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**The technical specification for remanufacturing of
automotive components - Cylinder head**

汽车零部件再制造产品技术规范 气缸盖

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Attachment:**Number, name and date of implementation of 22 automotive industry standards**

No.	Standard number	Standard name	Number of standard replaced	Date of implementation
301	QC/T 727-2017	Instrument for automobile and motorcycle	QC/T 727-2007	2017-10-01
302	QC/T 803-2017	Oxygen sensor for automobile	QC/T 803.1-2008	2017-10-01
303	QC/T 1072-2017	Gear position sensor for automobiles		2017-10-01
304	QC/T 1073.1-2017	Accelerometers for automobiles - Part 1: Linear accelerometers		2017-10-01
305	QC/T 1074-2017	Technical specifications for automotive parts remanufacturing products		2017-10-01
306	QC/T 1075-2017	Technical conditions for metal honeycomb carrier of exhaust catalytic converter		2017-10-01
307	QC/T 777-2017	Technical conditions for electromagnetic fan clutch of automobile	QC/T 777-2007	2017-10-01
308	QC/T 1076-2017	Performance requirements and test methods for continuously variable transmission (CVT)		2017-10-01
309	QC/T 1077-2017	Terminology and definitions for classification of automatic control transmission for automobile		2017-10-01
310	QC/T 1078-2017	Advertising vehicle		2017-10-01
311	QC/T 1079-2017	Suction & delivery vehicle		2017-10-01
312	QC/T 1080-2017	Mobile loudspeaker for popularization of science		2017-10-01
313	QC/T 1081-2017	Electric power steering device for automobile		2017-10-01
314	QC/T 1082-2017	Motor for electric power steering device of automobile		2017-10-01
315	QC/T 1083-2017	Controller for electric power steering device of automobile		2017-10-01
316	QC/T 1084-2017	Sensor for electric power steering device of automobile		2017-10-01
317	QC/T 1085-2017	X-ray testing for light-alloy wheel of motorcycle		2017-10-01
318	QC/T 1086-2017	Technical conditions for range extenders for electric vehicles		2017-10-01

319	QC/T 1087-2017	Technical conditions for pure-electric city sanitation vehicle		2017-10-01
320	QC/T 1088-2017	Technical conditions for charge & discharge type motor controllers of electric vehicles		2017-10-01
321	QC/T 1091-2017	Technical conditions for air purification device of passenger car		2017-10-01
322	QC/T 740-2017	Seat assembly for passenger car	QC/T 740-2005	2017-10-01

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The technical specification for remanufacturing of automotive components - Cylinder head

1 Scope

This standard specifies the terms and definitions, dismantling, cleaning, classification, inspection and repair, exit-factory inspection requirements, and other requirements for the remanufacturing of automobile engine cylinder heads.

This standard is applicable to the remanufacturing of automobile engine cylinder heads. The remanufacturing of other motor vehicle cylinder heads may refer to this standard.

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 standard.

GB/T 26989 Automobile recovery - Terminology

GB/T 28675 Remanufacturing of automotive components - Disassembly

GB/T 28676 Remanufacturing of automotive components - Classification

GB/T 28677 Remanufacturing of automotive components - Cleaning

GB/T 28678 Remanufacturing of automotive components - Pre-delivery inspection

3 Terms and definitions

The terms and definitions, which are defined in GB/T 26989, apply to this standard.

4 Requirements for dismantling, cleaning, classification

4.1 Disassembly

4.1.1 The dismantling of the cylinder head shall comply with the provisions of GB/T 28675.

head. The surface of the combustion chamber can be processed and repaired, by grinding within the specified range, to meet the specified dimensional tolerance requirements; OR match the thickened original cylinder head product drawings or the cylinder head liner, which is specified by the enterprise, to restore its fit clearance. OR pre-treat the surface of the combustion chamber; repair it by adding materials such as spraying or electroplating; then perform grinding, to restore to the original cylinder head product drawings or the dimensional tolerance requirements, which are specified by the company.

5.5 Check all holes in the cylinder head. Carry out pretreatment on the damaged light hole. Repair it by cold welding and other methods, so as to meet the tolerance size requirements, which are specified by the original cylinder head product drawings or the company. For the damaged threaded hole, if the company's requirements allow it, it may use the enlarged threaded hole and the method of re-inserting the wire sleeve, to restore to the original cylinder head product drawings or the dimensional tolerance requirements, which are stipulated by the enterprise.

5.6 Check all parts of the cylinder head for carbon deposits, oil stains, etc. It can be cleaned with cleaning fluids, such as carbon deposit removal and oil removal; OR use high-pressure (cold or hot) water jets, to wash the cylinder head surface, bottom hole, oil passage, water passage and other parts, to remove dirt. For diesel engines, it can use pyrolysis method. For dirt that is hard to clean, it may use such repair methods, as surface shot blasting, local sandpaper grinding, etc., meanwhile prevent the secondary damage to the non-shot blasting surface.

6 Exit-factory inspection requirements

6.1 Each remanufactured cylinder head shall be subject to corresponding flaw detection and pressure testing, as well as inspection of key dimensions, in accordance with the technical requirements of the corresponding remanufactured product or original product drawings.

6.1.1 The surface-repaired remanufactured cylinder head shall be inspected, by fluorescent flaw detection, magnetic particle flaw detection and other flaw detection methods, to ensure that there are no cracks on the surface.

6.1.2 Each cylinder head shall be inspected for tightness, according to the technical requirements of the remanufactured product drawings.

6.1.3 The key dimensions (inner diameter of valve guide hole, depth of valve seat ring, etc.) shall be inspected; corresponding records shall be made.

6.2 Cleanliness testing is required after the cylinder head is machined, to meet relevant requirements.

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