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

GB/T 13932-2016

Replacing GB/T 13932-1992

Cast iron swing check valves

铁制旋启式止回阀

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Table of Contents

Foreword...	3
1 Application Scope...	5
2 Normative References...	5
3 Structures and Basic Parameters...	6
4 Technical Requirements...	9
5 Test Methods...	13
6 Inspection Rules...	14
7 Requirements for Marking and Delivery...	15

Foreword

This Standard was drafted in accordance with the rules given in GB/T 1.1-2009. This Standard replaces GB/T 13932-1992, General Purpose Industrial Valves - Cast Iron Swing Check Valves. Compared with GB/T 13932-1992, the major technical differences of this Standard are as follows, in addition to editorial modifications. -- it cancels the words "General Purpose Industrial Valves" in the standard name (see cover and page 1); -- it modifies the application scope (see Article 1; Article 1 of edition 1992); -- it deletes Figure 4 (

3.2 of edition 1992); -- it modifies the basic parameters (see 3.2;

3.2 of edition 1992); -- it modifies the pressure-temperature ratings (see 4.1;

4.1 of edition 1992); -- it modifies the inner diameters of valve seat and the drift diameters of valve body (see 4.3.7;

4.3.8 of edition 1992); -- it adds the requirements for bypass devices (see 4.9); -- it adds mechanical property test (see 5.1); -- it adds shell wall thickness measurement (see 5.3); -- it adds inspection rules (see Article 6); -- it modifies the content of marking, the requirements for delivery and so on (see Article 7; Article 6 of edition 1992). This Standard was proposed by China Machinery Industry Federation. This Standard shall be under the jurisdiction of the National Standardization Technical Committee on Valves (SAC/TC 188).

The main drafting organizations of this Standard. Hefei General Machinery Research Institute, Anhui Fangxing Industrial (Group) Co., Ltd., Ningbo Amico Copper Valves Manufacturing Inc., Jiangsu Zhuze Valve Co., Ltd., Anhui Baihu Valve Factory Co., Ltd., Nengfa Weiye Tieling Valve Joint-stock Co., Ltd., Anhui Tongdu Flow Technology Co., Ltd. The main drafters of this Standard. Huang Yaming, Peng Lin, Jiang Jiaqian, Zheng Xuezhen, Xiao Peng, Cheng Jiangshan, Li Yanhui, Zhang Wenbing. The edition of the

standard replaced by this Standard is as follows: Cast Iron Swing Check Valves

1 Application Scope

GB/T 13932-2016 is the Chinese national standard on cast iron swing check valves, in the field of fluid systems and general-purpose components. 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 29 August 2016 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 2017.

Classification: ICS 23.060.50, CCS J16. 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 structures, technical requirements, test methods, inspection rules, and requirements for marking and delivery of cast iron swing check valves. This Standard applies to grey cast iron and spheroidal graphite cast iron swing check valves connected with flanges, whose nominal pressure is PN 2.5 ~ PN 25, nominal dimension DN 50 ~ DN 1800 and medium water (hereinafter referred to as "check valves").

2 Normative References

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

GB/T 152.1, Fasteners - Clearance Holes for Rivets

GB/T 152.2, Fasteners - Countersinks for Countersunk Head Screws

GB/T 152.4, Fasteners - Counterbores for Hexagon Bolts and Nuts

GB/T 228.1, Metallic Materials - Tensile Testing - Part 1. Method for Test at Room Temperature

GB/T 229, Metallic Materials - Charpy Pendulum Impact Test Method

GB/T 1184-1996, Geometrical Tolerancing - Geometrical Tolerance for Features without Individual Tolerance Indications

GB/T 1348, Spheroidal Graphite Iron Castings

GB/T 9439, Grey Iron Castings

GB/T 12220, Industrial Valves - Marking

GB/T 12221, Metal Valves - Face to Face, End to End, Center to Face and Center to End Dimensions

GB/T 12226, General Purpose Industrial Valve - Specification of Flake Graphite Iron Castings

4.5.2 The sealing surface between valve body and valve disc can be processed directly on valve body and valve disc or inserted with sealing ring or overlaid with other metals. If the sealing surface is overlaid, the thickness of overlaying after processing shall not be smaller than 2 mm.

4.6 Rocker The connection between rocker and valve disc and valve body shall rotate flexibly; it shall be ensured that the connecting place between rocker and valve body is secure and will not loosen during use.

5.1 Mechanical property test

5.1.1 The preparation of grey cast iron test specimens shall be as specified in GB/T 9439; the preparation of spheroidal graphite cast iron test specimens shall be as specified in GB/T 1348.

6.3.1 Under any of the following circumstances, type inspection shall be carried out and they can be mass produced only after they pass type inspection.

- a) during the trial production and approval of a new product;
- b) when there is any significant change in structure, material, process after mass production, which may influence the product properties;
- c) when production is resumed after a long term of production halt.

6.3.2 Specimens shall be taken for type test periodically or when a certain output is reached during normal production.

6.3.3 The sampling for type inspection shall be carried out as follows:

- a) test specimens shall be taken randomly from the inventory which has passed the inspection of the quality inspection department of the manufacturer. The minimum number for sampling of each specification and the number of specimens shall be as specified in Table 6.
- b) test specimens can also be taken from the user. They are taken randomly from the products which have been supplied to but not used by the user and remain in the as-delivered state. The minimum number is not limited by the specification of Table 6, but the test specimen number is still subjected to the specification of Table 7.
- c) when assessment is done for the quality of the whole series of products, 2 ~ 3 typical

specifications shall be sampled in accordance with the size of the series scope to carry out inspection. The minimum number for sampling of each specification and the specimen number shall be as specified in Table 6. Table 6 - Test Specimen Number Nominal dimension DN Min number for sampling/pc Specimen number/pc ≤ 200 10 1 250 ~ 600 6 1 ≥ 700 4 1

6.3.4 All items of type inspection shall be as specified in Table 5.

7 Requirements for Marking and Delivery

7.1 Marking content The marking of check valves shall be as specified in GB/T 12220 and shall be as specified in