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

CJ/T 137-2001

Replacing CJ/T 137-2001

**Malleable iron threaded fittings of lining plastic for water supply
(English Translation)**

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Table of Contents

- Foreword
- 1 Scope
- 2 Normative references
- 3 Terms and definitions
- 4 Product Classification and Marking
- 4.1 Classification

Foreword

This standard is CJ/T 137-2001 "water supply plastic lined malleable cast iron pipe," the amendment referred to the Japanese JPFMP003-2003 "Spiral pipe-end corrosion-proof pipe fittings for water supply lining steel pipe", JPFMP005-2004 "Heat-resistant rigid PVC-lined steel pipe screw Rotary pipe end corrosion of pipe fittings "and the relevant domestic standards, the main changes are as follows.

- Increase the plastic pipe fittings and other terms and definitions;
- Modify the classification of plastic pipe fittings and marking;
- Modify the relevant dimensions of the pipe fitting core;
- Increase the plastic lining bonding strength requirements;
- Modify the interface corrosion resistance requirements and test parameters;
- Modify the resistance to thermal cycling performance requirements and test parameters;
- Modify the factory inspection and type inspection sampling method.

This standard Appendix A, Appendix B and Appendix C are normative appendix.

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 Products Standardization Technical Committee.

This standard editor unit. China Construction Metal Structure Association Water Supply and Drainage Equipment Branch.

This standard unit. Tianjin Leader Steel Pipe Co., Ltd., Shanghai Texaco water purification Pipe Manufacturing Co., Ltd., Hangzhou pure source of steel-plastic pipe Limited company.

1 Scope

This standard specifies the water supply plastic lined malleable iron pipe fittings (hereinafter referred to lined plastic pipe fittings) product classification and marking, materials, requirements, test side Law, inspection rules, marking, packaging, transportation and storage.

This standard applies to connect to the water lining (coated) plastic pipe, the working pressure is not greater than 1.6MPa, the nominal size of not more than DN150 lined plastic Pipe fittings.

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. All dated references, which are subsequently owned (Not including errata content) or revisions do not apply to this standard, however, encouraged to reach an agreement in accordance with this standard aspects of research Whether you can use the latest version of these files. For undated references, the latest version applies to this standard.

GB/T 241 metal tube hydraulic test method Malleable cast iron pipe fittings GB/T 7306.2 55 ° sealing pipe threads - Part 2. Female and female conical taper threads GB/T 17219 drinking water distribution equipment and protective materials safety evaluation criteria HG/T 3091 to, drainage pipe seals rubber material HG/T 3097 110 °C hot water pipe sealing ring rubber material

3 Terms and definitions

The following terms and definitions apply to this standard.

Lined plastic pipe fittings an injection molding process is used to line the malleable cast iron pipe fittings with a plastic core pipe fitting which is made up of an interface core and a plastic lining.

Lined plastic pipe body Malleable cast iron pipe before injection molding.

Interface core

Plastic core and lining (coated) plastic pipe nozzle connection and prevent the pipe end of the water corrosion sites.

Lining plastic layer Affixed to the plastic core plastic pipe body and prevent the inner surface of the water corrosion parts.

4.1 Classification

4.1.1

lined plastic pipe according to the structure form is divided into interface core with and without thread two, see Figure 1.