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NATIONAL STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

GB/T 4676-2018

Replacing GB/T 4676-2003

Abrasive grains -- Sampling and splitting

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Table of Contents

Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard replaces GB/T 4676-2003 "General Abrasive Sampling Method", and the main changes compared with GB/T 4676-2003 are as follows.

--- Revised the general requirements for the sampler (see 5.1.1, 5.1 of the.2003 edition);

--- Deleted the informative appendix and added the contents of the sampler to the text (see 5.1.6, Appendix A of the.2003 edition);

--- Increased the type of sampler (see 5.1.3, 5.1.4, 5.1.5);

--- Added the content sampled from the pouch (see 7.2.2.2);

--- Increased the method of shrinking the artificial quadrant (see 8.2);

--- Revised the sample storage time, from 3 months to 6 months (see 9.2,.2003 version 9.2);

--- Increased structural changes with international standards (see Appendix A).

This standard uses the redrafting method to modify the use of ISO 9138.2015 "abrasive sampling and shrinking".

Compared with ISO 9138.2015, this standard has more structural adjustments. Appendix A lists this standard and ISO 9138.2015.

The chapter number is compared to the list.

The technical differences between this standard and ISO 9138.2015 and their reasons are as follows.

---About the normative reference documents, this standard has made technical adjustments to adapt to China's technical conditions, adjustments

The situation is reflected in Chapter 2, "Regulatory References", and the specific adjustments are as follows.

* Replace ISO 8486-1 with GB/T 2481.1 modified with international standards (see 5.1.1);

* Replace ISO 8486-2 with GB/T 2481.2 (see 5.1.1);

* Replace ISO 6344-1 with GB/T 9258.1 equivalent to the international standard (see 5.1.1);

* Added reference to GB/T 8170 (see 7.1.2).

--- In addition to the application of abrasives, the scope of the corundum series and carbide series for non-grinding applications can be referred to.

Content to meet the actual needs of our country;

--- Added terms and definitions (see Chapter 3) and general provisions (see Chapter 4) to facilitate the understanding and application of this standard;

--- Revised the specification of the insertion angle of the sampler, unified to 45 ° ~ 60 °;

--- Added Type 5 sampler (see 5.1.6), as this type of sampler is often used in China;

--- Added sampling shovel, sample shovel and sampler, as these are also commonly used tools in sampling and shrinking processes;

--- Added specific provisions for the size of the reducer to improve the standard operability;

--- Revised the requirements for sample volume to improve standard operability (see Chapter 6, ISO 9138.2015 4.1 and

4.5);

--- Added a description of the sampling method (see 7.1) to improve the standard operability;

--- Increased sampling shovel sampling (see 7.2.2.3), mesh reduction method and cone quadrilateral method (see 8.3, 8.4) to meet the actual situation in China

need;

--- Increased the content of sample storage (see Chapter 9), etc., to improve the standard content.

This standard has made the following editorial changes.

--- The standard name was changed to "Ordinary Abrasive Sampling Method";

--- Added informative Appendix A.

This standard was proposed by the China Machinery Industry Federation.

This standard is under the jurisdiction of the National Abrasives Standardization Technical Committee (SAC/TC139).

This standard was drafted. Guizhou Dazhong No.7 Grinding Wheel Co., Ltd., Zhengzhou Abrasives Grinding Research Institute Co., Ltd., Pingdingshanyi

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1 Scope

This standard specifies the terms and definitions of general abrasive sampling methods, general rules, sampling and shrinking tools, samples, sampling, shrinkage and samples.

Product storage.

This standard applies to ordinary abrasives. Corundum series and carbide series products for non-grinding purposes can be used as reference.

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 2481.1 Determination and marking of abrasive grain size of bonded abrasives - Part 1 . coarse abrasives F4~F220

(GB/T 2481.1-1998, eqvISO 8486-1.1996)

GB/T 2481.2 Fixed abrasives - Determination and marking of abrasive grain size - Part 2

GB/T 8170 Numerical Rounding Rules and Representation and Determination of Limit Values

GB/T 9258.1 Specification for abrasive grain size for coated abrasives - Part 1

ISO 6344-1.1998, IDT)

3 Terms and definitions

The following terms and definitions apply to this document.

3.1

Batch lot

A certain number of products produced under the same production conditions.

3.2

Delivery batch consignment

A certain number of products that are supplied to customers at one time.

Note. A delivery batch consists of one or several production batches, or it can consist of one part of a production batch or parts of several production lots.

3.3

Inspection lot testlot

A number of products for inspection sampling.

3.4

Sample sample

A certain quantity of products extracted from the inspection lot is used for physical and chemical analysis to provide a basis for judging whether the product meets the requirements.

3.5

Increment

A large sample taken from the packaging unit at a time.

3.6

Large sample

The sum of all samples taken from the same specification inspection lot.