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

GB/T 11105-2012

Replacing GB/T 11105-1989

Metallic powder - Rattle test for the green compacts

金属粉末 压坯的拉托拉试验

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Foreword

This standard rule according to GB/T 1.1-2009 given draft. This standard replaces GB/T 11105-1989 "metal powder compacts La Tuola test." This standard and GB/T 11105-1989 Compared to the main changes are as follows:

- To increase the content of Chapter 2 of the reference document;
- Chapter 4, delete "14 mesh";
- 5.1 "sample size" to "the number of samples and specimen size";
- 5.1 "specimen height and diameter 11.3mm considerable" to "high sample was 11.3mm $\pm$ 0.2mm, the diameter of the sample It was 11.3mm $\pm$ 0.2mm ";
- 5.2.1 adds solid lubricants synthetic waxes recommendation;
- 6.3 "87 $\pm$ 10r/min" to "87r/min $\pm$ 10r/min";
- 7.2 "on even rounding rules" to "according to the provisions of GB/T 8170, the rounding of numerical values." This standard by the national non-ferrous metals Standardization Technical Committee (SAC/TC243) centralized. This standard was drafted. PM Laiwu Iron and Steel Group Co., Ltd., a limited liability company Xi'an Pao powder metallurgy, iron and steel research General Hospital. The main drafters of this standard. Chen Jianhua, Yuan Yong, Zhao Jing, Li Ting, Dong Feng collar, Zhu Li Ran. Metal powder compacts La Tuola test

1 Scope

GB/T 11105-2012 is the Chinese national standard on metallic powder - rattle test for the green compacts, in the field of metallurgy. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 31 December 2012 by the General Administration of Quality

Supervision, Inspection and Quarantine of the People's Republic of China; Standardization Administration of China, and has been in force since 1 October 2013. Classification: ICS 77.160, CCS H16. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This standard specifies the test method for the determination of metal powder Latuo La formability. This standard applies to the wear resistance of powder compacts and the end corner portions of the shock resistance.

2 Normative references

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

GB/T 8170 represents rounding off rules and limit values \u200b\u200band judgment Principle

3 The powder compacts under specified conditions by cold pressing, placed in La Tuola test device, the starter motor, the cylindrical metal mesh prepared Shaped cage is rotated so compact and cage friction between the collision and the collision compact, fixed number of revolutions of the sample obtained under weightlessness.

4 Device

This device is a motor and automatic control of the number of revolutions of the drum by a circular device to 1190 μ m mesh net made of bronze and driving the drum Thereof. The shape and size of the main rotor is given in Appendix A.

5 Sample

5.1 Number of specimens and specimen size The number of samples was 5, a cylindrical sample, the sample height is 11.3mm $\pm$ 0.2mm, 11.3mm diameter sample was $\pm$ 0.2mm.

5.2 Sample Preparation

5.2.1 according to user needs or powder technical conditions can be determined as follows Lubrication.

a) die wall lubrication. The lubricant mixture doped or doped lubricants volatile organic solutions (eg. acetone 1000cm³ of Canada Into 100g of zinc stearate) is applied to the die wall. Let drain excess liquid adhering the die wall was formed in layer after volatilization Thin lubricating film.

b) lubricating powder. powder homogeneously mixed in a predetermined amount of solid lubricant (such as. zinc stearate or synthetic wax, etc.).

5.2.2 mold face roughness Ra should not be greater than 0.16 μ m.

5.2.3 In unidirectional or bidirectional manner to suppress a certain amount of powder press forming. Compaction pressure may be a pressure group or by negotiation determine.

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