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Replacing GB/T 6892-2005

Wrought aluminum and aluminum alloys extruded profiles for general engineering

一般工业用铝及铝合金挤压型材

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard replaces GB/T 6892-2006 “Wrought aluminum and aluminum alloys extruded profiles for general engineering”. As compared with GB/T 6892-2006, the main technical changes of this standard are as follows:

- DELETE the vehicle profiles;
- DELETE the original appendix A, Appendix B and Appendix C;
- ADD the 6008, 6360, 7021 alloy;
- ADD the H111 state of 2014, 2014A, 2024, and 6082 alloys;
- MODIFY the mechanical properties of 2017 alloy;
- ADD the 0 and H111 state of 5005 and 5005A alloy;
- ADD the T1 state of 6005 alloy;
- MODIFY the performance of 6005 and 6005A alloy under T5 state;
- ADD the T66 state of the 6063 and 6060 alloy;
- In respect of the profile mechanical property limit value of T4 state of 2A11 and 2A12 alloy, the T5 state of 6261 alloy, and the T6 state of 7A04 alloy, SPECIFY the maximum wall thickness of the applicable profile;
- ADD the surface treatment profiles of anodizing, anodizing + electrophoretic coating, powder spraying and liquid spraying.

This standard was proposed by China Nonferrous Metals Industry Association.

This standard shall be under the jurisdiction of the National Nonferrous Metals Standardization Committee (SAC/TC 243).

The responsible drafting organizations of this standard: Southwest Aluminum (Group) Co., Ltd., Nonferrous Metals Technology and Economic Research Institute, Northeast Light Alloy Co., Ltd., Guangdong Haomei Aluminum Co., Ltd., Guangdong Jianmei Aluminum Profile Factory (Group) Co., Ltd., Guangdong Xingfa Aluminum Co., Ltd., Longkou Jungle Aluminum Co., Ltd., Shandong YANCOHLA Light Alloy Co., Ltd., Northwest Aluminum Processing

Wrought aluminum and aluminum alloys extruded profiles for general engineering

1 Scope

This standard specifies the requirements, test methods, inspection rules and marking, packaging, transportation, storage and quality certificates and orders (or contracts) for wrought aluminum and aluminum alloys extruded profiles for general engineering.

This standard applies to wrought aluminum and aluminum alloys extruded profiles for general engineering (hereinafter referred to as profiles).

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) are applicable to this Standard.

GB/T 231 (All parts) Metallic materials - Brinell hardness test

GB/T 3190 Wrought aluminum and aluminum alloy - Chemical composition

GB/T 3199 Wrought aluminum and aluminum alloy products - Packing, marking, transporting and storing

GB/T 3246.1 Inspection method for structure of wrought aluminum and aluminum alloy products - Part 1: Inspection method for microstructure

GB/T 3246.2 Inspection method for structure of wrought aluminum and aluminum alloy products - Part 2: Inspection method for macrostructure

GB/T 6519 Process of ultrasonic inspection of wrought aluminum alloy products

GB/T 7999 Optical emission spectrometric analysis method of aluminum and aluminum alloys

GB/T 8013 (All parts) Anodic oxide coating and organic polymer coatings on aluminum and its alloys

GB/T 8170 Rules for rounding off for numerical values & expression and judgment of limiting values

GB/T 12966 The method of determining aluminum alloys conductivity using eddy current

GB/T 14846 Tolerances on dimensions and form of aluminum and aluminum alloy extruded profiles

GB/T 15970.7 Corrosion of metals and alloys - Stress corrosion testing - Part 7: Slow strain rate testing

GB/T 16865 Test pieces and method for tensile test for wrought aluminum and magnesium alloys products

GB/T 17432 Methods for sampling for analyzing the chemical composition of wrought aluminum and aluminum alloys

GB/T 20975 (All parts) Methods for chemical analysis of aluminum and aluminum alloys

GB/T 22639 Test method for exfoliation corrosion for wrought aluminum and aluminum alloys

GB/T 22640 Test method of C-ring sample to stress-corrosion cracking for wrought aluminum and aluminum alloys products

YS/T 730 Wood grain profiles of aluminum alloys used for architecture

YS/T 873 Specification of polishing coating on aluminum alloy

ISO 9223 Corrosion of metals and alloys - Corrosively of atmospheres - Classification, determination and estimation

3 Requirements

3.1 Product classification

3.1.1 Profiles are divided into two categories in accordance with their composition, as shown in Table 1.

Table 1 -- Profiles classification by composition

Classification by composition	Definition	Typical designation
Category I	1 x x x series, 3 x x x series, 5 x x x series, 6 x x x series and the 5 x x	1060, 1350, 1050A, 1100, 1200, 3A21, 3003, 3103, 5A02, 5A03, 5005, 5005A, 5051A, 5251,

Example 4:

The fixed length profile of yellow, film code GA40, 6063 designation, T5 state, cross-section code YST00010004, and length 4000 mm is marked as:

Profile yellow GA40 GB/T 6892-6063T5- YST00010004 × 4000

Example 5:

The fixed length profile of red, film code LB20, 6063 designation, T5 state, cross-section code YST00010004, and length 4000 mm is marked as:

Profile red LB20 GB/T 6892-6063T5- YST00010004 × 4000

Example 6:

The fixed length profile of green, film code LF4-65, 6063 designation, T5 state, cross-section code YST00010004, and length 4000 mm is marked as:

Profiles green LF4-65 GB/T 6892-6063T5- YST00010004 × 4000

3.2 Chemical composition

The profiles of designation 5051A, 6008, 6360, 6261, 6081, and 7178 shall comply with the requirements of Table 3, AND the chemical composition of other designations shall comply with GB/T 3190.

damage the internal structure of the profile that extruded by spider die or divergent die).

3.10.6 The depth of the coarse crystal ring shall be agreed upon by both the supplier and the purchaser, AND be indicated in the drawing or order (or contract).

3.11 Microstructure

The microstructure of the profile is not allowed to over-burn.

3.12 Film properties

As for the surface-treated profiles, the film performance shall comply with the requirements of Table 8.

		Pulverization degree		Grade 0				To be negotiated by supplier and purchaser		
		Discoloration degree		To be negotiated by supplier and purchaser						
	UV resistance		When the purchaser has requirement for the UV resistance (only applicable to the anodic oxidation tinted profiles), the supplier and the purchaser will negotiate the test conditions and the performance requirements, AND indicate it in the order (or contract).	When the purchaser has requirement for the UV resistance, the supplier and the purchaser will negotiate the test conditions and the performance requirements, AND indicate it in the order (or contract).						
	Natural weather fastness		When the purchaser has requirement for the natural weather fastness (only applicable to the anodic oxidation tinted profiles), the supplier and the purchaser will negotiate the test conditions and the performance requirements, AND indicate it in the order (or contract).	When the purchaser has requirement for the natural weather fastness, the supplier and the purchaser will negotiate the test conditions and the performance requirements, AND indicate it in the order (or contract).						
Appearance quality			The surface shall not have such defects as electric burn, oxide film peeling off, etc., which may affect use; BUT it is allowed for local film free within 80 mm to the profile end	The color and gloss shall be uniform and consistent. It is not allowed for such defects as wrinkle, blister, flow mark, pit, inclusion, clamminess, and film peeling off, etc. The specific appearance requirements may also be negotiated by the supplier and the purchaser though standard sample.				It is not allowed for such defects as excessive roughness, flow mark, blister, inclusion, depression, dark spot, pinhole, and scratch, etc., and any damage reaching to the metal base. The specific appearance requirements may also be negotiated by the supplier and the purchaser though standard sample.		
Color and color difference			The color shall be basically consistent with the color plate as negotiated between the supplier and the purchaser, OR otherwise be within the color range as limited by the upper limit color code and the lower limit color code as negotiated between the supplier and the purchaser. If the purchaser requires using the instrument method to determine the color, the allowable color difference shall be negotiated by the supplier and the purchaser.				The color shall be basically consistent with the color plate as negotiated between the supplier and the purchaser. When using the colorimeter for determination, the color difference between the single color film and the sample plate $\Delta E_{ab}^* \leq 1.5$, AND the color difference between the profiles of same batch (delivery batch) $\Delta E_{ab}^* \leq 1.5$.			
Abrasive	Falling sand test results		Abrasion coefficient $f \geq 300 \text{ g}/\mu\text{m}$	Sand	Sand	Sand	Sand	Abrasio	-	Abrasion coefficient $f \geq 1.6$

	thickness $\leq 5 \mu\text{m}$), the supplier and purchaser shall negotiate the performance requirements AND indicate in the order (or contract).				
Mass per unit area (surface density)	When the purchaser has requirements for mass per unit area (surface density), the supplier and purchaser shall negotiate the performance requirements AND indicate in the order (or contract).	-			
Sulphur dioxide wet atmosphere corrosion resistance	-	When the purchaser has requirements for sulphur dioxide wet atmosphere corrosion resistance, it shall be indicated in the order (or contract). After 24 cycles of sulphur dioxide wet atmosphere corrosion resistance tests, the film surface shall be free from color change or blistering (visual inspection), AND the film underneath single side penetration at both sides of the marking is $\leq 1 \text{ mm}$.			When the purchaser has requirements for sulphur dioxide wet atmosphere corrosion resistance, it shall be indicated in the order (or contract). After 24 cycles of sulphur dioxide wet atmosphere corrosion resistance tests, the film surface shall be free from color change or blistering (visual inspection), AND the film underneath single side penetration at both sides of the marking is $\leq 1 \text{ mm}$.
Solvent resistance	-	When the purchaser has requirements for solvent resistance, it shall be indicated in the order (or contract). AND the pencil hardness difference of the film before and after the film solvent resistance test shall be $\leq 1 \text{ H}$.	When the purchaser has requirements for solvent resistance, it shall be indicated in the order (or contract). AND the film shall be free from darkening or gloss reduction after the solvent resistance test: ≤ 5 gloss units. If using finger nail to scratch this film, it shall be free from obvious scratches.	-	When the purchaser has requirements for solvent resistance, it shall be indicated in the order (or contract). If using finger nail to scratch this film after the solvent resistance test, it shall be free from obvious scratches.

3.13 Appearance quality

3.13.1 The surface of the profile without surface treatment shall be clean and free from cracks and corrosive spots. The allowable depth of such defects on the profile surface such as the peeling, blister, indentation, damage, scratch, surface roughness, and local mechanical damage, etc., shall not exceed 8% of the nominal wall thickness of the corresponding location, not exceed 0.2 mm on the decorative surface, AND not exceed 0.5 mm on the non-decorative surface. The total area of the defects on the decorative surface shall not exceed 2% of the surface area of the profile, AND the total area of the defects on the non-decorative surface shall not exceed 5% of the surface area of the profile. As for the profile locations to be processed, the surface defect depth shall not exceed the processing margin. The surface of the profile allows the supplier to polish longitudinally along the profile to the smooth surface.

3.13.2 The appearance quality of the surface-treated profiles shall comply with the requirements of Table 8.

4 Test method

4.1 Chemical composition

4.1.1 The chemical composition analysis method shall comply with the provisions of GB/T 20975 or GB/T 7999, AND the arbitration analysis shall be in accordance with the method as specified in GB/T 20975.

4.1.2 As for the designation 5051A, 6008, 6360, 6261, 6081, 7178, only the element with value specification beyond the column “A1” and “other impurities” in Table 3 will be subjected to conventional chemical analysis. When it is suspected that the mass fraction of the unconventional analysis element exceeds the limit value of this standard, the manufacturer shall conduct analysis against these elements.

4.1.3 The “A1” contents shall be calculated using the method as specified in GB/T 3190; when calculating the “A1” content, the sum of the conventional analysis elements and non-conventional analysis elements of suspected excessive amount shall be used as the “total element content”.

4.1.4 The analysis values are judged through the rounding off & comparison method, the value rounding off shall be in accordance with the relevant provisions of GB/T 8170, AND the rounding off numerical place shall be in consistent with the limit numerical places as specified in Table 3 or GB/T 3190.

4.11 Film performance

The film performance test method shall be in accordance with the requirements of GB/T 8013.1 ~ GB/T 8013.3.

4.12 Appearance quality

The appearance quality of the profile without surface treatment shall be subjected to visual inspection; if it is difficult to determine the defect depth, it may be ground before measurement. As for the surface-treated profiles, the appearance quality inspection method shall be in accordance with the requirements of GB/T 8013.1 ~ GB/T 8013.3.

5 Inspection rules

5.1 Inspection and acceptance

5.1.1 The product shall be inspected by the supplier to ensure that the product quality complies with the requirements of this standard and the order (or contract), AND fill the quality certificate.

5.1.2 The purchaser shall inspect the products received in accordance with the provisions of this standard. When the inspection results are different from the provisions of this standard and the order (or contract), it shall propose to the supplier in written form, for settlement between the supplier and the purchaser through negotiation. As for the objection to the appearance quality and dimensional deviation, it shall be proposed within 1 month after receiving the product; as for the objection to other performances, it shall be proposed within 3 months after receiving the product. If arbitration is needed, it may entrust the unit which is recognized by both the supplier and the purchaser, AND the sampling shall be made together with the purchaser.

5.2 Batching

Products shall be submitted in batches for acceptance, AND each batch is composed of the products of same designation, same state, same dimension specification, and same film code and surface treatment technology.

5.3 Weighing

The product shall be weighed (unless otherwise agreed by both parties).

5.4 Test items

5.6.6 When the stress corrosion resistance of any samples is disqualified, this batch (or heat treatment furnace) is disqualified. However, it is allowed for the supplier to conduct repeated heat treatment, AND retake sample to test the room temperature tensile mechanical properties, conductivity and stress corrosion performance.

5.6.7 When the exfoliation corrosion resistance of any samples is disqualified, this batch (or heat treatment furnace) is disqualified. However, it is allowed for the supplier to conduct repeated heat treatment, AND retake sample to test the room temperature tensile mechanical properties, conductivity, stress corrosion performance, and exfoliation corrosion performance.

5.6.8 When the macrostructure of any sample is disqualified, it is judged as follows:

- a) If it is deemed as disqualified due to cracks, bright grain, non-metallic inclusions, foreign metal inclusions and white spots, primary crystal and oxide film and other metallurgical defects, this batch of profiles will be judged as disqualified. However, through negotiation between the supplier and the purchaser, the supplier may conduct test one by one, with the qualified products supplied.
- b) If it is deemed as disqualified due to lamination, shrinkage cavity, and rough crystal ring, it is allowed to cut one section from the extruded tail end of the profile for repeated test, until it is qualified; AND all the other profiles of this batch shall be subjected to the profile tail cutting test or test one by one based on the maximum length of the aforementioned defect distribution, with the qualified products supplied.
- c) If it is deemed as disqualified due to disqualified weld, it is allowed to cut one section from the extruded front end of the hollow profile for repeated test, until it is qualified; AND all the other hollow profiles of this batch shall be subjected to the profile head cutting test or test one by one based on the maximum length of the aforementioned defect distribution, with the qualified products supplied.

5.6.9 When the microstructure of any sample is disqualified, the profiles of this batch (or heat treatment furnace) are disqualified.

5.6.10 When the film performance of any of the profiles is disqualified, it is judged in accordance with GB/T 8013.1 ~ GB/T 8013.3.

5.6.11 When the appearance quality of any profile is disqualified, this piece of profile is judged as disqualified.

Appendix A

(Informative)

Surface treatment profiles selection guide

A.1 Overview

Surface-treated profile film is mainly for protection and decoration. The performance degradation of the film in the environment of use shall not lead to product corrosion or affect the product appearance. Therefore, before selecting the film type, it shall firstly determine the type of environment in the environment of use. The type of film selected for different environmental types may be different. There are many kinds of classification methods for environmental types in domestic and foreign related standards. For example, GB/T 15957 divides atmospheric types into four categories: industrial atmosphere, urban atmosphere, ocean atmosphere and rural atmosphere; AND the wet environment, ordinary environment, and dry environment based on humidity. ISO 9223 divides the environment into 6 categories of outdoor environment and indoor environment, as detailed in Table A.1.

Table A.1 -- Environment types

Corrosion grade	Corrosion degree	Environment conditions	
		Outdoor	Indoor
C1	Very low	Cold or dry atmospheric environment of very low pollution and wet duration, such as some deserts, Arctic and Antarctic centers	The heat supplied space of low pollution and low relative humidity, such as office, shop, school, hotel, museum
C2	Low	Low-polluted ($\text{SO}_2 < 5 \mu\text{g}/\text{m}^3$) temperate environment, such as rural, small towns; Cold or dry atmospheric environment of short wet duration, such as desert, sub-Arctic regions	Non-heat supplied space of high temperature and relative humidity change, low pollution, and less condensation, such as warehouse, gymnasium
C3	Medium	Medium-polluted ($\text{SO}_2: 5 \mu\text{g}/\text{m}^3 \sim 30 \text{g}/\text{m}^3$) temperate environment OR some areas slightly affected by chloride, such as urban areas, low-chloride accumulated coastal areas, low-polluted tropical and subtropical regions	The space with medium frequency condensation and medium pollution generated in the production process, such as food processing plants, laundries, wineries, milk factory
C4	High	High-polluted ($\text{SO}_2: 30 \mu\text{g}/\text{m}^3 \sim 90 \text{g}/\text{m}^3$) temperate environment OR some areas affected by chloride,	The space with very high frequency condensation and high pollution generated in the production process,

serious in the high-polluted industrial areas, AND the high temperature and dry-damp alternated climatic environment may also accelerate its performance degradation. Therefore, the industrial wet environment and the urban wet environment of high pollution and high temperature difference shall select the anodic oxide film of thick film grade; AND the industrial dry environment and the urban dry environment of high pollution and high temperature difference shall select the heat sealing anodic oxide film of thick film grade.

A.2.2.2 Anodic oxidation and electrophoretic coating composite film

Anodic oxidation and electrophoretic coating composite film is composed of the anodic oxide film and organic polymer film. Due to the presence of aluminum anodic oxide film, it is neither susceptible to damage or the mechanical damage from the metal base, nor susceptible to generate film underneath filiform corrosion. The industrial environment and the urban environment of high pollution shall select the anodic oxidation and electrophoretic coating composite film of high quality grade.

A.2.2.3 Spraying film

Spraying film may have performance degradation due to the existence of the acidic substance in the air when the surface is wet, AND it is especially serious in the high-polluted industrial areas. Long time in the hot and humid environment will accelerate the penetration of water and harmful ions into the film. Mechanical damage also accelerates the erosion of the film in industrial and urban environments. Therefore, industrial and urban wet tropical environment of serious pollution shall select the spraying film of high quality grade, such as the high weather fastness powder spraying film or fluorocarbon paint spraying film.

A.2.3 Marine environment

A.2.3.1 Anodic oxide film

In the environment conditions absence of acidic pollution, the anodic oxide film has good salt water resistance. However, if the acidic environment conditions lead to local dissolution of the film, the presence of chloride ions will accelerate the erosion of the aluminum substrate. The marine environment of high temperature difference shall select the anodic oxide film of high film thickness.

A.2.3.2 Anodic oxidation and electrophoretic coating composite film

Anodic oxidation and electrophoretic coating composite film is composed of the anodic oxide film and organic polymer film. Due to the presence of aluminum anodic oxide film, it is neither susceptible to damage or the mechanical damage from the metal base, nor susceptible to generate film

The information to be contained in fluorocarbon paint spraying profile order (or contract) is as shown in Table B.6.

Table B.6 -- Information to be contained in fluorocarbon paint spraying profile order (or contract)

Standard number	GB/T 6892-2015		Contract number	
Order unit			Order weight / kg	
Designation		State	Section code	
Surface treatment category	Fluorocarbon paint spraying	Film code		
Color	Color; Color standard sample number:			
Length per piece	1 <input type="checkbox"/> Fixed length mm; 2 <input type="checkbox"/> Non-fixed length			
Test items as negotiated by supplier and purchaser	Curved surface clearance	1 <input type="checkbox"/> Inspection as per standard; 2 <input type="checkbox"/> Negotiation requirements:		
	Plane clearance:	1 <input type="checkbox"/> High precision level; 2 <input type="checkbox"/> ultrahigh precision level; 3 <input type="checkbox"/> Negotiation requirements:		
	Longitudinal bending degree	1 <input type="checkbox"/> High precision level; 2 <input type="checkbox"/> ultrahigh precision level; 3 <input type="checkbox"/> Negotiation requirements:		
	Longitudinal waviness	1 <input type="checkbox"/> High precision level; 2 <input type="checkbox"/> ultrahigh precision level; 3 <input type="checkbox"/> Negotiation requirements:		
	Longitudinal side curvature	Negotiation requirements by the supplier and the purchaser:		
	Twisting degree	1 <input type="checkbox"/> High precision level; 2 <input type="checkbox"/> ultrahigh precision level; 3 <input type="checkbox"/> Negotiation requirements:		
	End cut slope	1 <input type="checkbox"/> High precision level; 2 <input type="checkbox"/> ultrahigh precision level; 3 <input type="checkbox"/> Negotiation requirements:		
	Mechanical properties of profiles with wall thickness exceeding the requirements of Table 4		1 <input type="checkbox"/> Supplied with measured results; 2 <input type="checkbox"/> Negotiation requirements:	
	Abrasive resistance	1 <input type="checkbox"/> It is required after negotiation to test it in accordance with GB/T 8013.3; 2 <input type="checkbox"/> It is required after negotiation to test it by other methods, as follows:		
	Salt mist corrosion resistance	1 <input type="checkbox"/> It is required after negotiation to test it in accordance with GB/T 8013.3; 2 <input type="checkbox"/> It is required after negotiation to test it by other methods, as follows:		
	Hydrochloric acid resistance	1 <input type="checkbox"/> It is required after negotiation to test it in accordance with GB/T 8013.3; 2 <input type="checkbox"/> It is required after negotiation to test it by other methods, as follows:		
	Damp heat resistance	1 <input type="checkbox"/> It is required after negotiation to test it in accordance with GB/T 8013.3; 2 <input type="checkbox"/> It is required after negotiation to test it by other methods, as follows:		
	Nitric acid resistance	1 <input type="checkbox"/> It is required after negotiation to test it in accordance with GB/T 8013.3; 2 <input type="checkbox"/> It is required after negotiation to test it by other methods, as follows:		
Alkaline resistance	1 <input type="checkbox"/> It is required after negotiation to test it in accordance with GB/T 8013.3; 2 <input type="checkbox"/> It is required after negotiation to test it by other methods, as follows:			

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