

ICS 47.080

CCS U 18



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

GB/T 19314.4-2019

**Small craft -- Hull construction and scantlings -- Part 4:
Workshop and manufacturing**

Issued on: May 10, 2019

Implemented on: December 1, 2019

**Issued by: State Administration for Market Regulation, China National
Standardization Administration**

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Foreword

GB/T 19314 "Small boat hull structure and component size" is divided into 9 parts.

- Part 1. Materials. thermosetting resins, glass fiber reinforced plastics, reference laminates;
- Part 2. Materials. core materials for embedded structures, embedded materials;
- Part 3. Materials. steel, aluminum alloy, wood, other materials;
- Part 4. Workshop and manufacturing;
- Part 5. Determination of design pressure, design stress and component size of single vessel;
- Part 6. Structural arrangements and details;
- Part 7. Determination of the dimensions of multi-hull ship components;
- Part 8. Rudder;
- Part 9. Sailboat possession.

This part is the fourth part of GB/T 19314.

This part is drafted in accordance with the rules given in GB/T 1.1-2009.

This part uses the translation method equivalent to ISO 12215-4:2002 "Small boat hull structure and component dimensions Part 4. Workshop and system

Made.

The documents of our country that have a consistent correspondence with the international documents referenced in this part are as follows.

- GB/T 19916-2005 Main data of small boats (ISO 8666:2002, IDT)

This part is proposed and managed by the National Small Boat Standardization Technical

Committee (SAC/TC241).

This section drafted by. China Shipbuilding Corporation, the 7th Eighteenth Institute.

1 Scope

This part of GB/T 19314 specifies the conditions of the shop, the storage and processing of the materials, and the manufacturing requirements for the boat. This section applies to

A dinghy with a hull length (LH) of not more than 24 m in accordance with ISO 8666.

This section does not address health and safety requirements.

Note. The root cause of the preparation of this part of GB/T 19314 is that the workshop conditions have a significant impact on the short-term and long-term mechanical properties of the yacht, and according to GB/T 19314.5

The determined component dimensions are based on the appropriate materials and manufacturing conditions used.

2 Normative references

The following documents are indispensable for the application of this document. For dated references, only dated versions apply to this article.

Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 19314.1-2003 hull structure and component dimensions - Part 1. Materials. thermosetting resin, glass reinforced

Plastic, reference laminate (ISO 12215-1.2000, IDT)

GB/T 19314.3-2019 hull structure and component dimensions - Part 3. Materials. steel, aluminium alloy, timber, other materials

(ISO 12215-3.2002, IDT)

GB/T 19314.5-2019 hull structure and component dimensions - Part 5. singular design pressure, design stress,

Determination of dimensions (ISO 12215-5.2008, IDT)

ISO 8666.20021) Small boat main data (Smalcraft-Principaldata)

1) This document was not published at the time of ISO 12215-4.2002, and was published in.2002.

3.1.1 General requirements

The workshop should be compatible with the production and storage conditions and meet the environment specified by the material manufacturer or supplier.

In order to minimize the contamination or damage of the laminate (stack), the production area should be separated from the storage area, and different systems should be used as much as possible.

The manufacturing process is carried out in an isolated interval.

The workshop and equipment should be properly maintained and kept clean, free of waste, residual materials and equipment not related to production.

3.1.2 Temperature and humidity

If the usual hand lay-up or injection molding process is used, the temperature of the molding shop should be kept in resin during the laying and curing.

Within the limits specified by the manufacturer.

If the temperature change is outside the specified limits, the dinghy manufacturer should work with the resin manufacturer to verify that the laminate (layer) will be made

Can meet the requirements of component size and design.