

ICS 25.020

CCS J32



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

GB/T 13915-2013

Replacing GB/T 13915-2002

Tolerance of angles for stamping parts

冲压件角度公差

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Foreword

This standard was drafted in accordance with GB/T 1.1-2009 given rules. This standard replaces GB/T 13915-2002 "stamping angle tolerance", compared with the GB/T 13915-2002, in addition to editorial changes, the The main technical changes are as follows:

--- Increased stampings blanking angle and bending angle of the legend (see
--- Modify the standard English translation of the name (see cover, the cover of the 2002 edition);

--- Revised English translation of the term (see 21, 22, 2002 edition of the 2.1, 2.2.);

3.3 representation selected this standard (see 33, 2002 version 3.3.);

--- Modify the limit deviation (see Chapter 1, Chapter 4, 42, 2002 edition of Chapter 1, Chapter 4, 4.2);

4.1 stampings angular deviation range of choice (see 41, 2002 version 3.3.);

--- Modify the tolerance level selection table thickness range and selection of tolerance (see Appendix A, 2002 edition of Appendix A). This standard by the National Standardization Technical Committee Forging (SAC/TC74) and focal points. This standard is mainly drafted by: YTO (Luoyang) Limited Fulai Ge body. The main drafters of this standard. Dai Road, Zhu Jing, Liu Nan. This standard replaces the standards previously issued as follows:

--- GB/T 13915-1992;

--- GB/T 13915-2002. Stamping angle tolerance

1 Scope

GB/T 13915-2013 is the Chinese national standard on tolerance of angles for stamping

parts, in the field of manufacturing engineering. 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 9 June 2013 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 March 2014. Classification: ICS 25.020, CCS J32. 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 angle of metal stampings Tolerance class code, tolerance values and deviation values. This standard applies to punching and bending sheet metal parts.

2 Terms and definitions

The following terms and definitions apply to this document.

2.1 Stamping Blanking angle blanking angle for stamping parts In the flat planar portion stamping stamping or molding, processing by punching step from the point of view.

2.2 Stamping bending angle bending angle for stamping parts Processed by bending angle formed by stamping process. 3 stampings angle tolerance levels, and numerical code

3.1 stamping punching angle tolerance points and six levels, namely. AT1 to AT6. AT represents stamping punching angle tolerance, tolerance level on behalf of the Numerals with Arabic numerals. From AT1 to AT6 rating in descending order. Stamping Blanking angle tolerance values specified in Table 1. stamping Member blanking angle tolerance should choose a shorter side as the main parameter. Short side dimension L selection example shown in Figure 1. Table 1 stamping punching angle tolerance Tolerance level Short side dimension L mm ≤ 10 $> 10 \sim 25$ $> 25 \sim 63$ $> 63 \sim 160$ $> 160 \sim 400$ $> 400 \sim 1000$ > 1000 AT1 $0^\circ 40' 0''$ $0^\circ 30' 0''$ $0^\circ 20' 0''$ $0^\circ 12' 0''$ $0^\circ 5' 0''$ $0^\circ 4' 0''$ - AT2 $1^\circ 0' 0''$ $0^\circ 40' 0''$ $0^\circ 30' 0''$ $0^\circ 20' 0''$ $0^\circ 12' 0''$ $0^\circ 6' 0''$ $0^\circ 4' 0''$ AT3 $1^\circ 20' 1''$ $0^\circ 40' 0''$ $0^\circ 30' 0''$ $0^\circ 20' 0''$ $0^\circ 12' 0''$ $0^\circ 6' 0''$ AT4 $2^\circ 1' 20''$ $1^\circ 0' 40''$ $0^\circ 30' 0''$ $0^\circ 20' 0''$ $0^\circ 12' 0''$ AT5 $3^\circ 2' 1''$ $2^\circ 1' 0''$ $0^\circ 40' 0''$ $0^\circ 30' 0''$ $0^\circ 20' 0''$ AT6 $4^\circ 3' 2''$ $1^\circ 20' 1''$ $0^\circ 40' 0''$ $0^\circ 30' 0''$ figure 1

3.2 Stamping bending angle Rating 5 grades, namely. BT1 to BT5. BT represents stamping bending angle tolerance, tolerance level on behalf of the