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Steel nails

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(English Translation)

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Foreword

6.5.2,6.5.3,6.6 this standard are mandatory, others are recommended.

The standard proposed by China National Light Industry Council.

This standard by the National Hardware Standardization Technical Committee (SAC/TC174) centralized.

This standard by the Beijing Darui Hing nail Co., Ltd. is responsible for drafting by Beijing Xing Delta nail industry limited liability company, Shandong Oriental Cherry Hardware Group Participate Ltd., Shanxi Yuci lofty Wire Products Co., Hai Rui Shanxi Hardware Industry Co., Ltd. drafted.

1 Scope

This standard specifies the terms and definitions nail, classification, marking, requirements, test methods, inspection rules, packaging, labeling, transportation and storage.

This standard applies to hand tools, power tools and hammering nails with a nail struck with. But the striking power tool connected with the nail timber Materials and methods not provided.

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 191 Packaging - Pictorial signs GB/T 228 metal materials at room temperature tensile test method GB/T 230.1-2004 Metallic Rockwell hardness test - Part 1. Test methods (A, B,

C, D, E, F, G, H, K, N, T scale) GB/T 342-1997 cold drawn round, square steel, hexagonal wire size, shape, weight and tolerance GB/T 701 low carbon steel hot rods GB/T 1216 outside micrometer GB/T 2828.1-2003 Sampling procedures for inspection - Part 1. by acceptance quality limit (AQL) retrieval batch test sample plan GB/T 2973 Zinc Coating quality test methods GB/T 4232 with stainless steel wire cold upsetting GB/T 4354 quality carbon steel hot rod GB/T 5267.1 fasteners plating layer GB/T 6311 Wide Range dial GB/T 13912 Metallic coatings Steel parts hot-dip galvanized layer of technical requirements and test methods GB/T 21389 cursor, with table and several Caliper JB/T 8928 steel parts galvanized machinery YB/T 5294 general purpose low carbon steel wire YB/T 5303 quality carbon structural steel JJF1070-2005 prepackaged goods measured net content inspection rules JJG33 universal point scale test procedures

3 Terms and Definitions

The following terms and definitions apply to this document.

Nail nailhead

Big nail on the head body.

Shank nailshank

Rod-shaped portion of the nail body.

Nail tip nailpoint

The tip of the nail body.

Curvature straightness Within the entire length of the nail, the maximum value of bending deformation.

Eccentricity headdeviation Nail shank off-center from the center line.

The power tool hit with nail powerdrivennails Plastic, paper tape, wire and nail adhesive and other materials will link up to meet the power tool or automated equipment hit the connecting member within the nail.

Category 4

In accordance with the nail into the use of hand tools and power tool with a thump struck with nail categories. Depending on the shape or intended use, hand Hammering nails into dynamic tools with common nails (see Appendix A), flooring nails (see Appendix B), concrete nails (see Appendix C), pallet nails (see Appendix D), Drum head staples (see Appendix E), roofing nails (see Appendix F), plasterboard nail (see Appendix G) and double cap screw (see Appendix H); hitting with power tool Pinning is divided into ordinary volumes nails with a nail (see Appendix I), plastic nails with a nail (see Appendix J), felt Vol nails with a nail (see Appendix K), the paper discharge connecting nail nails (See Appendix L), steel

row nails with nail connection (see Appendix M) and the T-shaped head plastic nails (see Appendix N).

5.1 Shape

Pinning generally consists of the nut, shank and sharp nails three parts. Nail shape mark in accordance with Table 1, Table 2 should be the shape of the shank mark, nail tip Shape in accordance with Table 3 mark.

Table 1 nail shape

Nail shape symbol shape (for example) A pocket cap Cup-shaped cap B C C-shaped cap D D-shaped cap Drum head shaped cap G

Table 1 (continued)

Nail shape symbol shape (for example) Flat-shaped hat P H-shaped pattern cap Q spherical cap T-shaped hat T Round table cap Y Conical cap Z

Table 2 Shank shape

Shank shape symbol shape (for example) Square rod F the ring-shaped lever HW Helical-shaped rod LX Chute-bar XC AeroBars Y Crimped-bar YH Straight slotted shaft ZC

Table 3 nail tip shape

Nail tip shape sign shape (Example) Lateral C-shaped tip Bullet-shaped tip D Diamond tip L no sharp W Wedge pointed X Tapered tip Z

5.2 Specifications

Nail specifications Arabic numerals combination shank diameter and length of the shank is marked (in mm); shank diameter and length of the shank Between use of the symbol "x" connection; nail should follow the specifications in Appendix A, Appendix B, Appendix C, Appendix D, Appendix E, Appendix F, Appendix G, Appendix H, Appendix I, Appendix J, Appendix K, Appendix L, M and Appendices Appendix N provisions; special specification orders when specified in the contract.

5.3.1 Mark mode

The type and shape of the nail marks, with the Chinese species, nail shape characteristics of the Chinese phonetic alphabet and number combinations nail specifications, in accordance with

Table 1, Table 2 and Table 3 mark. In general, the pattern shape steel nails cap, shank shape of a round bar, nail tip shape diamond tip shape

Feature can be omitted when labeling.

5.3.2 Markup order

Tag order in accordance with the type of nail products, nail shape, size, shape of the shank, the shape of the nail tip order sequentially. Nail surface Management mode, using Chinese characters in front of the species marked out. See examples.

Example.

Plating Pallet nails species Nail shape 2.68 Shank diameter x 50.8 Shank length LX Shank shape Nail tip shape He said. Shank diameter of 2.68mm, shank length 50.8mm, flat-shaped nut, helical rod-shaped nails, nail without sharp plating tray.

6.1 Raw materials

Manufacturing wire nails commonly used as a raw material. The use of low-carbon steel nails raw, raw materials shall comply with GB/T 701's;

Use high-quality carbon steel nail raw, raw materials shall comply with GB/T 4354's. Stainless steel nail raw, raw materials shall comply with GB/T 4232; or the use of other materials than the above criteria.

6.2.1 Nut

Screw cap does not allow significant skew and crack; round nail ovality should not exceed 16% of the nominal shank diameter; nail shape should follow According to Appendix A, Appendix B, Appendix C, Appendix D, Appendix E, Appendix F, Appendix G, Appendix H, Appendix I, Appendix J, Appendix K, Appendix L, M and Appendix N the provisions of appendix.

6.2.2 Shank

Shank should ensure straight nail length greater than 20mm, the bending of delta should be less than 0.005L, in units of mm, shown in Figure 1; long Less than or equal to 20mm steel nails, visual should be no significant bending. Shank shape should comply with Annex A, Annex B, Appendix C, Appendix D, Appendix E, Appendix F, Appendix G, Appendix H, Appendix I, Appendix J, Appendix K, Appendix L, M and Appendices Appendix N of the rules.

1 Shank curvature

6.2.3 Nail tip

Nail tip should not significantly skew, there should be flat or sharp fins; nail tip angle should be in accordance with Appendix A, Appendix B, Appendix C, Appendix D, Appendix E, Appendix F, Appendix G, Appendix H, Appendix I, Appendix J, Appendix K, Appendix L, M and Appendices Appendix N of the rules.