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**Earth-moving machinery - Remanufactured components -
Technical specification for assembly**

土方机械 再制造零部件 装配技术规范

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Foreword

This standard is drafted in accordance with the rules given in GB/T 1.1-2009. This standard is proposed by the China Machinery Industry Federation. This standard is under the jurisdiction of the National Technical Committee for Standardization of Earthmoving Machinery (SAC/TC334). This standard is responsible for drafting units. Tianjin Engineering Machinery Research Institute, Xiamen Xiamen Engineering Machinery Co., Ltd., Xugong Group Construction Machinery shares Co., Ltd., Henan Hongyuan Wheel Co., Ltd., Hangzhou Zongxing Gear Co., Ltd., Zoomlion Co., Ltd., Xiamen City Cheng Machinery Co., Ltd. This standard participates in the drafting unit. Hebei Xuanhua Construction Machinery Co., Ltd., Ningbo Guangtian Saikesi Hydraulic Co., Ltd., Shaanxi Tongli Heavy industry co., Ltd. The main drafters of this standard. Li Guangqing, Li Weiping, Ma Guangrong, Chen Hanjie, Han Yili, Liu Taiping, Chen Yuanshan, Yu Jie, Yao Guangshan, Chen Jianbo, Bai Feiping, Yang Xichuan. Earthmoving machinery remanufacturing parts Assembly technical specification

1 Scope

China's national standard for the assembly of remanufactured earth-moving machinery components. It specifies the terms and definitions and the requirements for assembling remanufactured parts, and it applies to that assembly. Remanufacturing is the industrial restoration of a used component to a condition at least equal to that of a new one, and it is a larger business in construction equipment than in almost any other sector, because the machines are expensive, they work until something fails, and the failed assemblies - engines, pumps, transmissions, final drives, cylinders - are worth restoring rather than scrapping. The assembly stage is where remanufacturing differs most from ordinary manufacture. In a new-build assembly every part comes from a production run and is within tolerance by construction. In a remanufactured one, some parts are new, some have been machined back to a repair dimension and some have been reclaimed by welding, spraying

or plating and machined to size, and the assembler must fit them together into something that meets the original specification. That is a fitting problem rather than an assembly problem, and it needs a set of rules: what is checked before assembly, what may and may not be reused, how parts are cleaned and stored between operations, and how the assembly environment is controlled. The standard sets those out, drawing its terminology from GB/T 28619 for remanufacturing and its general assembly requirements from JB/T 5945 for construction machinery. Issued on 29 August 2016 and in force since 1 March 2017.

This standard specifies the terminology and definitions and requirements of earthmoving machinery remanufacturing parts. This standard applies to the assembly of earthmoving machinery remanufacturing parts (hereinafter referred to as "parts").

2 Normative reference documents

The following documents are indispensable for the application of this document. For dated references, only the dated edition applies to this article. For undated references, the latest edition (including all modifications) applies to this document.

GB/T 28619 Termination Terminology General technical requirements for

JB/T 5945 engineering machinery assembly

3 Terms and definitions

GB/T 28619 Definitions and the following terms and definitions apply to this document.

3.1 Remanufacturing parts assembly assembly of remanufactured components The process of reassembling the finished parts and parts of the refurbished parts into the remanufactured product.

4.1 Pre-assembly requirements

4.1.1 The assembly environment of the parts should be clean and conform to the environmental requirements of the prototype new product.

4.1.2 Parts shall be inspected before assembly.

4.1.3 parts should be cleaned before assembly, and according to the provisions of the new prototype.

4.2 Requirements for assembly process

4.2.1 Parts shall be assembled in accordance with the requirements of the new prototype and shall comply with the requirements of JB/T 5945.

4.2.2 parts in the assembly process should avoid bumps, scratches.

4.2.3 The assembly should have an assembly log file during assembly.

4.2.4 relative to the movement of parts, the assembly side of the contact surface should be added appropriate amount of lubricating oil (grease).

4.2.5 For parts with tolerance requirements, the assembly can be carried out by means of interchange, matching, repair and adjustment.

4.2.6 Key fastening connections and parts of the original technical document that should be used with new parts should not be used for recycling disassembled parts or remanufactured parts.

4.2.7 Parts contain calibration data, the assembly should be updated to the latest calibration data.

4.2.8 assembly process parameters should meet the requirements of the prototype new assembly.

4.2.9 parts of the assembly accuracy should not be less than the prototype of the new assembly accuracy.