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

FZ/T 91004-2012

Replacing FZ/T 91004-1994

**Technical specification of the rust prevention in process and
for products**

工序间防锈和成品防锈技术规程 清晰版

(English Translation)

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Foreword

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

Instead of the standard FZ/T 91004-1994 "inter-process rust and rust finished technical regulations." this standard is the technical content compared with FZ/T 91004-1994 main differences are as follows.

--- 3.1.6 original "should meet the quality standards of the Ministry of Petroleum and Chemical provisions" to "shall comply with the relevant quality standards petrochemical industry Regulations and environmental requirements ";

--- 3.3.2 Where it pickling of parts, the original "must be neutralized, especially with the bore of parts and castings, powder metallurgy Parts, but also a timely manner. Parts treated immediately immersed in boiling oil and cook 10min or more, so that the pores between the acid residue row in addition to infiltrate the oil, so as not to rust after a long time. "To" and the process can be carried out in accordance with needs. Parts can be treated according to need for legislation that is immersed in boiling oil and cook over 10min to make acid residue and penetrate the pores between the exclusion of oil to avoid rust after a long time ";

--- 3.3.3 original "shall" to "may be needed in";

Use --- Table 1 metal cleaning agent bar Cancel "metal cleaning agent formulated into an aqueous solution of 3% to 5%, directly to clean metal Surface "content; scope rust water column point 2 Cancel" rust of more than six months "content; rust oil dehydration column so Method Cancel "rust period of one month or more" content;

--- Table 1, the use of VCI powders, tablets, liquid, oil and rust in the table space law 2 original "restrict the use of press GB/T 14188-1993 provisions in 3.3 "to" limit the use of press GB/T 14188-2008 4.4 provisions ";

--- Table 2. Use subdural anti-rust oil column of the original "120 solvent gasoline additive dilution, the solvent has evaporated, leaving a layer of the dura mater" change to "can be diluted"; use rust grease bar former "gasoline additive solvent dilution" to "may be diluted";

--- 5.5.1 original "press FZ/T 90001-1991 provisions 9.3.1 and 9.3.2 of execution" to "press FZ/T 90001-2006 in the implementation of the provisions of 8.3 ";

--- Table 3 "General moisture, water" column to cancel.

The standard proposed by China Textile Industry Association.

This standard by the National Standardization Technical Committee Textile machinery and accessories (SAC/TC215) centralized.

This standard was drafted. Shanghai Textile Machinery Co., Ltd., Branch Yuci Jingwei Textile Machinery Company Limited, Qingdao Hongda Textile Weaving Machinery Co., Ltd., Shanghai Liang Textile Textile Machinery and Special Parts Company Limited.

1 Scope

This standard specifies the technical specification for textile machinery, equipment industry, the production process and finished rust rust.

This standard applies to textile machinery, equipment rust rust and finished products between processes.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version suitable for use herein Member. For undated references, the latest edition (including any amendments) applies to this document.

GB/T 13125-2009 machinery products damp heat protective packaging methods of GB/T 14188-2008 General VCI packaging material selection FZ/T 90001-2006 Textile machinery Packaging JB/T 6977-1993 Mechanical Products rust treatment before clean technical conditions 3-step rust

3.1 General requirements

3.1.1

The production process should be civilized and tidy.

3.1.2

parts store site should prevent moisture intrusion and corrosive gases, to prevent dirt adhering to the parts, rust was found in time.

3.1.3

Where the storage part should provide rust deadline, and regular sampling inventory parts rust situation. Rusty parts should be rust, after passing Anti-rust treatment.

3.1.4

parts inventory should follow the principle of first in first out storage by the library.

General Procedure for inter-process rust 3.1.5. washing, drying (or dehydration), rust.

3.1.6

choice of cutting fluid, anti-rust agents, cleaning agents, rust-proof material shall comply with the desiccant petrochemical industry regulations and quality standards Environmental requirements.

3.2 Rust machining requirements

3.2.1

Select cutting fluids should be consistent with rust, cooling, lubrication, cleaning and so on four aspects of technological requirements, promote the use of water-based cutting fluid to reach Purpose cleaning process. Rust period shall meet the requirements of the process.

3.2.2

machined parts should be promptly after anti-rust treatment. Finished machined parts should be washed and dried (or dehydration), Rust.

Rust treatment 3.3 Other processing steps between

3.3.1 Where a surface-treated parts should be the residue, clean, and the inner surface of the hole may be left to acid, alkali remnants. No plating section the parts should be promptly dried or dehydrated, and then the anti-rust treatment.

3.3.2 Where it pickling of parts and processes can be carried out in accordance with needs. The treated parts can be immersed in boiling oil and cook according to immediate needs 10min or more, so that the acid residue and penetrate the pores between the exclusion of oil to avoid rust after a long time.

3.3.3 Where the heat-treated parts as needed after removal of trace residues of salt and oil in a timely manner as required for parts rust treatment.