

Translated English of Chinese Standard: GB/T6883-2017

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NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA

ICS 77.160

H 72

GB/T 6883-2017

Replacing GB/T 6883-1995

Cemented Carbide Sintering Body for Wire, Bar or Tube Drawing Dies - Dimensions

线、棒、管拉模用硬质合金烧结品 尺寸

(ISO2804: 1996, Wire, bar or tube drawing dies -

As-sintered pellets of hard metal (carbide) - Dimensions, NEQ)

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**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine;**

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

Table of Contents

Foreword	3
1 Scope	5
2 Normative references	5
3 Symbols and names	5
4 Requirements	6
5 Test method	14
6 Test rules	15
7 Marking, packaging, transportation, storage and quality certificate	16
8 Contract (or order form) content.....	17

Foreword

This Standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This Standard replaces GB/T 6883-1995, Wire, bar or tube drawing dies. As sintered pellets of hard-metal.

Compared with GB/T 6883-1995, the major changes of this Standard are as follows:

- Partially adjust type-II product specifications;
- Cancel the normal level of dimensional tolerance;
- Respectively formulate the dimensional tolerance according to the wire mold base and the bar and tube mold base;
- Delete Appendix A, and standardize the requirements for machining allowances;
- Delete Appendix B;
- Add requirements for size falling corners;
- Revise the surface defect requirements of the mold base;
- Add relevant contents of surface quality to the test methods and inspection rules.

This Standard uses the redrafting method to refer to ISO 2804:1996, Wire, bar or tube drawing dies - As-sintered pellets of hard metal (carbide) - Dimensions, NEQ; and its degree of consistency with ISO 2804:1996 is non-equivalent.

This Standard was proposed by the China Nonferrous Metals Industry Association.

This Standard shall be under the jurisdiction of National Technical Committee 243 on Nonferrous Metals of Standardization Administration of China (SAC/TC 243).

The drafting organizations of this Standard: Zhuzhou Cemented Carbide Group Co., Ltd., China Nonferrous Metals Techno-Economic Research Institute, Shenzhen Zhucheng Technology Co., Ltd.

The drafters of this Standard: Wang Huiping, Wu Jianbing, Liu Tiemei, Yang Jun, Wu Yanhua, Zhao Guoming.

The previous versions of the standards which are replaced by this Standard are:

Cemented Carbide Sintering Body for Wire, Bar or Tube Drawing Dies - Dimensions

1 Scope

This Standard specifies the dimensions and technical requirements for cemented carbide sintering body for metal wire, bar or tube drawing dies.

This Standard applies to metal wire, bar and tube drawing dies.

2 Normative references

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

GB/T 5242, Inspection rules and test methods of cemented carbide products

GB/T 5243, Marking, packing, transport and storage of cemented carbide products

3 Symbols and names

Symbols and names which are referred to in this Standard are shown in Table 1.

Table 1

Symbol	Name	Unit
d_1	Inner diameter of machining allowance	Millimeter (mm)
d_{01}	Inner diameter	
d_{02}	Outer diameter	
d_{04}	Entrance area width	
d_{05}	Exit area width	
h_{02}	Height	
l_{01}	Entrance area depth	
l_{02}	Deformation area depth	
l_{03}	Calibrating strap length	
l_{04}	Exit area length	
R_{01}	Entrance area chamfer radius	

5.2 The physical property, mechanical property and structure of the product shall be inspected according to the method that is determined by GB/T 5242.

5.3 The size and allowable deviation of the product shall be inspected by a gage of the appropriate accuracy.

5.4 The appearance quality of the product shall be inspected visually and in combination with gauges of corresponding precision.

6 Test rules

6.1 Inspection and acceptance

6.1.1 The product shall be inspected by the supplier to ensure that the product quality complies with the requirements of this Standard and the contract (or the order form); the supplier shall fill in the quality certificate.

6.1.2 The demander shall re-inspect the received products in accordance with the provisions of this Standard and the contract (or the order form). If the result of the re-inspection is inconsistent with the provisions of this Standard and the contract (or the order form), a written form shall be submitted to the supplier within 3 months from the date of receipt of the product; the issue shall be settled by negotiation between the supplier and the buyer. If an arbitration is required, the arbitration sampling shall be carried out jointly by the supplier and the buyer.

6.2 Batch

Products shall be submitted for acceptance in batches. Each batch consists of products of the same raw material, the same type, and the same process. The quantity of each batch is determined according to the requirements of the buyer.

6.3 Inspection items and sampling

The inspection items, sampling regulations and quantities of the products shall comply with the requirements of Table 14.

Table 14

Inspection items	Sampling regulations	Sampling amount	Required article number	Article number of the test method
Chemical composition	Mixture	1 part per batch	4.4	5.1
Physical property, mechanical property, structure	Random sampling of products (for bending strength	Perform according to the	4.5	5.2

	test, use the furnace sample)	provisions of GB/T 5242		
Dimensions and allowable deviation	One by one	-	4.6	5.3
Appearance quality	One by one	-	4.7	5.4
Note: for the chemical composition of the product, the supplier is allowed to report the test results by the mixture.				

6.4 Determination of the test result

6.4.1 If the chemical composition of the product is unqualified, the batch of products is judged to be unqualified.

6.4.2 The determination of the test result of physical property, mechanical property and structure of the product shall be performed according to the provisions of GB/T 5242. When the test result is unqualified, double sampling shall be carried out to repeat the test of the unqualified items. If there is still one unqualified inspection result, the batch of products is judged unqualified.

6.4.3 If the dimension and allowable deviation of the product are unqualified, the product is judged to be unqualified.

6.4.4 If the appearance quality of the product is unqualified, the product is judged to be unqualified.

7 Marking, packaging, transportation, storage and quality certificate

7.1 Marking, packaging, transportation and storage

Marking, packaging, transportation and storage of products shall be carried out according to provisions of GB/T 5243.

7.2 Quality certificate

Each batch of products shall be accompanied by a quality certificate, which indicates:

- a) the name and address of the supplier;
- b) product name;
- c) product model;
- d) batch number;

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