

A & E ENGINEERING SPECIFICATION

ES- 009

Revision Level: A

TITLE: **Engineering Standard for Purchased Gage Blades; Steel, Stainless Steel, and Brass**

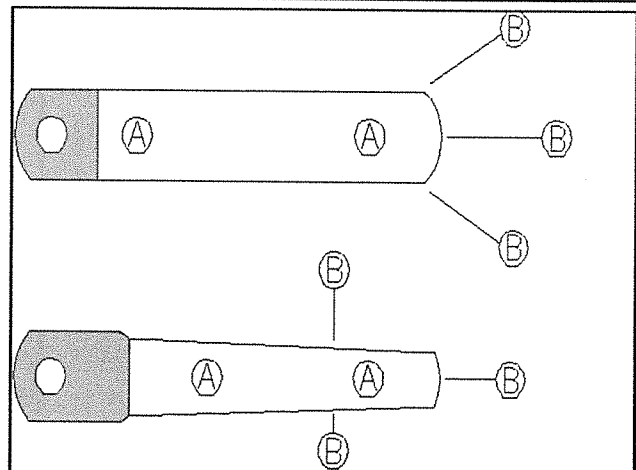
Written By: K.A. Gruber Date: 7/17/2002 Authorized By: Tom W. Burrows Date: 7/17/2002

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)	Blade (inches)	Thickness (inches)			Burr Tolerances (inches)	
		Tol. (+-)	Low Limit	High Limit	Edges	Hole
0.04	.00157	.00016	.00141	.00173	.0004	.0020
0.05	.00197	.00016	.00181	.00213	.0004	.0020
0.06	.00236	.00016	.00220	.00252	.0004	.0020
0.07	.00276	.00020	.00256	.00296	.0004	.0020
0.08	.00315	.00020	.00295	.00335	.0004	.0020
0.09	.00354	.00020	.00334	.00374	.0004	.0020
0.10	.00394	.00020	.00374	.00414	.0004	.0020
0.15	.00591	.00024	.00567	.00615	.0004	.0020
0.20	.00787	.00031	.00756	.00818	.0004	.0020
0.25	.00984	.00035	.00949	.01019	.0004	.0020
0.30	.01181	.00035	.01146	.01216	.0004	.0020
0.35	.01378	.00043	.01335	.01421	.0004	.0020
0.40	.01575	.00047	.01528	.01622	.0005	.0020
0.45	.01772	.00047	.01725	.01819	.0005	.0020
0.50	.01969	.00055	.01914	.02024	.0005	.0020
0.55	.02165	.00055	.02110	.02220	.0005	.0020
0.60	.02362	.00055	.02307	.02417	.0005	.0020
0.65	.02559	.00067	.02492	.02626	.0006	.0020
0.70	.02756	.00067	.02689	.02823	.0006	.0020
0.75	.02953	.00067	.02886	.03020	.0006	.0020
0.80	.03150	.00075	.03075	.03225	.0006	.0020
0.85	.03346	.00075	.03271	.03421	.0007	.0020
0.90	.03543	.00075	.03468	.03618	.0007	.0020
0.95	.03740	.00075	.03665	.03815	.0007	.0020
1.00	.03937	.00094	.03843	.04031	.0007	.0020



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