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

GB/T 30571-2014

General specifications of sheet metal stamping parts

金属冷冲压件 通用技术条件

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Foreword

This standard was drafted in accordance with GB/T 1.1-2009 given rules. This standard by the National Standardization Technical Committee Forging (SAC/TC74) and focal points. Drafting of this standard. Shanghai Jiaotong University, Yangzhou Ling Electronics Co., Ltd., Beijing Institute of Electrical. The main drafters of this standard. Zhao Zhen, Zhuang Village, Wang Chung, red and gold, to China, Wei Wei, Chen Wenjing. Cold metal stamping parts General technical conditions

1 Scope

China's national general technical specification for cold stamped metal parts. It sets out the requirements for such parts, the inspection items, the inspection methods and the delivery conditions, and it applies to parts produced by cold pressing from sheet metal more than 0.1 mm thick, with stampings made from sections and tube able to refer to it. It does not apply to parts produced by fine blanking, which are covered separately. Cold stamping is the highest-volume metal forming process there is - almost every steel part in a car body, an appliance, an electrical enclosure or a piece of consumer electronics is stamped - and its economics are unforgiving: the tooling is expensive, the cycle time is short, and a defect discovered downstream has usually been reproduced tens of thousands of times before anyone notices. What this standard does is make the terms of the transaction explicit. It fixes the raw material requirements against the material standards for carbon steel sheet, cold rolled electrical steel, copper and copper alloy sheet, stainless steel sheet and aluminium extrusions, and it makes clear that the stamper may re-inspect incoming material and states what that re-inspection covers. It then sets the requirements for the part itself - dimensional accuracy against the unspecified tolerance standard GB/T 15055, burr height against JB/T 4129, surface condition, and freedom from the forming defects that stamping produces - together with the inspection methods and the sampling rules of GB/T 2828.1. The result is a document that lets a purchase order say what a stamping has to be without restating it in every contract. Issued on 6 May 2014 and in force since 1 December 2014.

This standard specifies requirements for cold metal stamping parts, inspection items,

inspection methods and delivery conditions. This standard applies to cold pressing method of production of sheet metal thickness greater than 0.1mm cold stamping. Stamping profiles and pipes Member can refer to this standard. This standard does not apply to the use of fine blanking methods of production stampings.

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. RT Test Method. Test Part 1

GB/T 228.1 metallic materials tensile

GB/T 230.1 metallic materials - Rockwell hardness test - Part 1. Test methods (A, B, C, D, E, F, G, H, K, N, T standard ruler)

GB/T 710 high-quality carbon structural steel sheets and strips

GB/T 716 carbon structural steel cold-rolled steel

GB/T 2040 copper and copper alloy sheet

GB/T 2521 cold rolled grain oriented and non-oriented electrical steel (sheet)

GB/T 2828.1 Sampling procedures for inspection - Part 1. by acceptance quality limit (AQL) retrieval batch inspection sampling plan

GB/T 3280 stainless steel cold-rolled steel sheet and strip

GB/T 6892 General Industrial aluminum and aluminum alloy extrusion profiles

GB/T 15055 stampings not note size limit deviation tolerance And test methods

GB/T 15825 (all parts) sheet metal forming

GB/T 16743 blanking clearance 30570 cold metal stamping components as GB/T

JB/T 4129 stamping burr height JB/T material dimensions without individual tolerance limit deviations punching shear at 4381

3.1 Raw materials

3.1.1 stampings selected raw materials should be consistent with stamping drawings and GB/T 710, GB/T 716, GB/T 2521, GB/T 6892, The provisions of GB/T 2040 and GB/T 3280, and we can use stamping parts manufacturers and customers agreed material.

3.1.2 The quality of raw materials should be stamping a pledge to comply with the technical requirements of the material. Stampings manufacturers may be needed Reinspection, the reinspection and major projects include.

- a) visual inspection. Test material surface defects, smudges, outline, size, shape and thickness and surface roughness.
- b) chemical analysis, metallographic examination. Content of chemical elements in the material; determining the level of material grain size and uniformity; assessment material Level feed free cementite, banded structure and non-metallic inclusions; check the material shrinkage, porosity and other defects.

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