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

GB/T 32804-2016

**Earth-moving machinery - Remanufacture of components -
Technical specification for disassembly**

土方机械 零部件再制造 拆解技术规范

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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). The standard responsible for the drafting unit. Tianjin Engineering Machinery Research Institute, Hangzhou Zongxing Gear Co., Ltd., Hill Reconstruction Co., Ltd., Xiamen Xiamen Engineering Machinery Co., Ltd., Xiamen City, Yu Ming Engineering Machinery Co., Ltd. This standard participates in the drafting unit. Xuzhou Xugong Mining Machinery Co., Ltd., Ningbo Guangtian Saikesi Hydraulic Co., Ltd., Shaanxi Tongli Heavy Industry Co., Ltd. The main drafters of this standard. Chen Baoqing, Han Yili, Xu Guojie, Xu Bin, Lin Chengjia, Li Zhiyong, Yao Guangshan, Chen Jianbo, Li Guangqing, Li Weiping, Ma Yumin. Technical specification for remanufacturing and dismantling of earthwork parts

1 Scope

China's national standard for the disassembly stage of earth-moving machinery component remanufacturing. It specifies the terms and definitions, the classification, the requirements, the methods and the safety and environmental requirements for disassembly, and it applies to the disassembly of earth-moving machinery parts and components for remanufacturing. Disassembly is the first operation in remanufacturing and the one that determines how much of the rest is possible. The standard defines it as taking an old product and its parts apart, down to the smallest unit that need not be separated further, in a way that ensures the parts are not further damaged in the process - and that last clause is the entire point. In scrapping, a machine is taken apart as fast as possible because the material is worth the same however it arrives. In remanufacturing, the core is worth many times its material value and only while it remains reclaimable, so a press fit driven out with a hammer instead of a puller, or a seized fastener cut through the housing rather than the bolt, destroys the value the whole operation exists to recover. The standard therefore classifies disassembly two ways: destructive against non-destructive, and partial against complete, and the choice

among them is an economic judgement made before the first tool is picked up. It also covers the safety and environmental requirements, which are substantial for this work: stored energy in accumulators and springs, suspended loads, and the oils, coolants and greases that come out of a used machine and have to go somewhere. Issued on 29 August 2016 and in force since 1 March 2017.

This standard specifies the terms and definitions, classification, requirements, methods, safety and environmental requirements for remanufacturing of earthmoving machinery parts. This standard applies to the dismantling of earthmoving machinery parts and components remanufacturing.

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

GB/T 25688.2 Earthmoving machinery maintenance tools - Part 2. Mechanical pullers and pushers

GB/T 28619 Termination Terminology

3 Terms and definitions

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

3.1 Remanufacturing disassembly The old products and their parts in order to disassemble, disassemble to the smallest non-dismantling unit, and to ensure that the dismantling in the dismantling of spare parts The performance is further damaged by the process.

4 Classification

4.1 According to the dismantling method, can be divided into destructive dismantling and non-destructive dismantling.

4.2 in accordance with the degree of dismantling, can be divided into partial dismantling, complete dismantling and target dismantling.

4.3 in accordance with the dismantling order, can be divided into sequential dismantling and parallel dismantling.

5 Request

5.1 before dismantling should be clear to see the composition of parts structure, the development of dismantling operations instructions.

5.2 before the dismantling of the parts should be visually inspected the sealing, damage, the application of special containers to collect waste.

5.3 For coupling parts and parts that do not have interchangeability, mark them before dismantling to prevent damage or damage to the original fit or balance status.

5.4 dismantling should be strictly in accordance with the provisions of the operating instructions, select the correct dismantling methods, dismantling tools, tooling and equipment, and record zero Parts of the necessary information.

5.5 Disassembly should avoid damage to parts and improve remanufacturing utilization.

5.6 When dismantling fasteners, pay attention to the dismantling of fasteners in order to avoid damage to parts.

5.7 For all parts that can be reused, they should be dismantled to the minimum non-dismantling unit.

5.8 After dismantling, check the surface condition of the parts and determine whether the main parts are suitable for remanufacturing.