drive shaft;
- which cuts on the forward stroke
- which presents the blade at an inclination of $1^{\circ}15' \pm 10'$
- with stroke length of $153\text{mm} \pm 1\text{ mm}$
- with a cutting speed of $70\text{ strokes/min} \pm 2\text{ strokes/min}$
- which does not lift the reciprocating arm on the return stroke
- which exerts static loads on the test bar at the top of the cut as follows:
 - start of stroke $3,3\text{kg} \pm 0,1$
 - Mid stroke $5,7\text{ kg} \pm 0,1$
 - end of stroke $8,4\text{ Kg} \pm 0,1$

A test bar consisting of lengths of cold rolled stainless steel type 304. the strip shall be $25,0\text{mm} \pm 0,15\text{mm}$ in width $2,6\text{mm} \pm 0,05\text{mm}$ in thickness.

Test bar - Cold rolled – Hardness $180\text{HV} \pm 12\text{HV}30$.

Assessment of results

a) **Wear rate.** Wear rate is represented by the recorded number of strokes plotted sequentially against section number. The average increase in wear per section cuts is the slope of plotted curve.

A mathematical value for this is derived by first performing a least squares linear regression which is designed to minimize the sum of the squares of the deviations of the actual recorded data points from the straight line of best fit and then calculating the slope of the line.

b) **Total time.** The total time shall be calculated by dividing the cumulative number of strokes for the allotted number of sections to be cut by the number of strokes per minute, performed by the machine.

All hard and bimetal blades shall perform the minimum wear rate and total time as follows, for ten cuts:

18pitch n° of strips 10 wear rate maximum 16 total time minimum 80 minutes
24pitch n° of strips 9 wear rate maximum 18 total time minimum 85 minutes
32 pitch n° of strips 8 wear rate maximum 18 total time minimum 90 minutes

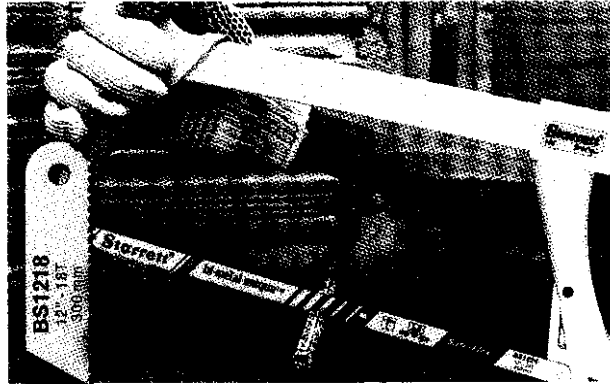
(Text from British standard 1919 - part 2)

We also performed the traction test according to Standard NF E 73-072 where our blade start to fault with 3200 N, which is in accordance with the standard.



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Starrett®



NUEVO



BS Bi-metal Starrett®

Esta hoja de sierra manual es una excelente opción para mecánicos, herreros, plomeros (fontaneros) y electricistas. Fabricada con el exclusivo acero Bi-metal Unique™.

- Corta 35% más rápido.
- Rendimiento 25% superior.
- Dientes 170% más resistentes a la rotura.
- Hoja de sierra manual flexible, irrompible durante el uso y a prueba de astillamiento.
- Para uso de profesionales exigentes.
- Menor costo por corte.

Largo x Ancho x Espesor		Dientes por 25mm	Nº Catálogo
300x13x0,60mm	12x1/2x0,024"	14	BS1214
		18	BS1218
		24	BS1224
		32	BS1232

Starrett®
bi-metal unique™
saw technology



HSS