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BUILDING MATERIAL STANDARD OF
THE PEOPLE'S REPUBLIC OF CHINA

JC/T 644-1996

Man-made agate and man-made marble sanitary wares

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Man-made agate and man-made marble sanitary wares

1 Scope

This standard specifies the definition, product classification, technical requirements, test methods, inspection rules, marking, packaging, transportation, storage of man-made agate and man-made marble sanitary ware.

This standard applies to man-made agate and man-made marble sanitary ware.

2 Normative references

The provisions contained in the following standards constitute provisions of this standard by reference in this standard. At the time of publication, the editions indicated were valid. All standards will be revised and parties using this standard should explore the possibility of using the latest version of the following standards.

GB 1462-88 Test methods for water absorption of fiber reinforced plastics

GB 2828-87 Sampling procedures and tables for lot-by-lot inspection by attributes (Apply to inspection of successive lots or batches)

GB 3854-83 Test method for hardness of reinforced plastics by means of Barcol impresser

GB 6952-86 Sanitary wares

GB 7191-87 Glass fiber reinforced plastic bathtubs

GB 9266-88 Determination of scrub resistance of film of architectural paints and coatings

GB/T 13891-92 Test methods of specular gloss for decorative building materials

JC 502-93 Test method for flushing function of ceramic closet pan

3 Definition

This standard uses the following definitions.

The number of pitting within the range of $\Phi 200$ mm does not exceed 2.

3.7

Scratches

The damage on the surface due to friction or the like.

3.7.1

Non-obvious scratches

In the range of 1 m^2 with the length $\times$ width not exceeding $50 \text{ mm} \times 0.1 \text{ mm}$, the number of scratches with a slight depth does not exceed 1.

3.8

Repair traces

The traces left on the surface due to repair.

3.8.1

Non-obvious repair traces

The surface repair is basically matched with the surroundings, with non-obvious difference in color.

3.9

Depression

The local sinking of the surface of the product.

3.9.1

Non-obvious depression

The number of depressions of not more than 1 mm^2 within the range of 1 mm^2 does not exceed 5.

3.10

Color difference

The difference of color of the same product or the same set of products.

3.11

Impurities

6.4.2.1 Measuring tool

Steel ruler with a length of 500 mm or 1000 mm; a feeler gauge with a precision of grade 2.

6.4.2.2 Measurement method

Place the steel ruler vertically on a flat surface in different directions of the product. Insert the feeler gauge into the gap between the steel ruler and the surface of the product. Record the thickness of the feeler gauge. Each product is measured 3 times.

6.4.2.3 Calculation of results

$$F = \frac{D}{L} \times 100 \dots\dots\dots (1)$$

Where:

F - Unevenness, %;

L - Measured length, mm;

D - Thickness measured by feeler gauge, mm.

Take the average of 3 data and record the maximum value, accurate to 0.01%.

6.4.3 Determination of Barcol hardness

According to GB 3854, the hardness tester's model is 934-1, which is carried out on the flat part of the cleaned face or the visible face of the product.

6.4.4 Test of load-bearing capacity

It is carried according to 3.4 of GB 7191-87.

6.4.5 Test of impact resistance

Take 3 points at the flat position at the bottom of the bathtub. The distance between each point is not less than 150 mm. Allow a steel ball which has a diameter of 30 mm (about 110 g) to freely fall from the height of 750 mm. If there is no crack at the point of impact, it is qualified.

6.4.6 Determination of water absorption

It is carried out according to GB 1462.

6.4.7 Determination of gel-coating thickness

6.4.7.1 Instrument

Reading microscope, which has a minimum division value of 0.02 mm.

6.4.7.2 Test methods

From each specimen, cut a test strip of about 50 mm x 4 mm perpendicular to the gel-coating layer. Put the test strip on the specimen platform of the microscope with the cutting surface upwards. Read the thickness of the gel-coating. Make two measurements for each test strip. The thickness of the gel-coating is expressed by the average of five specimens, accurate to 0.01 mm.

6.4.8 Determination of cleanability

It is carried out according to GB 9266. Remove the test plate after 10000 times of cleaning. Check the surface wear.

6.4.9 Test of hot water resistance

6.4.9.1 Instruments

Super constant temperature bath or constant temperature water bath with an accuracy of $\pm 2\text{ }^{\circ}\text{C}$.

6.4.9.2 Test methods

Put the specimen in a thermostatic bath at a water temperature of $80\text{ }^{\circ}\text{C} \pm 2\text{ }^{\circ}\text{C}$. After 100 h, take it out, to check whether the surface is cracked or bubbled.

6.4.10 Pollution resistance test

6.4.10.1 Reagent

Ethanol	3% hydrogen peroxide
Acetone	Tea
2% red mercury solution	Vinegar
2% iodine solution	Black liquid shoe polish
Gentian violet	Lipstick

6.4.10.2 Test method

Use the absorbent cotton to dip the substances as listed in 6.4.10.1, respectively. Place it on the specimen. After 24h, wipe off the pollutant. Use detergent to wash it clean and wipe it dry. Check whether the surface of the specimen has color change.

6.4.11 Test of flushing function

It is carried out according to JC 502.

7.3.2 Type inspection shall be sampled and judged according to Table 6.

Table 6 -- Sampling inspection requirements of type inspection

Sample size	Category B unqualified products AQL = 6.5		Category B unqualified products AQL = 10		Classification of nonconformances	
	Ac	Re	Ac	Re	Category B nonconformances	Category C nonconformances
3	0	2	0	2	Appearance quality, gloss, unevenness, Barcol hardness, gel-coating thickness,	Dimensional deviation,
3 (6)	1	2	1	2	impact resistance, load-bearing capacity, hot water resistance, flushing function	water absorption, cleanability, pollution resistance

8 Marking, packaging, transportation and storage

8.1 Marking

8.1.1 Product marking

At an eye-catching position on each product, it shall be attached a label which contains the name of the manufacturer, the product marking, the date of manufacture, the batch number of the production.

8.1.2 Package marking

On the outer packaging, there shall be a receipt and delivery marking, product marking, as well as the letter or graphical markings of quality grade, manufacturer name and address, gross weight, net weight, handle with care.

8.2 Packaging

The package shall be secure and use a shock pad. The product certificate and instruction manual shall be accompanied in the packaging box.

8.3 Transportation

8.3.1 The product shall be handled with care.

8.3.2 The product be prevented from heavy pressure, mechanical collision, strong vibration during transportation.

8.4 Storage

8.4.1 The stacking height of the bathtubs and the toilets shall not exceed four. The stacking height of the washbasin shall not exceed six.

8.4.2 Products shall be stored according to different varieties, specifications, colors, grades, batch numbers.

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