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**INDUSTRY STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

CJ/T 108-1999

Replacing CJ/T 108-1999

**Polyethylene/aluminum/polyethylene composite pressure pipe
(overlap-welded)
(English Translation)**

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Foreword

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

This standard replaces CJ/T 108-1999 "aluminum-plastic composite pressure pipe (lap welding)", compared with CJ/T 108-1999, the main technical changes as follows.

--- Added a heat-resistant polyethylene (PE-RT) aluminum-plastic composite pressure pipe and related requirements (see 4.2.1 and Chapter 6);

--- Increased nominal diameter of 18mm aluminum-plastic composite pressure pipe and related requirements (see Chapter 6);

--- Gas-plastic composite pressure pipe with the ambient temperature from -20 °C ~ 40 °C to -20 °C ~ 60 °C (see 6.1,1999 version

Table 1);

--- Increasing the peel force requirements of the ring, instead of interlayer adhesive strength requirements (see 6.5.1, 1999 version 5.6);

--- Increased diameter test requirements (see 6.5.2);

--- Pipe specifications grouped, modify hydrostatic test conditions (see 6.7,1999 version

5.9);

--- Increased system suitability test requirements (see 6.12).

This standard proposed by the Ministry of Housing and Urban Standard and Design Institute.

This standard by the Ministry of Housing and Urban Water Supply and Drainage Standardization Technical Committee building centralized.

This standard was drafted. Rifeng Enterprise Group Co., Ltd., the national ceramic and plumbing products Quality Supervision and Inspection Center, Zhejiang double Lin Machinery Co., Ltd., Nichiren Technology Co., Ltd., Guangdong Liansu Technology Industry Co., Ltd., Nichiro Building Materials (Tianjin) Co., Ltd.

1 Scope

This standard specifies the aluminum-plastic composite pressure pipe (lap welding) terms and definitions, symbols, structure, classification and marking, materials, requirements, test side Law, inspection rules, marking, packaging, transportation and storage.

This standard applies to the pressure fluid (hot and cold water, gas, compressed air and special fluids, etc.) of the aluminum-plastic composite pressure pipe, does not apply to aluminum tubes Plastic clamped aluminum tubing without welding or adhesive layer compounding and butt-welded aluminum-plastic composite pressure tubing.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version applies to this article Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 228.1 Tensile testing of metallic materials - Part 1. Room temperature test method
GB/T 1033.1 Determination of plastic non-foam density - Part 1. Immersion, liquid pyknometer and titration
GB/T 1040.2 Determination of tensile properties of plastics - Part 2. Test conditions for molding and extrusion of plastics
GB/T 2035 Plastics Terms and Definitions
GB/T 2828.1 Sampling procedures for inspection - Part 1. Sampling inspection by batch acceptance inspection by acceptance quality limit (AQL)
GB/T 2829 cycle test count sampling procedures and tables (for the stability of the test process)
GB/T 2918 plastic sample conditioning and testing of the standard environment
GB/T 3682 Thermoplastics melt mass flow rate and melt volume flow rate determination
GB/T 4217 thermoplastic pipe delivery fluid nominal diameter and nominal pressure
Thermoplastics pipes for the conveyance of fluids - Pressure resistance test methods
Plastics piping systems - Determination of dimensions of plastic parts
GB 15558.1 Buried polyethylene (PE) piping systems for gas - Part 1. Tubing
Fluidized plastic pipes - Hydraulic

instantaneous burst and pressure test methods GB/T 17219 drinking water distribution equipment and protective materials safety evaluation criteria Test method for thermal stability of polyethylene pipe and fittings GB/T 18252 plastic pipe system using extrapolation to determine the long-term hydrostatic strength of thermoplastic materials in the form of pipe GB/T 18474 cross-linked polyethylene (PE-X) pipe and tube cross-linked degree of test methods GB/T 18997.2 aluminum-plastic composite pressure pipe Part 2. aluminum pipe butt-welded aluminum-plastic pipe

3.1 Terms and definitions

GB/T 2035 established and the following terms and definitions apply to this document.

3.1.1

Aluminum-plastic composite pressure pipe polyethylene-aluminum composite pipe an embedded metal layer is a welded aluminum alloy tube, the inner and outer layers are coextruded polyethylene plastic, the layers are formed by the hot melt glue layer Co-management.