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NATIONAL STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

GB/T 1156-2011

Replacing GB/T 1156-1979

Sleeve type drip-feed lubricating cups

旋套式注油油杯

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009 Directives for standardization - Part 1: Structure and drafting of standards.

This standard replaces GB/T 1156-1979 Sleeve type drip-feed lubricating cups - Basic types and dimensions. Compared with GB/T 1156-1979 the main technical changes are the following: the title of the standard has been changed to "Sleeve type drip-feed lubricating cups"; the structure and content of the standard have been adjusted; a designation method for sleeve type drip-feed lubricating cups has been added; and the requirements for material and for surface treatment have been revised.

This standard was proposed by and is under the jurisdiction of the China Machinery Industry Federation.

The organisation responsible for drafting this standard is the China Machinery Productivity Promotion Centre.

The previous edition of the standard replaced by this standard is GB/T 1156-1979.

1 Scope

China's national standard for the sleeve type drip-feed lubricating cup, one of the small screwed fittings through which a machine is oiled by hand. The cup screws into a tapped hole over the bearing and holds a charge of oil; a knurled sleeve turns over the cup body to open or close the passage, so the operator can let the oil down into the bearing when the machine is running and shut it off when it stops. It is the simplest answer to a problem every workshop has - getting oil to a plain bearing at intervals, without a pump and without dismantling anything - and it survives on machine tools, presses and agricultural machinery

because it is cheap, visible and needs no maintenance itself. This standard specifies the types and dimensions, the designation, the technical requirements and the marking and packaging of these cups, and applies to cups connecting to an oil port with thread sizes M8x1, M10x1, M12x1.5 and M16x1.5. The 2011 edition renamed the standard, reorganised its structure, added the designation method and revised the material and surface treatment requirements.

This standard specifies the type and dimensions, the designation, the technical requirements and the marking and packaging of sleeve type drip-feed lubricating cups.

This standard applies to sleeve type drip-feed lubricating cups used with oil ports of thread sizes M8x1, M10x1, M12x1.5 and M16x1.5.

2 Normative references

The following documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

GB/T 197 General purpose metric screw threads - Tolerances.

GB/T 6403.3 Knurling.

3 Type and dimensions

The type and the dimensions of sleeve type drip-feed lubricating cups shall comply with Figure 1 and Table 1.

Figure 1 shows the cup in section and in elevation. It has two parts: 1, the cup body, and 2, the sleeve. The sleeve is knurled on its outside surface in accordance with GB/T 6403.3.

Table 1 gives, in millimetres, the overall height, the sleeve diameter, the thread length and the three further diameters for each of the four thread sizes; the fit of the sleeve on the body is H9/h9.

4.1 Designation method

The designation of a sleeve type drip-feed lubricating cup consists of three elements, in this order: the word for the cup, the thread size code, and the number of this standard, in which the year of issue may be omitted.

4.2 Designation example

The designation of a sleeve type drip-feed lubricating cup of thread size M8x1 is: Cup M8x1 GB/T 1156.

5 Technical requirements

5.1 The material of the parts of a sleeve type drip-feed lubricating cup shall be chosen according to the use and the working conditions of the cup; carbon structural steel, non-ferrous metals or plastics may be selected.

5.2 The parts of the cup shall be free from cracks, blowholes and sand holes, and the surfaces shall be free from burrs, dents and other defects that would affect performance in use.

5.3 The thread tolerance shall comply with grade 6g of GB/T 197. The surface of the thread shall be smooth and free from burrs, cracks, bruises and other defects affecting use.

5.4 The surfaces of the parts of a steel sleeve type drip-feed lubricating cup shall in general be oxidised or electroplated. Where the surfaces of the parts are coated, the fit between the cup body and the sleeve shall be assured, and the thread shall be able to pass the inspection with a go thread gauge.

5.5 Reliable oil feed shall be assured, and there shall be no leakage of oil.

6 Marking and packaging

6.1 Before packing, the cups shall be cleaned; the surfaces of parts without a metallic coating shall be coated with a rust preventive, and under normal transport and storage conditions the cups shall remain free from rust for six months from the date of despatch.

6.2 The cups shall be placed in a packing case, box or bag lined with oiled paper, and the case, box or bag shall protect the cups from corrosion and from damage during transport.

6.3 A product quality certificate shall be enclosed in the packing case.