

INTERNATIONAL STANDARD

ISO
6753-1

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Tools for pressing and moulding — Machined plates —

Part 1:

Machined plates for press tools, jigs and
fixtures

Outilsage de presse et de moulage — Plaques usinées —

Partie 1: Plaques usinées pour outillage de presse, gabarits et montages



Reference number
ISO 6753-1:1994(E)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 6753-1 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 8, *Tools for pressing and moulding*.

Together with ISO 6753-2, it cancels and replaces the International Standard ISO 6753:1982, which has been technically revised.

ISO 6753 consists of the following parts, under the general title *Tools for pressing and moulding — Machined plates*:

- Part 1: *Machined plates for press tools, jigs and fixtures*
- Part 2: *Machined plates for moulds*

Tools for pressing and moulding — Machined plates —

Part 1:

Machined plates for press tools, jigs and fixtures

1 Scope

This part of ISO 6753 specifies dimensions and tolerances, in millimetres, of machined plates for press tools, jigs and fixtures.

It gives guidance relative to materials and hardness and specifies the designation of machined plates in accordance with this part of ISO 6753.

2 Dimensions

See figure 1 and table 1.

3 Material and corresponding hardness

The material and hardness are left to the manufacturer's discretion.

4 Designation

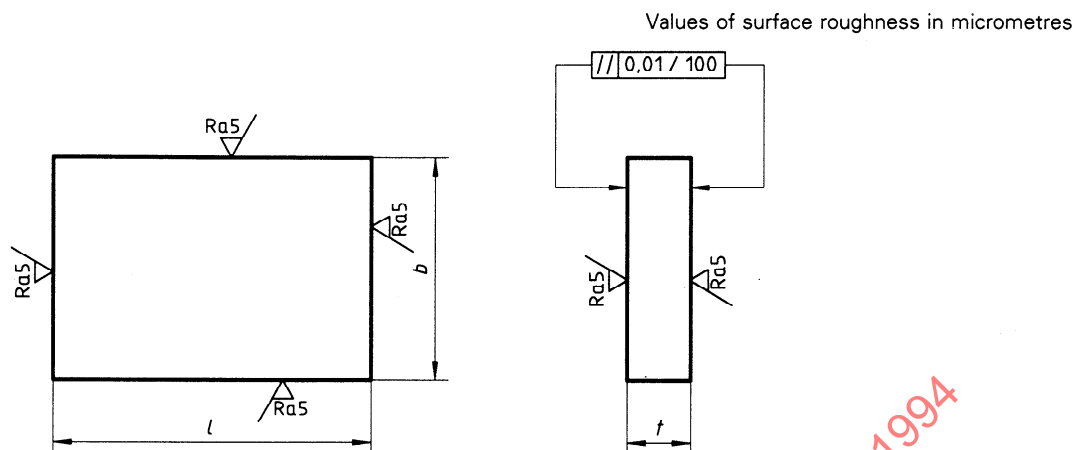
Machined plates for press tools in accordance with this part of ISO 6753 shall be designated by

- a) "Machined plate";
- b) reference to this part of ISO 6753;
- c) its edge machining process (oxygen cut, water-jet cut, etc.: 1; milled: 2);
- d) its length l , in millimetres;
- e) its width b , in millimetres;
- f) its thickness t , in millimetres.

EXAMPLE

The designation for a machined plate with oxygen-cut edges (1), with length $l = 160$ mm, with width $b = 80$ mm and with thickness $t = 20$ mm is as follows:

Machined plate ISO 6753-1 1-160 × 80 × 20



NOTE — These values of surface roughness apply only to plates with milled edges.

Figure 1

Table 1

Size of plate $l \times b$ ¹⁾	t						
	20	25	32	± 2 40	50	63	80
160 × 80	X	X	X				
160 × 100	X	X	X				
160 × 125	X	X	X				
160 × 160	X	X	X				
200 × 100		X	X	X			
200 × 125		X	X	X			
200 × 160		X	X	X			
200 × 200		X	X	X			
250 × 125		X	X	X			
250 × 160		X	X	X			
250 × 200		X	X	X			
250 × 250		X	X	X			
315 × 160			X	X	X		
315 × 200			X	X	X		
315 × 250			X	X	X		
315 × 315			X	X	X		
400 × 200			X	X	X		
400 × 250			X	X	X		
400 × 315			X	X	X		

Size of plate $l \times b$ 1)	t ± 2						
	20	25	32	40	50	63	80
400 × 400			X	X	X		
500 × 250			X	X	X		
500 × 315			X	X	X		
500 × 400			X	X	X		
500 × 500			X	X	X		
630 × 315			X	X	X	X	
630 × 400			X	X	X	X	
630 × 500			X	X	X	X	
630 × 630			X	X	X	X	
710 × 400			X	X	X	X	
710 × 500			X	X	X	X	
710 × 630			X	X	X	X	
800 × 400			X	X	X	X	
800 × 500			X	X	X	X	
800 × 630			X	X	X	X	
900 × 500			X	X	X	X	
900 × 630			X	X	X	X	
900 × 710			X	X	X	X	
1 000 × 500					X	X	X
1 000 × 630					X	X	X
1 000 × 710					X	X	X
1 000 × 800					X	X	X
1 120 × 630					X	X	X
1 120 × 710					X	X	X
1 120 × 800					X	X	X

1) Plates with milled edges: tolerance for dimensions l and $b \leq 630$ mm: $\begin{smallmatrix} +0.4 \\ +0.2 \end{smallmatrix}$ mm.

Plates with milled edges: tolerance for dimensions l and $b > 630$ mm: $\begin{smallmatrix} +0.6 \\ +0.2 \end{smallmatrix}$ mm.

Plates with oxygen-cut edges, water-jet-cut edges: tolerance for dimensions l and b : $\begin{smallmatrix} +4 \\ +1 \end{smallmatrix}$ mm.

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