

JB

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

JB/T 7699-1995

Replacing JB/Z 85-1965

**Wooden patterns and core boxes for foundry - Technical
specifications**

铸造用木制模样和芯盒 技术条件

(English Translation)

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1 Subject content and applicable scope

This standard specifies the grades, technical requirements, acceptance rules, markings and storage of wooden patterns and core boxes for sand casting process.

This standard is applicable to wooden patterns and core boxes for sand casting process, and also to mixed patterns and core boxes of wood and metal.

2 Normative references

- GB 153.1 Coniferous sawn timber - Species tolerance
- GB 153.2 Coniferous sawn timber - Grading
- GB 4817.1 Broad leaves sawn timber - Species, Sizes, Tolerance
- GB 4817.2 Broad leaves sawn timber - Grading
- GB 5611 Foundry terminology
- GB/T 11350 Machining allowances on castings
- GB 12472 Surface roughness parameters and their values for wooden pieces
- GB/T 14495 Roughness comparison specimens for wooden pieces
- JB/T 5105 Casting form - Pattern draft
- JB/T 5106 Calculation method of castings material consumption process quota

3.1 measurement dimension

sum of the basic dimensions of parts, machining allowance on castings, shrinkage margin of castings, other process allowance, and casting form pattern draft on the casting process drawing, as well as that dimension of the core print

3.2 flatness tolerance

maximum distance allowed between the working plane and the ideal plane of the pattern and core box

3.3 coincident dimension tolerance

tolerance of overlapping dimension of parting line or parting of core box

3.4 dimension tolerance of tooling

only the dimension tolerance of pattern and core box, which includes the sand box and pattern mounting plate for manual molding and universal molding machine

3.5 unspecified dimension tolerance

dimension tolerance other than center distance tolerance, fit dimension tolerance, overlapping dimension tolerance, wall thickness tolerance, process equipment dimension tolerance

3.6 universal molding machine

molding machine which, if used for molding, does not require the sand box to be equipped with limit and slide and requires the side wall of the sand box not to be provided with box structure except the lifting shaft

4 Grade of pattern and core box

In accordance with the number of uses of pattern and core box and different requirements for the castings' accuracy, it can be classified into the following three grades.

4.1 Grade I pattern and core box

It is applicable to any of the following situations: