

Translated English of Chinese Standard: GBT21469-2008

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NATIONAL STANDARD OF THE  
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**GB/T 21469-2008**

Replacing GB/T 15826.1-1995

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**Machining allowances and tolerances for steel open die  
forgings on hammer - General requirement**  
锤上钢质自由锻件机械加工余量与公差 一般要求

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## Foreword

This standard is a revision of GB/T 15826.1-1995 *Machining allowances and tolerances for steel open die forgings on hammer - General requirement*.

Compared with GB/T 15826.1-1995, the main changes of this standard are as follows:

- The foreword is added.
- English annotations for terms are added.

This standard was proposed by the China Machinery Industry Federation.

This standard is under the jurisdiction of the National Technical Committee on Forging and Stamping of Standardization Administration of China.

Drafting organizations of this standard are Shanghai Hudong Forging Factory and Pinghu Chenren Meter Co., Ltd.

The main drafters of this standard are Sun Changfen and Dong Zhusheng.

The previous versions of the standards replaced by this standard are as follows:

- GB/T 15826.1-1995.

# **Machining allowances and tolerances for steel open die forgings on hammer - General requirement**

## **1 Scope**

This standard specifies the general requirements for the machining allowances and tolerances of steel open die forgings on hammer and their use.

This standard applies to open die forgings of carbon steel and alloy steel with a carbon content not exceeding 0.9% and a total content of other alloy components not exceeding 4%.

For open die forgings that exceed the scope specified in this standard, the machining allowance and tolerance shall be determined by the supplier and the buyer through separate negotiation.

## **2 Normative references**

The clauses in the following documents become the clauses of this standard through reference in this standard. For all the referenced documents with dates, all the subsequent amendments (excluding errata) or revisions are not applicable to this standard. However, the parties who reach an agreement based on this standard are encouraged to study whether the latest versions of these documents can be used. For all the referenced documents without dates, the latest versions are applicable to this standard.

GB/T 8541 Terminology of forging and stamping

## **3 Terminology**

### **3.1 Basic terms**

The definitions of nominal dimensions of forgings, forging tolerances, steps, hubs, forgings without machining and forging drawings shall be in accordance with the provisions of GB/T 8541.

### **3.2 Other terms**

#### **3.2.1 machining allowance**

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