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GB/T 13932-92

General Purpose Industrial Valves – Cast Iron Swing Check Valves

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General Purpose Industrial Valves – Cast Iron Swing Check Valves

1 Subject Content and Application Scope

This Standard specifies the structural type, technical requirements, test methods, marking, packaging, transport and storage of cast iron swing check valves.

This Standard is applicable to gray cast iron and ductile cast iron swing check valves which are connected by flanges and whose nominal pressure is PN0.25~4.0MPa, nominal diameter is DN50~1800mm, temperature is less than or equal to 350°C AND working medium is steam, air and water (hereinafter referred to as check valves).

2 Normative References

GB 152.1~152.4 Fasteners - Clearance Holes and Counterbores

GB 1184 Geometrical Tolerancing - Geometrical Tolerances for Features without individual Tolerance Indications

GB 4216 Gray Iron Pipe Flange and Gasket Dimensions

GB/T 13927 Pressure Testing for General Purpose Valves

GB 9112 Types of Steel Pipe Flanges

GB 9113 Integral Steel Pipe Flanges

GB 12220 General Purpose Industrial Valves - Marking

GB 12221 Metal Valves for Use in Flanged Pipe Systems - Face-to-face and Centre-to-face Dimensions

GB 12232 General Purpose Industrial Valve - Flanged Iron Gate Valves

GB/T 12252 General Purpose Industrial Valve - Delivery Specification

JB 308 Valves Model Designation Method

JB/T 5300 General Purpose Valves - Material

4.4 Bonnet

4.4.1 The minimum wall thickness of bonnet shall be in accordance with those specified in Table 3.

4.4.2 The bonnet and valve body are connected by flange; where the nominal pressure, PN, is less than or equal to 2.5MPa; the flange sealing face may adopt plane type; for other conditions, convex-concave type, tongue-and-groove type or trapezoidal groove type may be adopted, but it shall be noted in the order contract.

4.4.3 The bonnet flange whose nominal pressure, PN, is greater than or equal to 2.5MPa, shall be round; its rear surface shall be processed or reamed to flat according to the requirements of GB 152.1~152.4.

4.4.4 The quantity of connection screws (or studs) of the bonnet and valve body shall not be less than 4.

4.5 Valve seat and valve flap

4.5.1 The combination between the valve seat and valve body AND between the valve flap sealing ring and valve flap may be in any form, however, it must ensure that no looseness or falling-off occurs during the use, and no leakage happens at the junction.

4.5.2 The valve seat and valve flap sealing ring may also be processed directly on the valve body or valve flap, or be processed after the valve body or valve flap has been overlaid with other metal; the thickness after the processing of overlaying layer shall not be less than 2mm.

4.6 Rocker

The connection between the rocker and the valve flap or valve body must be guaranteed of flexible rotation, reliable sealing and free from falling-off in service.

4.7 Others

4.7.1 The total area of the filter holes on the filter screen shall be greater than 1.5 times of the nominal diameter area.

4.7.2 According to the user's requirements, the check valve may be set with buffer devices in different forms.

4.8 Materials

Materials of the major parts of check valve shall be selected according to the requirements of JB/T 5300.

5 Test Methods

The pressure test of check valve shall meet the requirements of GB/T 13927.

6 Marking, Packaging, Transport and Storage

6.1 Marking of check valves shall meet the requirements of GB 12220.

6.2 Packaging, transport and storage of check valves shall meet the requirements of GB/T 12252.

Additional Information:

This Standard was proposed by the Ministry of Machine and Electronics Industry of the People's Republic of China.

This Standard shall be under the jurisdiction of Hefei General Machinery Research Institute, Ministry of Machine Building and Electronics Industry.

Tieling Valve Plant is responsible for the drafting of this Standard.

Chief drafting staffs of this Standard are Wang Yueliang and Wu Hongnian.

Hefei General Machinery Research Institute, Ministry of Machine Building and Electronics Industry is entrusted for the interpretation of this Standard.

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