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

GB/T 46233-2025

Products in fibre-reinforced cement - Sampling and inspection

纤维增强水泥制品 抽样与检验

(English Translation)

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Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for standardization work Part 1: Structure and drafting rules for standardization documents" Drafting.

This document is modified to adopt ISO 390:1993 "Sampling and testing of fiber reinforced cement products".

This document has the following structural adjustments compared to ISO 390:1993.

--- Split Table 1 in ISO 390:1993 into Table 1, Table 2 and Table 3 (see Table 1, Table 2 and Table 3 of this document);

---5.2.1 and 5.3.2 correspond to 5.3.4 in ISO 390:1993;

---5.2.3 and 5.3.4 correspond to 5.3.3 of ISO 390:1993;

---5.3.3 corresponds to 5.3.2 in ISO 390:1993;

---6.1 and 6.2 correspond to 6.2 in ISO 390:1993.

The technical differences between this document and ISO 390:1993 and their reasons are as follows.

--- Added normative references GB/T 2829-2002 (see Chapter 3), GB/T 3358.2-2009 (see Chapter 3), GB/T 16309 (see Chapter 3). This document quotes terms from the above three

standards;

--- Deleted ISO 9000:1987, ISO 9001:1987, ISO 9002:1987, ISO 9003:1987, my country and foreign certification the systems are different, and deleting the standards for ISO-related certification can improve the applicability of this document in my country;

--- Added the terms "delivery inspection" and "process inspection" (see Chapter 3). The above two commonly used terms in my country are added.

The smooth implementation of localization and technical exchanges are of great significance;

--- Deleted the terms "order", "delivery batch", "type inspection", "acceptance inspection", "inspection", "product", "inspection batch", "inspected batch", "inspection batch" Maximum quantity, minimum quantity for inspection lot, metrological inspection, attribute inspection, sample, sampling plan, sample size, and test sample "Non-conforming", "non-conforming product", "accept", "reject", "acceptance number", "rejection number", these terms are defined in GB/T 2828.1, the above terms have already appeared in GB/T 2829 and GB/T 3358.2. Deleting the above terms can avoid duplicate definitions and keep this document simple.

Cleanliness;

--- Added symbols "AL", "LI", "Lu", "R", "R", "X" (see Chapter 4). Adding the above symbols can eliminate ambiguity and ensure unified understanding.

Improve the readability of this document;

--- Added subsampling in sampling (see 5.2.2) to maintain the integrity of the structure of this document;

--- Deleted 5.3.2.7 in ISO 390:1993. The secondary sampling in ISO 390:1993 is only for the re-inspection of the first unqualified items.

There is a contradiction between this method and my country's national conditions. According to my country's GB/T 2828.1, if a second sampling is required after the first sampling, the whole all items are sampled and inspected for the second time to determine whether the batch is qualified or not;

--- Deleted 6.1 in ISO 390:1993. Regarding the inspection level applicable to this document, footnote 1 of Chapter 1 has been mentioned;

--- Deleted Chapter 7 of ISO 390:1993. my country's product and quality certification systems are different from those mentioned in ISO 390:1993.

Chapter 7 does not conform to my country's national conditions. In order to improve the operability of this document in my country, Chapter 7 will be deleted;

--- Added Appendix B Table B.1 to Table B.7. The addition of Table B.1 to Table B.7 can

improve the clarity of technical terms and facilitate enterprises to quickly Benchmark execution.

The following editorial changes have been made to this document.

- Deleted the reference standards ISO 395:1983 and ISO 881:1980 in Appendix C;
- Added the reference standards JC/T 412.1-2018 and JC/T 980-2018 in Appendix C;
- Deleted Appendix D in ISO 390:1993;
- Added references.

1 Scope

This document describes the composition, sampling¹⁾ and judgment rules of inspection lots of fiber reinforced cement products, and establishes the sampling rules for delivered finished products and in-process finished products.

Guiding principles for sample inspection and judgment.

1) The sampling plan is based on GB/T 2828.1-2012, GB/T 6378.1-2008, GB/T 8051-2008 and GB/T 16307-1996, using a 4% AQL (Acceptance Quality Limit) and S-3 inspection level. Based on the results obtained from the previous batch of samples, these standards can be relaxed or tightened.

For the sampling and inspection rules (conventional, stricter or relaxed inspection) to be used, see Appendix A and Appendix B.

This document is applicable to delivery inspection, process inspection and type inspection.

2 Normative references

The contents of the following documents constitute the essential clauses of this document through normative references in this document.

For referenced documents without a date, only the version corresponding to that date applies to this document; for referenced documents without a date, the latest version (including all amendments) applies to this document.

GB/T 2828.1-2012 Sampling procedures for inspection by attributes Part 1: Sampling for batch inspection based on acceptance quality limit (AQL) Plan (ISO 2859-1:1999, IDT)
GB/T 2829-2002 Periodic Inspection Attribute Sampling Procedures and Tables (Applicable to Inspection of Process Stability) GB/T 3358.2-2009 Statistical Vocabulary and Symbols Part 2: Applied Statistics (ISO 3534-2:2006, IDT) GB/T 16309 Terminology for fiber reinforced cement and its products

3 Terms and Definitions

Terms defined in GB/T 2828.1-2012, GB/T 2829-2002, GB/T 3358.2-2009, GB/T 16309, and the following and definitions apply to this document.

The worst average process quality level that can be tolerated when a consecutive series of batches are submitted for acceptance sampling.

Note 1: This term is used only when the sampling plan has the transfer rules and suspension rules used in GB/T 2828.1 and GB/T 6378.1.

NOTE 2 The specified acceptance quality limit does not imply that the acceptance quality limit is acceptable, although lots with quality as bad as the acceptance quality limit may be accepted with a higher probability.

The sampling plan and its transfer rules and suspension sampling inspection rules in this part are to encourage suppliers to have comparative. If the process average is not consistently better than the AQL, there will be a shift to tighter inspection to make the acceptance accurate.

Once stricter inspection is carried out, quality improvement measures must be taken to improve process quality, otherwise it may lead to temporary Stop sampling inspection.

[Source. GB/T 2828.1-2012, 3.1.26, modified] 3.2 production batch the quantity of products or materials produced by the same supplier under the same conditions.