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CCS J18



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

GB/T 1568-2008

Replacing GB/T 1568-1997

Technical specifications for keys

键 技术条件

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Foreword

This standard is GB/T 1568-1997 "key technical conditions" amendments. This standard and GB/T 1568-1997 compared to the main changes are as follows:

--- Increase "in addition to a variety of external spline key" in scope;

--- According to GB/T

1.1 modify the provisions of normative references documents;

--- The 3.2 "crack" to "crack", by deleting "streaks and Use dent";

--- Deleting 3.3 "semicircular area of the end portion of the impact is not allowed to use flawed"; Increase "(keypad take a small value, large keys whichever is greater)" Content after

3.5 increase ", the guide button", the corresponding increase in Table 1 "guide button" content. This standard by the National Standardization Technical Committee axis machines and accessories and focal points. This standard was drafted. the machine Productivity Promotion Center, Deyang Rieter Transmission Machinery Co., Ltd. The main drafters of this Standard. Chui Ming new, Chen Zhifang, Jin Ming, Deng Takami. This standard replaces the standards previously issued as follows:

--- GB 1568-1979, GB/T 1568-1997. Key technical conditions

1 Scope

GB/T 1568-2008 is the Chinese national standard on technical specifications for keys, in the field of mechanical systems and 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 27 September 2008 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 May 2009. Classification: ICS 21.120.30, CCS J18. 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 addition of various external spline key technical requirements, acceptance inspection, marking and packaging.

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 1184 shape and position tolerances without individual tolerance value (GB/T 1184-1996, eqv ISO 2768-2. 1989)

GB/T 2828.1-2003 Sampling procedures for inspection - Part 1. by acceptance quality limit (AQL) retrieval batch test sample Programme (ISO 2859-1.1999, IDT)

GB/T 11334-2005 Geometrical product specifications (GPS) taper tolerance

3 Technical requirements

3.1 bond tensile strength of greater than or equal 590MPa.

3.2 key surface does not allow cracks, rust, scale and burrs.

3.3 A, Part C-arc flat key, there should be no deflection wedge bond. Punching process on the use of A, C-type keys, avoiding the semicircular part of the measurement Its height.

3.5 Ordinary flat key, guide key and Thin flat keys, with the key when the key length L Chou width ratio greater than 8 equal, parallel key width Chou surface in the longitudinal direction Degree should be GB/T 1184, when Chou $\leq 6\text{mm}$ by grade 7; Chou $\geq 8\text{mm} \sim 36\text{mm}$ by grade 6; Chou $\geq 40\text{mm}$ press five.

3.6 key wedge inclination angle tolerance

1.100 according to GB/T 11334-2005 AT8 level of selection, which limit deviation of $\pm$ AT8/2.

3.7 In the case of supply and demand sides agreed, key, key semicircular arc portion wedge portion and Woodruff key does not allow chamfer or round, but need Deburring.

4.1 Basic rules

4.1.1 Each key should comply with all relevant provisions of the standard, but in mass production is not always possible. According to key functions and Applications will conform to the standard and do not fully meet the requirements of the standard keys completely separate is not necessary, it is not economical.

4.1.2 supplier in the production process (including product storage acceptance inspection) have the right to use any quality control inspection procedures. But we must ensure that key Product quality in line with relevant standards.

4.1.3 demand-side considers it necessary or economically reasonable, it can guarantee the quality of the credibility of the case according to the supplier's quality inspection and previous products, the submission Acceptance of products exempt from inspection, acceptance inspection can also be customized according to the demand side of the sampling plan, but this should not be increased for inspection party is rejected Risk that should not be reduced AQL value or reduce the probability of reception.

4.2 Depending on the requirements, the demand and supply agreement, may be key to tensile strength test. Sampling plan is. acceptable quality level AQL 1.5, 8-shaped sample, the acceptance number is Ac.

4.3 Dimensional inspection Check the project and acceptable quality level key in Table 1, the sample size according to GB/T 2828.1-2003 general inspection level II, normal inspection Check a sampling program to extract.