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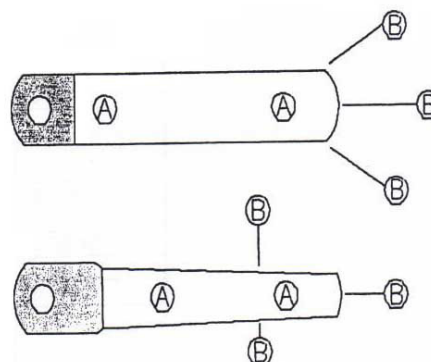
## Gauge Blades

Engineering standard for internally manufactured gage blades; steel and stainless steel.

**Additional Notes:**

For blade thicknesses greater than 0.0400 inch or 1.00 metric use  $\pm 0.0010$  thickness tolerance and burr tolerances corresponding with 0.400 blade.

- A. Designates area to check thickness tolerance on blades
- B. Designates area to check over burr tolerance on blades
- C. Hole end of blade (shaded area) may have a .0020 max. burr



### SAE Inch - Series Blades

Nominal Blade:	Thickness (inches):			Burr Tolerances (inches):	
	Tol. (+-)	Low Limit	High Limit	Edges	Holes
.0015	.00012	.00138	.00162	.0004	.0020
.0020	.00016	.00184	.00216	.0004	.0020
.0030	.00020	.00280	.00320	.0004	.0020
.0040	.00020	.00380	.00420	.0004	.0020
.0050	.00024	.00476	.00524	.0004	.0020
.0060	.00024	.00576	.00624	.0004	.0020
.0070	.00028	.00672	.00728	.0004	.0020
.0080	.00031	.00769	.00831	.0004	.0020
.0090	.00031	.00869	.00931	.0004	.0020
.0100	.00035	.00965	.01035	.0004	.0020
.0110	.00035	.01065	.01135	.0004	.0020
.0120	.00035	.01165	.01235	.0004	.0020
.0130	.00043	.01257	.01343	.0004	.0020
.0140	.00043	.01357	.01443	.0004	.0020
.0150	.00043	.01457	.01543	.0004	.0020
.0160	.00047	.01553	.01647	.0005	.0020
.0180	.00047	.01753	.01847	.0005	.0020
.0200	.00055	.01945	.02055	.0005	.0020
.0220	.00055	.02145	.02255	.0005	.0020
.0240	.00055	.02345	.02455	.0005	.0020
.0250	.00067	.02433	.02567	.0006	.0020
.0280	.00067	.02733	.02867	.0006	.0020
.0300	.00067	.02933	.03067	.0006	.0020
.0320	.00075	.03125	.03275	.0007	.0020
.0350	.00075	.03425	.03575	.0007	.0020



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## Gauge Blades

### SAE Inch - Series Blades

SAE (inches):	SAE Metric Equiv.:	Metric (mm):	Difference Metric V's Equiv. (mm):	Difference Metric V's Equiv. (inches):
.0015	.0381	.04	0.0019	0.00007
.0020	.0508	.05	- 0.0008	-0.00003
.0030	.0762	.07	-0.0062	-0.00024
.0030	.0762	.08	0.0038	0.00015
.0040	.1016	.09	0.0116	0.00046
.0050	.1270	-	-	-
.0060	.1524	.15	-0.0024	-0.00009
.0070	.1778	-	-	-
.0080	.2032	.20	-0.0032	-0.00013
.0090	.2286	-	-	-
.0100	.2540	.25	-0.0040	-0.00016
.0110	.2794	-	-	-
.0120	.3048	.30	-0.0048	-0.00019
.0130	.3302	-	-	-
.0140	.3556	.35	-0.0056	-0.00022
.0150	.3810	-	-	-
.0160	.4064	.40	-0.0064	-0.00025
.0180	.4572	.45	-0.0072	-0.00028
.0200	.5080	.50	-0.0080	-0.00031
.0220	.5588	.55	-0.0088	-0.00035
.0240	.6096	.60	-0.0096	-0.00038
.0250	.6350	-	-	-
.0280	.7112	.70	-0.0112	-0.00044
.0300	.7620	.75	-0.0120	-0.00047
.0320	.8128	-	-	-
.0350	.8890	.90	0.0110	0.00043

Product Code:	Description:	Size:	Additional Notes:
187-0036	Gauge Blade	-	-

TITLE: Engineering Standard for Internally Manufactured Gage Blades; Steel and Stainless Steel

Written By: K. Gruber

Date: 9/13/1998

Authorized By: Tom W. Burrows

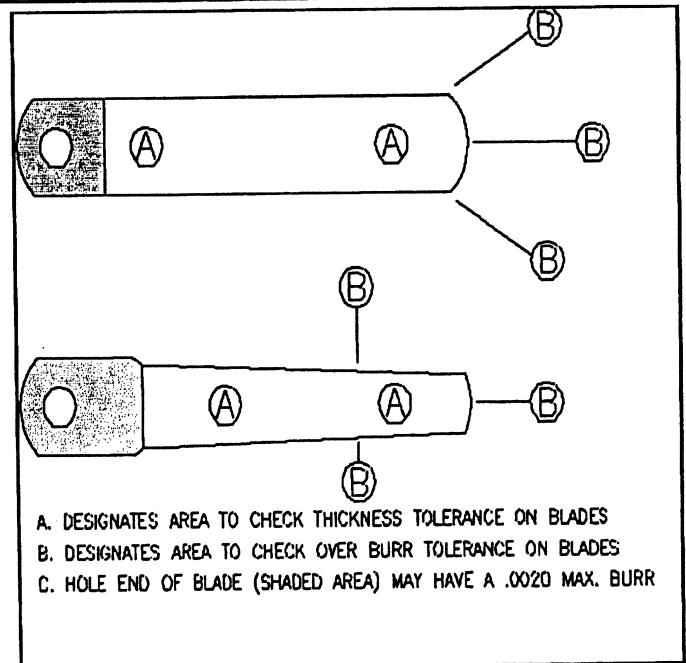
Date: 8/3/2004

**SAE Inch-Series Blades**

Nom. Blade	Thickness (inches)			Burr Tolerances (inches)	
	Tol. (+/-)	Low Limit	High Limit	Edges	Hole
.0010	.00012	.00088	.00112	.0004	.0020
.0015	.00012	.00138	.00162	.0004	.0020
.0020	.00016	.00184	.00216	.0004	.0020
.0025	.00020	.00230	.00270	.0004	.0020
.0030	.00020	.00280	.00320	.0004	.0020
.0040	.00020	.00380	.00420	.0004	.0020
.0050	.00024	.00476	.00524	.0004	.0020
.0060	.00024	.00576	.00624	.0004	.0020
.0070	.00028	.00672	.00728	.0004	.0020
.0080	.00031	.00769	.00831	.0004	.0020
.0090	.00031	.00869	.00931	.0004	.0020
.0100	.00035	.00965	.01035	.0004	.0020
.0110	.00035	.01065	.01135	.0004	.0020
.0120	.00035	.01165	.01235	.0004	.0020
.0130	.00043	.01257	.01343	.0004	.0020
.0140	.00043	.01357	.01443	.0004	.0020
.0150	.00043	.01457	.01543	.0004	.0020
.0160	.00047	.01553	.01647	.0005	.0020
.0170	.00047	.01653	.01747	.0005	.0020
.0180	.00047	.01753	.01847	.0005	.0020
.0190	.00047	.01853	.01947	.0005	.0020
.0200	.00055	.01945	.02055	.0005	.0020
.0210	.00055	.02045	.02155	.0005	.0020
.0220	.00055	.02145	.02255	.0005	.0020
.0230	.00055	.02245	.02355	.0005	.0020
.0240	.00055	.02345	.02455	.0005	.0020
.0250	.00067	.02433	.02567	.0006	.0020
.0260	.00067	.02533	.02667	.0006	.0020
.0270	.00067	.02633	.02767	.0006	.0020
.0280	.00067	.02733	.02867	.0006	.0020
.0290	.00067	.02833	.02967	.0006	.0020
.0300	.00067	.02933	.03067	.0006	.0020
.0310	.00067	.03033	.03167	.0006	.0020
.0320	.00075	.03125	.03275	.0007	.0020
.0330	.00075	.03225	.03375	.0007	.0020
.0340	.00075	.03325	.03475	.0007	.0020
.0350	.00075	.03425	.03575	.0007	.0020
.0360	.00075	.03525	.03675	.0007	.0020
.0370	.00075	.03625	.03775	.0007	.0020
.0380	.00075	.03725	.03875	.0007	.0020
.0390	.00075	.03825	.03975	.0007	.0020
.0400	.00094	.03906	.04094	.0007	.0020

**Metric-Series Blades**

Nom. Blade (mm)	Nom. Blade (inches)	Thickness (inches)			Burr Tolerances (inches)	
		Tol. (+/-)	Low Limit	High Limit	Edges	Hole
0.04	.0015	.00012	.00138	.00162	.0004	.0020
0.05	.0020	.00016	.00184	.00216	.0004	.0020
0.06	.0025	.00020	.00230	.00270	.0004	.0020
0.07	.0030	.00020	.00280	.00320	.0004	.0020
0.08	.0030	.00020	.00280	.00320	.0004	.0020
0.09	.0040	.00020	.00380	.00420	.0004	.0020
0.10	.0040	.00020	.00380	.00420	.0004	.0020
0.15	.0060	.00024	.00576	.00624	.0004	.0020
0.20	.0080	.00031	.00769	.00831	.0004	.0020
0.25	.0100	.00035	.00965	.01035	.0004	.0020
0.30	.0120	.00035	.01165	.01235	.0004	.0020
0.35	.0140	.00043	.01357	.01443	.0004	.0020
0.40	.0160	.00047	.01553	.01647	.0005	.0020
0.45	.0180	.00047	.01753	.01847	.0005	.0020
0.50	.0200	.00055	.01945	.02055	.0005	.0020
0.55	.0220	.00055	.02145	.02255	.0005	.0020
0.60	.0240	.00055	.02345	.02455	.0005	.0020
0.65	.0250	.00067	.02433	.02567	.0006	.0020
0.70	.0280	.00067	.02733	.02867	.0006	.0020
0.75	.0300	.00067	.02933	.03067	.0006	.0020
0.80	.0310	.00067	.03033	.03167	.0006	.0020
0.85	.0330	.00075	.03225	.03375	.0007	.0020
0.90	.0350	.00075	.03425	.03575	.0007	.0020
0.95	.03740	.00075	.03665	.03815	.0007	.0020
1.00	.0400	.00094	.03906	.04094	.0007	.0020



Note: For blade thicknesses greater than .0400 inch or 1.00 metric use  $\pm .0010$  thickness tolerance and burr tolerances corresponding with .0400 blade.

SAE (inches)	SAE METRIC EQUIV.	METRIC (mm)	DIFFERENCE METRIC VS. EQUIV. (in mm.)	DIFFERENCE METRIC VS. EQUIV. (in inches.)
0.0010	0.0254			
0.0015	0.0381	0.04	0.0019	0.00007
0.0020	0.0508	0.05	-0.0008	-0.00003
0.0025	0.0635	0.06	-0.0035	-0.00014
0.0030	0.0762	0.07	-0.0062	-0.00024
0.0030	0.0762	0.08	0.0038	0.00015
0.0040	0.1016	0.09	-0.0116	-0.00046
0.0040	0.1016	0.10	-0.0016	-0.00006
0.0050	0.1270			
0.0060	0.1524	0.15	-0.0024	-0.00009
0.0070	0.1778			
0.0080	0.2032	0.20	-0.0032	-0.00013
0.0090	0.2286			
0.0100	0.2540	0.25	-0.0040	-0.00016
0.0110	0.2794			
0.0120	0.3048	0.30	-0.0048	-0.00019
0.0130	0.3302			
0.0140	0.3556	0.35	-0.0056	-0.00022
0.0150	0.3810			
0.0160	0.4064	0.40	-0.0064	-0.00025
0.0170	0.4318			
0.0180	0.4572	0.45	-0.0072	-0.00028
0.0190	0.4826			
0.0200	0.5080	0.50	-0.0080	-0.00031
0.0210	0.5334			
0.0220	0.5588	0.55	-0.0088	-0.00035
0.0230	0.5842			
0.0240	0.6096	0.60	-0.0096	-0.00038
0.0250	0.6350			
0.0260	0.6604	0.65	-0.0104	-0.00041
0.0270	0.6858			
0.0280	0.7112	0.70	-0.0112	-0.00044
0.0290	0.7366			
0.0300	0.7620	0.75	-0.0120	-0.00047
0.0310	0.7874	0.80	0.0126	0.00050
0.0320	0.8128			
0.0330	0.8382	0.85	0.0118	0.00046
0.0340	0.8636			
0.0350	0.8890	0.90	0.0110	0.00043
0.0360	0.9144			
0.0370	0.9398	0.95	0.0102	0.00040
0.0380	0.9652			
0.0390	0.9906	1.00	0.0094	0.00037
0.0400	1.0160			

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