

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

CJ/T 177-2002

**Work coupling type cast iron pipe and fittings for building
drainage**

(English Translation)

Issued on: January 14, 2003

Implemented on: June 1, 2003

**Issued by: Ministry of Housing and Urban-Rural Development of the
People's Republic of China**

Table of Contents

Foreword

1 Scope

2 Normative references

3 Terms

Foreword

This standard is equivalent to the international standard of ISO 6594:1995 "cast iron drain pipe and fittings". In the development of this standard, full consideration of production the standard size of the product caliber should conform to the regulations of China's metrology law, and the metric size standard should be uniformly adopted to facilitate other drainage pipes with national standards.

(such as PVC-U pipe, galvanized pipe, etc.) are connected to ensure the quality of the project and avoid leakage and water seepage due to different pipe sizes.

According to the actual situation in China, this standard has made clear positive and negative tolerance standards for pipe outer diameter and pipe wall thickness. In the matching fittings, it is convenient to form a natural slope when the horizontal pipe is installed, and the angles of the T-type three-way, the TY-type three-way and the T-shaped four-way are uniformly defined. Increase work Standards for pipe fittings such as load-bearing short tubes and duck feet supporting elbows are required for installation. Increase the thickness of the inner and outer coatings and coatings of straight pipes and pipe fittings begging. Increase the standard requirements for materials for stainless steel clamps and reinforcement clamps.

The chemical composition, dimensional tolerance, tensile strength and water pressure resistance of the clamped cast iron pipe and pipe fitting materials for building drainage prepared by this standard the technical requirements and test methods for performance meet or exceed the ISO 6594:1995 "cast iron drain pipe and fittings" standard. Taking into account the product the actual situation of matching, marketing and engineering user installation requirements has only been modified for a few sizes.

This standard was proposed by the Institute of Standards and Ratings of the Ministry of Construction.

This standard is under the jurisdiction of the Ministry of Construction Water Supply and Drainage Product Standardization Technical Committee.

This standard consists of Guangzhou Xinhong Electromechanical Equipment Co., Ltd.,

Guangzhou Design Institute, Shanghai Hubiao Engineering Construction Consulting Co., Ltd., Zhongyuan the National Engineering Design and Research Institute is responsible for drafting.

1 Scope

This standard specifies the dimensions, shape and weight, requirements, test methods, inspection rules and standards for clamped cast iron pipes and fittings for building drainage.

Certificate, packaging, transportation, storage and quality certificate.

This standard is applicable to DN50~DN300 clamped cast iron pipe and fittings for building drainage (hereinafter referred to as straight pipe and pipe fittings), the scope of use for. building drainage wastewater and sewage pipelines; building drainage rainwater pipelines; building drainage ventilation pipelines.

2 Normative references

The terms in the following documents become the terms of this standard by reference to this standard. All dated references, followed by all Modifications (not including errata content) or revisions do not apply to this standard, however, parties to agreements based on this standard are encouraged to study is it possible to use the latest version of these files? For undated references, the latest edition applies to this standard.

GB/T 223.2-1981 Determination of sulfur content in steel and alloys GB/T 223.3-1988 Methods for chemical analysis of steels and alloys - Determination of phosphorus content by dianipyry methane phosphomolybdic acid gravimetric method GB/T 228-1987 Metal tensile test method GB/T 230-1991 Metal Rockwell hardness test method GB/T 232-1999 Metal material bending test method GB/T 246-1982 Metal tube flattening test method GB/T 528-1992 Determination of tensile properties of vulcanized rubber and thermoplastic rubber GB/T 531-1992 Rubber Shore A hardness test method GB/T 708-1988 Size, shape, weight and tolerance of cold rolled steel sheets and strips GB/T 1682-1994 Determination of low temperature brittleness of vulcanized rubbers GB/T 1683-1981 Determination of constant deformation compression set of vulcanized rubber GB/T 1685-1992 Determination of compressive stress relaxation of vulcanized rubber at normal temperature and high temperature GB/T 1690-1992 Test method for liquid resistance of vulcanized rubber GB 3280-1992 stainless steel cold rolled steel plate standard GB/T 3512-1983 Rubber hot air aging test GB 4334.1~4334.6-2000 stainless steel corrosion test method HG/T 3091-1998 Rubber sealing ring rubber for water supply and drainage pipes

3 Terms

Centrifugal casting process Use horizontal rotary centrifugal casting technology.

Machine sand casting process the use of mechanical equipment to control the casting technology of injection pressure or machine pressure sand.