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

GB/T 23252-2009

**Pneumatic fluid power -- Cylinders -- Final examination and
acceptance criteria**

气缸 成品检验及验收

(English Translation)

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Foreword

This standard is equivalent to international standards ISO 10099:2001 "Pneumatic cylinder factory inspection and acceptance" (in English).

This standard is equivalent translation ISO 10099:2001. For ease of use of this standard, the following editorial changes made.

--- In the "Normative references" to the referenced part of the technical content of relevant international standards consistent with national standards for alternative international standard.

The standard proposed by China Machinery Industry Federation.

This standard by the National Standardization Technical Committee of hydraulic and pneumatic (SAC/TC3) centralized.

This standard was drafted. Wuxi City Product Quality Supervision, Inspection, SMC (China) Co., Festo (China) Co., Ltd., Sea Camozzi Pneumatic Control Components Co., Ltd.

Introduction

In pneumatic systems, fluid energy through the circuit to deliver compressed air and control.

Cylinder is a pneumatic system components. It is a fluid energy into mechanical force and linear motion devices. By the cylinder and the cylinder in which the movement of the piston and rod and other moving parts.

GB/T 23252-2009/ISO 10099:2001 Inspection and acceptance of finished cylinders

1 Scope

This standard specifies the pneumatic system of single-pole double-acting cylinder function test product testing and acceptance.

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 17446 Fluid power systems and components Terminology (GB/T 17446-1998, idtISO 5598. 1985) Pneumatic ISO 8778 standard reference atmosphere

3 Terms and Definitions

Terms and definitions GB/T 17446 apply to this standard established.

4 Consistency Checker

In the manufacturing process, the following product characteristics should be recognized upon completion of product assembly or before through regular quality assurance operations.

- Cylinder type;
- Stroke length;
- Total length;
- Type mark;
- Cylinder bore;
- Extending the length of the piston rod and the thread diameter;
- The role of magnetic components;
- Product dimensions (including shaft pin position);
- Choose appropriate buffer;
- Air intake form, position and size.

5 Functional test pressure of not more than 150 k P Rao Conditions

Cylinder in a horizontal position to complete the test. During the test, if the buffer cylinder regulator should be completely open, full-stroke reciprocating Moving in both directions, telescopic rod should be smooth, no creeping phenomenon and tremor.

6 Pressure is 150 k and 630 k P P Rao Rao leak test

6.1

After several cylinder reciprocating action, the rod chamber vent has never passed into 150kPa and 630kPa gas, so that the rod with the large air intake chamber Gas connected. Adopted to meet the testing requirements of inspection methods and measuring equipment, measuring cylinder rod chamber of all leakage. The amount of leakage in Lower parts of spillage and.

- a) rod chamber air intakes;
- b) After the end cover and the cylinder connections;
- c) the rod chamber buffer surrounding the device and check valve (if any) regulation;
- d) at the end cap of the pores;

GB/T 23252-2009/ISO 10099:2001