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

GB/T 4678.17-2024

Replacing GB/T 4678.17-2003

Die casting dies-Components-Part 17: Ejector sleeves

压铸模 零件 第17部分：推管

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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 is required.

This document is part 17 of GB/T 4678 "Die casting parts". GB/T 4678 has published the following parts. Part 1: Template;- Part 2: Circular inserts;- Part 3: Rectangular inserts;- Part 4: Square guide posts;

Part 5: Circular guide cylinders;

Part 6: Guide bushings with head;

Part 7: Straight guide bushings; Part 8: Push Plate;- Part 9: Push plate guide column;

Part 10.Push plate guide bushing; Part 11.Push rods;- Part 12.Reset rod;- Part 13.Push plate washers; Part 14.Stopping pins; - Part 15.Spacers;- Part 16.Flat push rods; Part 17.Push tube; Part 18.Support columns;

Part 19.Positioning elements. - This document replaces GB/T 4678.17-2003 "Die casting parts Part 17.Push tube" and is consistent with GB/T 4678.17-2003.

In addition to structural adjustments and editorial changes, the main technical changes are as follows.

Added B-type push tube (see 4.2); a) Adjusted the requirements for the roughness of the cylindrical surface of the D-size of the A-type push tube (see Figure 1, Figure 1 of the 2003 edition); b) Adjust the size range of A-type push tube D from 2 mm to 12 mm to 4 mm to 16 mm (see Table 1, Table 1 of the 2003 edition); c) The value range of L dimension has been adjusted (see Table 1, Table 1 of the 2003 edition). d) Please note that some of the contents of this document may involve patents. The issuing organization of this document does not

assume the responsibility for identifying patents.

This document is proposed and coordinated by the National Technical Committee for Mould Standardization (SAC/TC 33).

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The previous versions of this document and the documents it replaces are as follows.

First published in 2003 as GB/T 4678.17-2003; This is the first revision. -

Introduction

The series of standards for die casting parts are the basic technical documents for the design, manufacture, inspection and acceptance of die casting parts.

The purpose of the formulation of the "Die Casting Parts" is to unify the basic structure and specifications of die casting parts, standardize their technical requirements, and improve the quality of domestic die casting parts.

Product quality and standard parts utilization rate, reduce production costs. Due to the large number of parts types, according to the number of typical parts of the die casting mold GB/T 4678 is divided into the following 19 parts. Part 1: Template;- Part 2: Circular inserts;- Part 3: Rectangular inserts;- Part 4: Square guide posts;

Part 5: Circular guide cylinders;

Part 6: Guide bushings with head;

Part 7: Straight guide bushings; Part 8: Push Plate;- Part 9: Push plate guide column;

Part 10.Push plate guide bushing; Part 11.Push rods;- Part 12.Reset rod;- Part 13.Push plate washers; Part 14.Stopping pins; - Part 15.Spacers;- Part 16.Flat push rods; Part 17.Push tube; Part 18.Support columns;

Part 19.Positioning elements. - Each part specifies the structure, technical requirements, material requirements, marking, etc. of one of the parts.

According to the requirements, design and manufacture die-casting mold parts according to the corresponding parts.

GB/T 4678 was first issued in 1984 and was revised and supplemented for the first time in 2003 according to the needs of the development of the die-casting mold industry.

In recent years, with the development of China's industry and economy, the design and manufacturing technology of large, precise, complex and other high-end die-casting molds has become more and more mature.

At the same time, with the application of new materials and new processes and the requirements of international standards brought about by mold exports, the basic size system of die-casting mold parts has been There have been changes in the series, accuracy requirements, marking, packaging, etc.

The National Technical Committee on Mould Standardization completed Part 1 to Part 16 of GB/T 4678 from 2017 to 2023.

Part 19 is a revision of 17 parts. This revision is Part 17 of GB/T 4678.

Timely and comprehensive reflection of the latest mature technology content of the die casting mold industry, and coordinated with other revised die casting mold parts standards, It is of great significance to the technological progress and industrial upgrading of the industry.

Die casting parts Part 17. Push tube

1 Scope

This document specifies the types and dimensions, materials, technical requirements and markings of push tubes for die casting moulds.

This document applies to the design and manufacture of push tubes for die casting molds.

2 Normative references

GB/T 1800.1-2020

GB/T 1804-2000

GB/T 4679

3 Terms and definitions

There are no terms or definitions that require definition in this document.

4 Type and size

4.1 The type of A push tube should be consistent with Figure 1, and the dimensions should conform to the values given in Table 1. Surface roughness in microns Dimensions in millimeters The roughness Ra of the unnotched surface should be 3.2 μm . Figure 1 A-type

push tube

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