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**Remanufacturing - Technical specifications for
inspection of mechanical products**

再制造 机械产品检验技术导则

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Remanufacturing - Technical specifications for inspection of mechanical products

1 Scope

This Standard specifies the inspection classification, general requirements, main inspection content and other relevant technical requirements for remanufactured mechanical products.

This Standard is applicable to the inspection assessment of remanufactured mechanical products.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

GB/T 2828.1, *Sampling procedures for inspection by attribute - Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection*

GB/T 28618, *Remanufacturing - General technical requirements for mechanical products*

GB/T 28619, *Remanufacturing - Terminology*

GB/T 31208, *The methods of quality evaluation for remanufacturing core*

3 Terms and definitions

For the purposes of this document, the terms and definitions defined in GB/T 28619 as well as the followings apply.

4 Inspection classification

4.1 According to the test object, it can be divided into: parts inspection, assembly inspection and machine inspection.

heat treatment, and the mated surface after processing shall not need to be annealed.

6.1.1.3 Degaussing shall be performed due to machining or inspection of workpieces with residual magnetism. The burrs on the surface of the part (including the keyway) shall be removed, and the sharp edges and sharp corners shall be blunt.

6.1.1.4 Dimensional inspection and precision inspection of the surface repair layer after machining, the size and precision shall meet the process requirements.

6.1.2 Repair layer inspection

6.1.2.1 Spray coating

6.1.2.1.1 Use intensity tensile tester to test the bonding strength and hardness of the sprayed layer.

6.1.2.1.2 The surface of the coating is free from cracks, peeling and stripping, and the surface roughness shall meet the design requirements.

6.1.2.2 Brush plating

6.1.2.2.1 The hardness of the brush plating can be checked by a hardness tester.

6.1.2.2.2 After the brush plating is mechanically processed, the coating does not fall off or peel off, which affects the defects of use.

6.1.2.3 Welding layer

6.1.2.3.1 Through fatigue and wear resistance experiments and metallographic analysis, determine whether the welding layer meets the mechanical properties requirements.

6.1.2.3.2 Determine whether the bonding strength and airtightness meet the repair process requirements by means of tensile test, pressure test (strength test) and non-destructive testing.

6.1.2.3.3 The surface of the welding layer shall be uniform, without peeling, faulting, etc. The dimensions and surface quality shall meet the requirements of the repair process.

6.1.2.4 Other repair layer

For parts with special inspection requirements, it can be executed according to the requirements of both supplier and purchaser.

6.3.3 Reliability inspection

The reliability inspection of remanufactured mechanical products is based on the requirements of both the supplier and the purchaser.

6.3.4 Operation inspection

In the trial operation of remanufactured mechanical products, the following principles shall be obeyed: non-load before load, the partial before the whole, low speed before high speed, short time before long time. Check the lubrication and heat generation of the friction combination, whether the operation is stable, whether there is abnormal noise and vibration, and the sealing or fastening of each connection part. For remanufactured products with special requirements, in order to achieve long-term effective operation under the specified load conditions, appropriate overload test operation can be carried out.

6.3.5 Other item inspection

Negotiated by both parties, the whole machine inspection required by other items can be performed.

7 Painting inspection

7.1 Before painting, there shall be no burrs, scales, sticky sand, oil stains, etc.

7.2 Special parts shall be protected.

8 Type inspection

Type inspection shall be performed in one of the following situations:

- a) trial model identification for new product or old product produced in transferred plant;
- b) once every 3 years after official production which may affect product performances;
- c) production resumed after discontinued production of more than two year;
- d) great difference between exit-factory inspection results and previous type inspection results.

9 Packaging inspection

9.1 The exit-factory documentation for remanufactured mechanical products shall include the following information:

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