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

GB/T 32805-2016

**Earth-moving machinery - Remanufacture of components -
Technical specifications of cleaning**

土方机械 零部件再制造 清洗技术规范

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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 drafting of this standard. Hangzhou Zongxing Gear Co., Ltd., Hill Reconstruction Co., Ltd., Xiamen Xiamen Engineering Machinery Co., Ltd., Shandong card Heavy Industry Machinery Co., Ltd., Xiamen City, Yu Ming Engineering Machinery Co., Ltd., Tianjin Engineering Machinery Research Institute, Shaanxi Tongli Heavy Industry Co., Ltd. the company. The main drafters of this standard. Han Yi Li, Zhang Yi, Li Weiping, Zhong Yuzhu, Chen Zhizhong, Lin Chengjia, Bian Gangqiang, Huang Ruhong, Chen Baoqing, Li Guangqing. Technical specification for remanufacturing and cleaning of earthmoving machinery parts and components

1 Scope

China's national specification for the cleaning of earth-moving machinery components in remanufacturing - the first operation performed on every core that enters the plant, and the one that determines whether everything after it can be done at all. A used excavator engine or transmission arrives coated in a mixture of oil, carbon, rubber, paint, rust and ground-in soil; until that is off, the component cannot be inspected for the cracks and the wear that decide its fate, cannot be measured, and cannot be machined, coated or welded. The standard specifies the technical requirements for the cleaning of the components of earth-moving machinery in remanufacturing, together with the methods, the process requirements and the criteria by which the result is judged. It applies to the cleaning of the components of earth-moving machinery for remanufacture. The methods it covers are the ones the industry uses - the chemical and solvent cleaning, the aqueous and alkaline washing, the high pressure water and the abrasive and shot blasting, the ultrasonic cleaning and the thermal methods - each with the components and the contaminants it

suits, since a bearing journal and a cast iron block cannot be treated alike and a method that removes carbon may damage a sealing surface or leave residual stress. The standard sets the process parameters, the requirement that the cleaning must not damage the base material or alter its properties, the removal of the cleaning agent itself and the protection of the cleaned surface until the next operation, the assessment of cleanliness against defined levels, and the handling of the waste and the safety of the operators. It is the companion to GB/T 32803, which classifies the components before they reach this stage. Issued on 29 August 2016 and in force since 1 March 2017.

This standard specifies the terms and definitions, classification, requirements, and parts cleanliness of earthmoving machinery parts and components for cleaning and cleaning. Methods, safety and environmental requirements. This standard applies to the cleaning 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 20082 Hydraulic fluid transmission - Determination of particle contamination by optical microscopy

GB/T 28619 Termination Terminology Method for determination of cleanliness of parts of

JB/T 7158 engineering machinery

3 Terms and definitions

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

3.1 Remanufacturing cleaning remanufacturingcleaning The use of mechanical, physical, chemical or electrochemical methods to remove parts attached to the surface of the grease, corrosion, dirt, scale, carbon deposition and other dirt, and So that the surface of the parts to achieve the required cleanliness of the process.

4 Classification

4.1 according to the different stages of cleaning and role can be divided into before cleaning, dismantling after cleaning, and then manufacturing process cleaning, cleaning before assembly, coating Pre-installed cleaning.

4.2 According to the classification of cleaning parts category, can be divided into assembly cleaning, parts cleaning, spare parts cleaning.

4.3 by cleaning the object to be classified, can be divided into oil cleaning, coke cleaning,

scale cleaning, surface coating cleaning, rust cleaning.

4.4 by cleaning method for classification, can be divided into manual cleaning, pyrolysis, pressure cleaning, ultrasonic cleaning, chemical cleaning.

5 Request

5.1 Before cleaning, according to the characteristics of the parts to be washed to develop the appropriate cleaning instructions.

5.2 cleaning in strict accordance with the requirements of the operating instructions, select the correct cleaning methods, cleaning tools, cleaning agents.

5.3 cleaning to prevent corrosion of parts, cleaning after a long time to store the parts need to do anti-corrosion treatment.

6 Parts cleanliness assessment

6.1 The sampling method should be taken to determine the appropriate sampling frequency according to the different parts type and production process.