



The American Society of
Mechanical Engineers

A N A M E R I C A N N A T I O N A L S T A N D A R D

SPECIFICATIONS FOR HACKSAW BLADES

REAFFIRMED 2015

FOR CURRENT COMMITTEE PERSONNEL
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ASME B94.52M-1999
(Revision of ASME B94.52M-1994)

Date of Issuance: January 28, 2000

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FOREWORD

The first Simplified Practice Recommendation to cover hacksaws was issued by the Department of Commerce in 1928, in cooperation with the hacksaw industry. The changing requirements of the marketplace were met by six subsequent revisions, the last revision being in 1962.

In 1962, recognizing the interest of European industry in promoting an international standard, the United States hacksaw industry began to work toward the approval of its standard under the Institute's existing standards method of procedure. The existing standard, ANSI B121.1-1970, was the result of this work.

As a result of work in the 1970s in the area of international standards, the Hack and Band Saw Manufacturers Association of America, which is a member of the committee for the promulgation of the standard (ISO TC29 WG), felt that additional information should be available to manufacturers, distributors, and users that would enable them to produce, sell, and utilize better hacksaw blades.

Added sections included:

- (a) suggested composition guidelines for standard, composite, alloy, and high-speed steel hacksaws;
- (b) hardness limits;
- (c) tooth form suggestions;
- (d) tooth form set tolerances;
- (e) flatness tolerances.

The present standard is a result of submittals by the hacksaw industry to the ASME Standards Committee B94. This Committee achieves consensus of the standards by means of a Subcommittee which develops standards under procedures accepted by the American National Standards Institute.

The American Society of Mechanical Engineers is the sponsor for B94 and supervises the promulgation of the standard with the expertise furnished by individual members. This Standard was designated B94.52M and was approved as an American National Standard on April 14, 1999.