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**High Speed Precision Hot Upsetting Forgings -
General Specification**

高速精密热镦锻件 通用技术条件

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High Speed Precision Hot Upsetting Forgings - General Specification

1 Scope

This Standard specifies the technical requirements, test methods and inspection rules, mark, package, transportation and storage of high-speed precision hot upsetting forgings (hereinafter referred to as “forgings”).

This Standard is applicable to using the high-speed precision hot upsetting forging equipment to produce the steel precision hot forgings with mass 7.5kg below and outer size no greater than 180mm at the beat of more than 50 times per minute.

2 Normative References

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

GB/T 191 Packaging - Pictorial Marking for Handling of Goods

GB/T 224 Determination of Depth of Decarburization of Steels

GB/T 226 Test Method for Macrostructure and Defect of Steel by Etching

GB/T 228.1 Metallic Materials - Tensile Testing – Part 1: Method of Test at Room Temperature

GB/T 229 Metallic Materials - Charpy Pendulum Impact Test Method

GB/T 230.1 Metallic materials - Rockwell Hardness Test - Part 1: Test Method (Scales A, B, C, D, E, F, G, H, K, N, T)

GB/T 231.1 Metallic Materials - Brinell Hardness Test - Part 1: Test Method

GB/T 699 Quality Carbon Structural Steels

GB/T 700 Carbon Structural Steels

GB/T 702 Hot-Rolled Steel Bars - Dimensions, Shape, Weight and Tolerances

GB/T 3077 Alloy Structure Steels

GB/T 5216 Technical Requirements for Structural Steel with Specified Hardenability Bands

GB/T 6394 Metal - Methods for Estimating the Average Grain Size

GB/T 8541 Terminology of Forging and Stamping

GB/T 13298 Inspection Methods of Microstructure for Metals

GB/T 13299 Steel - Determination of Microstructure

GB 13318-2003 General Rules for Safety and Environmental Conservation of Forging Production

GB/T 13320 Metallographic Grading Atlas and Assessing Method for Steel Die Forgings

GB/T 18254 High-Carbon Chromium Bearing Steel

GB/T 19096-2003 Technical Drawing - Drawing Presentation - Vocabulary and Indications for Edges of Undefined Shape

3 Terms and Definitions

The terms and definitions stipulated in GB/T 8541 are applicable to this document.

4 Technical Requirements

4.1 Acceptance basis

The forging drawings, technical agreements and supply contract signed by the supplier and the purchaser shall be served as the main basis for the inspection and delivery of the forged finished products.

4.2 Raw materials

4.2.1 The raw materials selected for forgings shall conform to the provisions of GB/T 699, GB/T 700, GB/T 3077, GB/T 18254, GB/T 702, GB/T 5216, and other standards.

4.2.2 The steel used for forgings in addition to meeting the requirements of 4.2.1, different forgings manufacturers shall also take enterprise standard or special technical

6 Mark, Package, Transportation and Storage

6.1 Mark requirements

6.1.1 The forgings shall be marked; when marking is not required, it shall be determined through the negotiation between the supplier and the purchaser.

6.1.2 Each batch of forgings shall be accompanied by a quality certificate issued by the Quality Inspection Department.

6.1.3 The symbol of storage and transportation of the package shall conform to the provisions of GB/T 191; it shall mark the following contents:

- a) Supplier name, address, contact number and fax;
- b) The name, drawing number, quantity, status and part number of the packaged products;
- c) The purchaser organization and address;
- d) Production batch number;
- e) Date of packaging, and rust-proof period.

6.2 Package requirements

The forgings shall take the rust-proofed measures before being packaged; the rust-proof period shall be determined through the negotiation between the supplier and the purchaser. The packaging box shall adopt wooden box, calcium plastic corrugated box, metal packing box, or reusable turnover box, etc.; if agreed by the purchaser, the simple package can also be adopted. Appropriated measures shall be taken during the packaging to prevent bumps during the transportation.

6.3 Transportation requirements

The forgings shall be avoided rain and bumps during the exit-factory transportation; ensure no damage during the normal transportation.

6.4 Storage requirements

The packaged forgings shall be stored neatly in a ventilated and dry warehouse according to their types and models.

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