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MACHINERY INDUSTRY STANDARD
OF THE PEOPLE'S REPUBLIC OF CHINA

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Replacing JB/T 3943.1-1999

Drawing Dies – Carbide Alloy Drawing Dies - Specifications

拉制模 硬质合金拉制模 技术条件

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Table of Contents

Foreword	3
1 Scope	5
2 Normative References	5
3 Requirements	5
3.1 Structural requirements	5
3.2 Parts requirements	7
3.3 Assembly requirements	8
4 Inspection	8
4.1 Co-axiality inspection of die hole and die sleeve	8
4.2 Die hole inspection	8
5 Acceptance.....	9
6 Marking, Packaging, Transportation and Storage.....	9
6.1 Marking	9
6.2 Packaging, transportation and storage.....	10

Foreword

This Standard was drafted as per the rules specified in GB/T 1.1-2009.

This Standard replaced JB/T 3943.1-1999 *Technical Specification or Hard Alloy Dies for Wire Drawing*. Compared with JB/T 3943.1-1999, the major technical changes of this Standard are as follows:

- Change the name of *Technical Specification or Hard Alloy Dies for Wire Drawing* into *Drawing Dies – Carbide Alloy Drawing Dies - Specifications*;
- Change the dated documents cited in the Normative References to the current edition;
- Make necessary modifications and improvements to the content, structure and tables in accordance with current national standards;
- Modify the typical structural diagram of cemented carbide drawing die;
- Delete the table of size data in the original standard;
- Add recommended materials and requirements regulations for die parts;
- Add die hole structure diagram;
- Modify the die hole surface roughness requirements and tables;
- Add the structure and limit deviation requirements regulations of die cores and die sleeves;
- Add matching tolerance requirements regulation between die sleeves and die holes;
- Add assembly requirements regulations;
- Modify "test method" in the original standard into "inspection"; and make major changes to the inspection content and methods;
- Modify the "inspection rules" in the original standard into "acceptance"; and add acceptance regulations;
- Modify "packaging" in the original standard into "marking, packaging, transportation and storage"; and add marking diagrams and transportation and storage regulations;
- Delete "Appendix A Compression Ratio Selection Reference Table".

This Standard was proposed by China Machinery Industry Federation.

This Standard shall be under the jurisdiction of National Technical Committee on Dies of Standardization Administration of China (SAC/TC 33).

Drawing Dies – Carbide Alloy Drawing Dies – Specifications

1 Scope

This Standard specifies the requirements, inspection, acceptance and marking, packaging, transportation and storage of carbide alloy drawing dies.

This Standard applies to carbide alloy drawing dies for wire and bar forming.

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) is applicable to this Document.

GB/T 1184-1996 Geometrical tolerancing - Geometrical tolerance for features without individual tolerance indications

GB/T 1800.2-2009 Geometrical product specifications (GPS) - Limits and fits - Part 2: Tables of standard tolerance grades and limit deviations for holes and shafts

GB/T 1801-2009 Geometrical product specifications (GPS) - Limits and fits - Selection of tolerance zones and fits

GB/T 6110-2008 Carbide dies for drawing - Types and dimensions

GB/T 18376.3-2015 Grades of cemented carbide - Part 3: Grades of cemented carbide for wear parts

3 Requirements

3.1 Structural requirements

3.1.1 The carbide alloy drawing die consists of a die core and a die sleeve. The typical structure is shown in Figure 1.

5 Acceptance

5.1 Acceptance shall include the following:

- a) Inspection of die size and appearance;
- b) Inspection of product quality compliance.

5.2 Suppliers and customers shall inspect the appearance and dimensions of the die according to technical requirements.

5.3 After the die runs stably, take the 5m~10m products for appearance and dimensional inspection.

5.4 After the die supplier and customer confirm that the product is qualified, the supplier shall issue a die certificate and deliver it to the customer along with the die. The certificate of conformity shall include the following contents:

- a) Contract number;
- b) Supplier's name;
- c) Die number;
- d) Die specifications;
- e) Die quality;
- f) Exit-factory date.

6 Marking, Packaging, Transportation and Storage

6.1 Marking

The die shall be marked with the trademark and specifications on the front of the die sleeve; and the blank model and die number on the back of the die sleeve. The location of the marking is shown in Figure 3.

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