

ICS 83.040.01

CCS G 48



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

GB/T 13460-2025

Replacing GB/T 13460-2016

Reclaimed rubber - General specification

再生橡胶 通用规范

Issued on: March 28, 2025

Implemented on: October 1, 2025

**Issued by: State Administration for Market Regulation;
Standardization Administration of China**

Table of Contents

- 1 Scope
- 2 Normative References
- 3 Terms and Definitions
- 4 Classification
- 5 Technical Requirements
- 6 Test Methods
- 6.7 Mooney Viscosity
- 6.9 Tensile Strength and Elongation at Break
- 7 Inspection Rules
- 7.1 Inspection
- 8 Packaging, Marking, Storage and Transportation

1 Scope

GB/T 13460-2025 is the Chinese national standard on reclaimed rubber - general specification, in the field of rubber and plastic industries. 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 28 March 2025 by the State Administration for Market Regulation; Standardization Administration of China, and has been in force since 1 October 2025. Classification: ICS 83.040.01, CCS G 48. 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 document specifies the classification, technical requirements, inspection rules, packaging, marking, storage and transportation of reclaimed rubber, and describes the corresponding test methods. This document applies to the production and inspection of reclaimed rubber made from various waste rubber products.

2 Normative References

The contents of the following documents constitute indispensable clauses of this document through the normative references in the text. In terms of references with a specified date, only versions with a specified date are applicable to this document. In terms of references

without a specified date, the latest version (including all the modifications) is applicable to this document.

GB/T 528 Rubber, Vulcanized or Thermoplastic - Determination of Tensile Stress-strain Properties

GB/T 533-2008 Rubber, Vulcanized or Thermoplastic - Determination of Density

GB/T 1232.1 Rubber, Unvulcanized - Determinations Using a Shearing-disc Viscometer - Part

3 Terms and Definitions

The terms and definitions defined in GB/T 9881 and the following are applicable to this document.

3.1 reclaimed rubber Vulcanized rubber that has been plasticized by thermal, mechanical and (or) chemical action and is mainly used as a rubber diluent, extender or processing aid. [Source: GB/T 9881-2008, 2.330, modified]

3.2 reclaimed butyl rubber Reclaimed rubber made from waste rubber products with butyl rubber as the main component.

3.3 reclaimed butadiene-acrylonitrile rubber Reclaimed rubber made from waste rubber products with butadiene-acrylonitrile rubber as the main component.

3.4 reclaimed natural rubber Reclaimed rubber made from waste rubber products with natural rubber as the main component.

4 Classification

4.1 Reclaimed rubber can be classified in accordance with the main rubber varieties and the sources of waste rubber.

4.2 For reclaimed rubber with clarified main rubber components, it is classified in accordance with the main rubber components it contains and represented by the English prefix "R-" meaning "reclaimed" and the symbol of the rubber varieties, as shown in Table 1.

5 Technical Requirements

5.1 Appearance The reclaimed rubber shall be uniform in texture and shall not contain visible non-rubber component impurities, such as metal, wood chips and sand grains, etc.

5.2 Properties The properties of the reclaimed rubber shall comply with the provisions of Table 3.

6 Test Methods

6.1 Appearance Visual inspection under natural light.

6.2 Heating Loss Carry out the determination in accordance with Appendix A.

6.3 Acetone Extract Carry out the determination in accordance with Method A in GB/T 3516, with acetone as the solvent and Soxhlet extractor as the instrument.

6.7 Mooney Viscosity

6.8 Density Take the non-vulcanized rubber sheet specimen and determine it in accordance with Method B in GB/T 533-2008.

6.9 Tensile Strength and Elongation at Break

6.10 Contents of Polycyclic Aromatic Hydrocarbons and Hazardous Substances In accordance with GB/T 26125, determine the content of mercury (Hg), lead (Pb), cadmium (Cd), hexavalent chromium (Cr6+), polybrominated biphenyls (PBB) and polybrominated diphenyl ethers (PBDE).

7.1 Inspection

7.1.1 Inspection is divided into type inspection and exit-factory inspection.

7.2 Batch The inspection is carried out in batches, with reclaimed rubber produced on the same production line, with the same raw materials, the same formulas and the same process as a batch, and the mass of each batch shall not exceed 50 t.

7.3 Qualification Determination If any item of the inspection results does not meet the requirements of this document, double samples shall be taken from that batch of products to a re-inspection of the disqualified item. If the re-inspection results meet the requirements of this document, then, the batch of products shall be determined as qualified. Otherwise, the batch of products shall be determined as disqualified.

8 Packaging, Marking, Storage and Transportation

8.1 Packaging The packaging materials and requirements shall be agreed upon by both the supply-side and the demand-side.

8.2 Marking Each outer package shall be marked with product name, reclaimed rubber code, net weight, manufacturer name, production date and serial No. of this document.