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**CJ**

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

**CJ/T 110-2018**

Replacing CJ/T 110-2000

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**Socket type pipe joint  
(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 is a revision of the CJ/T 110-2000 "Plug-in Fittings". Major technical changes compared to CJ/T 110-2000 as follows.

- Increased material requirements for gaskets and locking sleeves (see 4.1);
- Change the "Parts Machining" section to "Geometry" and delete the processing aspects (see 5.2);
- Modify "connection reliability" to "stretch resistance" (see 5.3.1);
- Change the "sealing" to "air tightness" and reduce the test pressure from 1.0MPa to 0.6MPa, in line with other standards (see 5.3.2);
- Change the "static internal pressure strength" to "hydrostatic strength" (see 5.3.3);
- Modify "hydraulic burst" to "hydraulic burst" (see 5.3.4);
- Increase the internal pressure of the thermal cycle test from  $(690 \pm 69)$  kPa to 1.0 MPa, and the alternating hot and cold temperature changes from 15 ° C to 82 ° C.  
20 ° C ~ 90 ° C, the number of cycles increased from 1000 to 5000 times (see 5.3.5);
- Change the thermal cycle test method to comply with the provisions of GB/T 18991-2003 (see 6.8);
- Removed the structure of the pipe joint 2 (see Appendix A);
- Change Appendix B from a normative appendix to an informative appendix;
- Removed Appendix C.

This standard was proposed by the Institute of Standardization of the Ministry of Housing and Urban-Rural Development.

This standard is under the jurisdiction of the Building Water Supply and Drainage Standardization Technical Committee of the Ministry of Housing and Urban-Rural Development.

This standard was drafted. Zhejiang Zhongyuan Maple Leaf Pipe Co., Ltd., Guangzhou Maple Leaf Pipe Co., Ltd., Guizhou Maple Leaf Pipe Co., Ltd., Zhejiang Jiang Jiu hao Technology Development Co., Ltd.

## 1 Scope

This standard specifies the product classification, structure, marking, materials, and requirements for socket-type pipe joints for construction pipeline engineering (hereinafter referred to as "pipe joints").

Requirements, test methods, inspection rules, marking, packaging, transportation and storage.

This standard applies to pipe joints of 40mm~75mm aluminum-plastic composite pipe and plastic pipe system.

## 2 Normative references

The following documents are indispensable for the application of this document. 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 196-2003 basic thread basic size GB/T 197-2018 Ordinary thread tolerance GB/T 1176 cast copper and copper alloy GB/T 1184-1996 Shape and position tolerances without tolerance values GB/T 1220 stainless steel rod GB/T 1804-2000 General tolerances and tolerances for linear and angular dimensions without tolerances GB/T 2100 general corrosion resistant steel castings GB/T 2828.1. Sampling procedures for sampling by sampling - Part 1 . Batch-to-batch sampling plan, searched by AQL GB/T 5231 processing copper and copper alloy grades and chemical composition GB/T 6111 Determination of internal pressure resistance of thermoplastic piping systems for fluid transport GB/T 7306.1 55° sealed pipe threads - Part 1. Cylindrical internal and conical external threads GB/T 7307-2001 55° unsealed pipe thread GB/T 11352 casting carbon steel for general engineering GB/T 15560-1995 Hydraulic instantaneous bursting and pressure test method for plastic pipes for fluid transportation Pull-out test of GB/T 15820 polyethylene pressure pipe and pipe fitting GB/T 17219 Safety evaluation criteria for drinking water distribution equipment and protective materials GB/T 18991-2003 Thermoplastic pipes and fittings for hot and cold water systems GB/T 18997.2-2003 Aluminium-plastic composite pressure pipes - Part 2. Aluminium tube butt welded aluminum-plastic tube HG/T 2811 Rotary shaft lip seal rubber material

### **3.1 Classification**

#### **3.1.1**

Pipe joints can be divided into external types.

- a) straight through, code S;
- b) elbow, code L;
- c) tee, code T;
- d) Plug, code D.