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NATIONAL STANDARD OF THE
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ICS 43.060.30

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GB/T 34595-2017

The technical specifications for remanufacturing of automotive components - Water pump

汽车零部件再制造产品技术规范

水泵

Issued on: October 14, 2017

Implemented on: May 1, 2018

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China;**

**Standardization Administration of the People's Republic of
China.**

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The technical specifications for remanufacturing of automotive components - Water pump

1 Scope

This Standard specifies the terms and definitions, disassembly, cleaning, classification, testing and repair, assembly, exit-factory inspection, protection, marking and packaging and other requirements for remanufacturing water pumps.

This Standard is applicable to the remanufacturing of cooling water pumps for automotive engines. For the remanufacturing of water pumps for other purposes, it can also be used for reference.

2 Normative references

The following documents are essential to the application of this document. For dated references, only the editions with the dates indicated are applicable to this document. For undated references, only the latest editions (including all the amendments) are applicable to this document.

GB/T 26989 *Automobile recovery -- Terminology*

GB/T 28675 *Remanufacturing of automotive components -- Disassembly*

GB/T 28676 *Remanufacturing of automotive components -- Classification*

GB/T 28677 *Remanufacturing of automotive components -- Cleaning*

GB/T 28678 *Remanufacturing of automotive components -- Pre-delivery inspection*

GB/T 28679 *Remanufacturing of automotive components -- Assembly*

QC/T 288.1-2001 *Technical specifications for cooling water pumps of automotive engines*

3 Terms and definitions

The terms and definitions defined by GB/T 26989 are applicable to this document.

must not cause damage to the environment.

5 Testing and repair

5.1 Testing and repair of water pump housing

5.1.1 Visual inspection

Non-destructive testing methods such as visual inspection, liquid penetrate testing, pressure sealing test, eddy current testing, etc. can be used to detect the existence of defects such as cracks in the water pump housing. If cracks are too severe to be remanufactured, it shall be scrapped. If there are flaws in the oil passages of the inner cavity of the housing and the mounting holes, surfaces, etc., they shall be scrapped.

5.1.2 Dimension testing

In accordance with the requirements of the drawings, TEST the geometric accuracy of the water pump housing such as dimensional tolerance, geometric tolerance, etc. MAKE the records accordingly.

5.1.3 Water pump housing repair

5.1.3.1 For defects that are not affected by pressure, the methods such as cracking rivets, welding repair (arc cold welding, cold gas welding, brazing or spray welding, etc.) or the use of special glue to bond the broken and cracked parts of castings may be used for repair. After repair, it is required to make a smooth surface by grinding. On the machined surface, grinding or cutting is applied until it is flush with the reference surface. For those with sealing or pressure requirements, airtightness tests, hydrostatic tests, or leak tests shall be conducted after repair.

5.1.3.2 The defects such as pores, blisters, etc. can be filled with a special repair agent and repaired by machining and cutting.

5.1.3.3 TEST the dimensional tolerance, geometric tolerance, surface structure, etc. of the housing. Where the housing hole size is out of tolerance or worn, the machining methods such as grinding, reaming, etc. are used to eliminate wear trace. Then PROVIDE with oversized lining. Or USE cladding, cold welding, spraying and other methods to restore the size.

5.1.3.4 For the damages to machining plane, USE metal spraying or other welding repair methods to repair, through the addition of materials, followed by machining.

5.1.3.5 If the remaining holes are damaged, PRE-TREAT the damaged mating holes. REPAIR by welding repair. For damaged threaded holes without

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