

ICS 25.120.10

CCS J62



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

GB/T 14349-2011

Replacing GB/T 14349-1993

Press brake - Testing of the accuracy

板料折弯机 精度

Issued on: June 16, 2011

Implemented on: January 1, 2012

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China;
Standardization Administration of China**

Table of Contents

- 1 Scope
- 2 Normative references
- 3 Inspection instructions
 - 3.1 General requirements
 - 3.2 Test conditions for precision work

Foreword

Accordance with the standards GB/T 1.1-2009. Drafting Rules "Standardization Guide Part 1 standard structure and preparation of" given. This standard replaces GB/T 14349-1993 "plate bending machine precision." This standard compared with GB/T 14349-1993, the main changes are as follows:

- Increasing the general requirements for accuracy test (see 3.1); When
- modifications and additions to the work of the accuracy test specimen requirements (see 3.2);
- Modify the preset test representation (see 3.1.1);
- Modify and adjust the geometric accuracy (see 4.1);
- Modify and adjust the working accuracy (see 4.2). The standard proposed by China Machinery Industry Federation. This standard by the National Forging Machinery Standardization Technical Committee (SAC/TC220) centralized. This standard is drafted by: Shanghai punching machine tool factory, Tianshui Metalforming Machine Tool Co., Ltd., Anhui Sanli Machine Tool Manufacturing Co., Foshan City, South China Sea ACL Machine Co., Ltd., Shenyang Forging Machinery Co., Ltd. Hubei Tri-ring forging equipment. The main drafters of this standard. Deming, Guo Wei, Cai Li Quan, Dao Bao, Yangcheng Shou, Chen Jin, Yue Chunjuan, Liu Binglian. This standard replaces the standards previously issued as follows:
- GB/T 14349-1993. Precision sheet metal bending machine

1 Scope

GB/T 14349-2011 is the Chinese national standard on press brake - testing of the accuracy, 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 16 June 2011 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 January 2012. Classification: ICS 25.120.10, CCS J62. 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 sheet metal bending machine accuracy test, test and test method precision allowable value. This standard applies to general purpose plate bending machine.

2 Normative references

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

GB 10923-2009 accuracy test General Forging Machinery

GB/T 8170 repair value expressed about the rules and limit values \u200b\u200band judgment

3.1 General requirements

3.1.1 Accuracy test should be adjusted before the installation of the horizontal plate bending machine, leveling machine after the longitudinal and transverse directions should not be more than 0.20 / 1000.

3.1.2 Geometric accuracy tests should be conducted under no load conditions.

3.1.3 accuracy should work full-load test after test.

3.1.4 accuracy of the inspection process, should not affect the accuracy of bodies and parts to be adjusted.

3.1.5 Accuracy Test and inspection gage amount shall comply with GB/T 10923 of.

3.1.6 When the actual measured length is less than a predetermined length tolerance, the actual measured length shall be converted, the conversion results by GB/T 8170 rounding To m digits.

3.1.7 Specimen length, width limit deviation of $\pm 2\text{mm}$, the specimen thickness limit deviation of $\pm 0.3\text{mm}$.

3.2 Test conditions for precision work

3.2.1 The length of the specimen shall conform to the requirements of Table 1. Table 1

millimeters Table length L specimen length l ≤ 2000 $L > 2000$ to 3200 $2000 > 3200$ ~
50,003,000 $> 50,004,000$

3.2.2 The width of the specimen shall not be less than 100mm.

3.2.3 Specimen thickness shall comply with the requirements of Table 2.

chinastandards.org · PREVIEW