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**Copper powder metallurgy dry brake friction lining of  
clutch of forging press - Specification**

锻压机床离合器铜基干式摩擦片 技术规范

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# **Copper powder metallurgy dry brake friction lining of clutch of forging press - Specification**

## **1 Scope**

This document specifies the technical requirements, test methods, inspection rules, marking, accompanying documents and packaging, transportation and storage of copper powder metallurgy dry brake friction lining of clutch of forging press.

This document is applicable to the manufacture of copper powder metallurgy dry brake friction lining of clutch of forging press (hereinafter referred to as “friction lining”).

## **2 Normative references**

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the version corresponding to that date is applicable to this document; for undated references, the latest version (including all amendments) is applicable to this document.

GB/T 1958, Geometrical product specifications (GPS) - Geometrical tolerance - Verification

GB/T 10421, Sintered metal friction materials - Determination of density

GB/T 10425, Sintered metal friction materials - Determination of apparent hardness

JB/T 7269, Sintered metal friction materials run without lubricants - Determination of frictional characteristics

## **3 Terms and definitions**

No terms and definitions need to be defined in this document.

## **4 Technical requirements**

**4.1** The friction and wear properties and physical properties of the friction lining shall meet the requirements in Table 1.

evenly distributed bonding points at the point where the friction layer falls off, which means the bond is firm.)

**5.6** Geometric errors shall be tested according to the provisions of GB/T 1958:

- a) Parallelism detection: Use a micrometer to uniformly measure the total thickness point by point on the inner and outer rings of the lining surface of the friction lining, and take the difference between the maximum value and the minimum value of these measurement points as the parallelism of the friction lining;
- b) Flatness detection: Place the two ends of the friction lining on the first-level flat plate; use a feeler gauge with an accuracy of 0.01 mm to measure point by point on the inner and outer rings of the friction lining surface; take the maximum value as the flatness of the friction lining.

**5.7** See Table 3 for the inspection methods of the appearance quality and packaging quality of friction linings.

**5.8** Use measuring tools such as micrometers, vernier calipers, measuring rods, and snap-gauges to measure the structure size of friction linings.

## **6 Inspection rules**

### **6.1 Ex-factory inspection**

The ex-factory inspection items are shown in Table 4.

### **6.2 Type inspection**

The type inspection items are shown in Table 4. In any of the following cases, type inspection shall be carried out:

- a) A new product is put into production;
- b) The product is transferred to another factory for production or the production is resumed after more than 2 years of suspension;
- c) Large changes in materials and processes may affect product performance;

**6.5.2** If all the test results of the friction layer density, apparent hardness, and friction and wear properties meet the requirements of this document, the above inspection items of this batch of products shall be judged to be qualified. If any of the above inspection items does not meet the requirements of this document, re-inspect the item with double sampling; if the re-inspection results all meet the requirements of this document, judge the item qualified; if the re-inspection results still do not meet the requirements of this document, judge this batch of products as unqualified.

**6.5.3** If all the inspection items are qualified, judge the batch of products to be qualified. If any item is unqualified, judge the batch of products to be unqualified.

## **7 Marking and accompanying documents**

### **7.1 Marking**

Marking shall comply with:

- a) For easy identification, there shall be a special marking of the manufacturer or a traceable production date or production batch on the spline tooth or flange of the crossband veneer of the friction lining.
- b) There shall be rain-proof, moisture-proof, and upright markings, as well as the product code, name and quantity, and the manufacturer's logo and name, and production date, on the conspicuous places outside the packaging box. The handwriting of marking and labeling shall be clear and beautiful, and not easy to disappear.
- c) When the user has special requirements for product marking, the marking shall be in accordance with the user's requirements.

### **7.2 Accompanying documents**

Accompanying documents shall generally include the product qualification certificate, which shall be placed in the packaging box.

## **8 Packaging, transportation and storage**

### **8.1 Packaging**

**8.1.1** Products shall be packaged with moisture-proof packaging materials, and the packaging box shall be firm and reliable.

**8.1.2** The dimensions and weight of the packaging box shall comply with the relevant regulations of the transportation department.

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