

Translated English of Chinese Standard: QB/T4055.2-2011

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ICS 39.040.10

Classification: Y 11

Reference No.: 32178-2011



Light Industry Standard of the People's Republic of China

QB/T 4055.2-2011

Cermet casings of watches — Part 2: Carbide cermet casings

手表用金属陶瓷外观件

第 2 部分：碳化物金属陶瓷外观件

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Issued on May 18, 2011

Implemented on August 1, 2011

**Issued by: Ministry of Industry and Information Technology of the
People's Republic of China**

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Foreword

QB/T 4055 Cermet Casings of Watches has two parts:

- Part1: Oxide cermet casings;
- Part2: Carbide cermet casings.

This Part is the second part of QB/T 4055.

This Standard is proposed by China National Light Industry Council.

This Standard is under the jurisdiction of National Watch Standardization Center.

This Standard is drafted by organizations: Shenzhen FLYTA Precision Timer Manufacturing CO.LTD and FLYTA (Group) Holdings LTD.

This Standard is mainly drafted by: Zhang Na, Bao Xianyong, Yan Ming, Cui Xiaolong, and Guo Feng.

Introduction

Carbide cermet material is widely used in casings of watches because of its excellent wear resistance, it has greatly improve the product style and exterior quality of watch industry of our country. But this material differs from traditional metallic materials, the quality of this material has great influence in impact resistance and corrosion resistance of end-product watches, and it may cause skin allergy when wore by some customers.

In order to regulate the use of carbide cermet material in watch industry, and to take the essence and discard the dregs, it is necessary to make this product standard to unify technical requirements and marks, to make it rule-based for manufacturers and users, to improve the quality and market competitiveness of carbide cermet material, to promote carbide cermet material to be healthily-developed in watch market, and to protect interests of both manufacturers and consumers.

Cermet casings of watches — Part 2: Carbide cermet casings

1 Scope

This Part specifies technical requirements, testing methods, rules for inspection, packing, marking, transport and storage of carbide cermet watchcases and watch-bands of watches (known as casings for short hereafter).

This Standard applies to watch-cases and watch-bands made by carbide cermet material with tungsten (WC) and titanium (TiC) as main composition. Watch-cases and watch-bands made by carbide cermet material with other composition can also refer to this Part.

2 Normative references

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

GB/T 2828.1 Sampling procedures for inspection by attributes-Part1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection (GB/T 2828.1-2003, ISO 2859-1: 1991, IDT)

GB/T 2829 Sampling procedures and tables for periodic inspection by attributes (Apply to inspection of process stability)

GB/T 3489 Hard metals - Metallographic determination of porosity and uncombined carbon (GB/T 3489-1983, ISO 4505: 1978, EQV)

GB/T 4028 Timekeeping instruments - Symbolization of control positions (GB/T 4028-1994, ISO 3158: 1976, IDT)

GB/T 6569 Test method for flexural strength of monolithic ceramics (GB/T 6569-2006, ISO 14704: 2000, MOD)

GB/T 7997 Hard metals - Vickers hardness test (GB/T 7997-1987, ISO 3878: 1983, EQV)

GB/T 10700 Test methods for elastic moduli of fine ceramics - Bending method

GB/T 19719 Jewelry - Determination of the release of nickel - Method of spectrometry (GB/T 19719—2005, EN 1811: 1998, MOD)

A) When the product is discontinued more than one production cycle and is resumed production.

B) When new product is launched for production or old product transfers production.

C) When the product design, structure, processes, materials have significant changes or when the product transfers production.

D) When National Quality Supervision and Inspection agency calls for the type inspection.

6.3 Inspection of Nickel release

Nickel release shall be tested according to the predetermined methods in GB/T9719.

7 Marking, Packaging, Transportation, and Storage

7.1 Marking

7.1.1 Marking Requirements

If the exterior parts meet the requirements of Chapter 4, marking shall be conducted on a suitable location of the product or on the product certification, or on the product's instructions for use.

7.1.2 Marking Methods

Marking shall be composed of the code, the type of material and exterior parts of cermet material as follows:

$\underline{\text{C}}$ $\boxed{x_1}$ $\boxed{x_2}$

X_2 -- Cermet casing (Indicated by the first letter in English)

X_1 -- Cermet type (Represented by the chemical formula of the major component)

C -- Cermet material code

In which:

C: Cermet material code, cermet type of exterior parts shall be represented by C.

X₁: Type of Cermet material shall be represented by the chemical formula of the major component. Commonly used chemical formula of metal carbide cermet materials are shown in 3.2, 3.3.

X₂: Type of cermet casing, in which - "front circle" is represented by a "B" (bezel), "Watch Case (with front ring-structure containing pre-laps)" is represented by C (case), "Bracelet" is represented by L (link), and "strap" is represented by W (wristlet).

References and Original Chinese Documents

- [1] QB/T 4055.2-2011 Cermet casings of watches. Part 2: Carbide cermet casings.
<http://www.chinesestandard.net/Default.aspx?PDF-English-ID=QB/T%204055.2-2011>