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

GB/T 37400.11-2019

**Heavy machinery general technical specification - Part 11:
Piping**

重型机械通用技术条件 第11部分：配管

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Foreword

GB/T 37400 "General Technical Conditions for Heavy Machinery" is divided into 16 parts.

- Part 1. Product inspection;
- Part 2. Flame cutting parts;
- Part 3. Welded parts;
- Part 4. Cast iron parts;
- Part 5. Non-ferrous metal castings;
- Part 6. Steel castings;
- Part 7. Repair welding of steel castings;
- Part 8. Forgings;
- Part 9. Machining parts;
- Part 10. Assembly;
- Part 11. piping;
- Part 12. Painting;
- Part 13. Packaging;

1 Scope

Part 11 of China's general technical specification for heavy machinery, covering piping. It specifies the technical and safety requirements for the piping of heavy machinery, applying to oil lubrication, grease lubrication, hydraulic and pneumatic systems. On a large machine these pipes are the circulatory system, and they are the part most often responsible for a machine that will not stay in service. Hydraulic systems on rolling mills and presses run at high pressure and their failures are dangerous - a pinhole leak at three hundred bar produces a jet that will inject oil through skin. Lubrication systems fail more quietly and

more expensively: a blocked line to one bearing on a mill stand destroys it without warning. And cleanliness governs both, since almost all hydraulic failures trace to contamination, and a system assembled from pipes that were cut, bent and welded on site starts full of scale and swarf unless it is flushed properly.

This part of GB/T 37400 specifies the technical and safety requirements for heavy mechanical piping. This section applies to oil lubrication, grease lubrication, hydraulic, pneumatic and industrial water piping on heavy machinery products. This section does not apply to piping for pressure vessels.

2 Normative references

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

GB/T 324 weld symbol notation

GB/T 3765 card sleeve pipe joint technical conditions

GB/T 7306.1 55° sealed pipe threads - Part 1. Cylindrical internal and conical external threads

GB/T 7306.2 55° sealed pipe threads Part 2. Conical internal and conical external threads

GB/T 7307 55° unsealed pipe thread

GB/T 12716 60° sealed pipe thread

GB/T 14383 steel socket weld and threaded pipe fittings

GB/T 37400.1 General technical requirements for heavy machinery - Part 1. Product inspection

GB/T 37400.3-2019 General technical requirements for heavy machinery - Part 3

GB/T 37400.12-2019 General technical conditions for heavy machinery - Part 12. Painting

GB/T 37400.16 General technical conditions for heavy machinery - Part 16. Hydraulic systems

3.1 Inspection before piping and parts piping

3.1.1 The parts manufactured by the manufacturer shall be assembled after being inspected by the quality inspection department.

3.1.2 The purchased materials and parts shall comply with the relevant provisions of GB/T 37400.1.

3.1.3 Confirm that the pipe diameter, material and wall thickness of the pipe meet the

requirements.

3.2 Pipe cutting Pipes should preferably be sawed or machined, and grinding and flame cutting are not permitted. Cutting the vertical section of the pipe The degree shall comply with the provisions of Table 1.

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