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

JG/T 320-2011

Replacing JG/T 5030-1993

**Hydraulic buttonhead machine for prestressed tendon
(English Translation)**

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Table of Contents

Foreword

1 Scope

2 Normative references

3 Terms and definitions

Foreword

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

This standard is the JG/T 5030-1993 "prestressed steel, wire hydraulic upsetting head" amendment, this standard and JG/T 5030-1993 Compared to the main technical changes are as follows.

- Modify the standard name;
- Modify the scope of the description (see Chapter 1);
- Modify and increase the reference standard (see Chapter 2);
- Modify the terms and definitions (see Chapter 3);
- Modify the preparation of the product model (1993 version 4.2; version 4.2);
- Modify the main parameters of the series (1993 version 4.3; version 4.3);
- Modify the requirements of the working medium (1993 version 4.1.1; version 5.1);
- Modify the heading quality requirements (1993 version 5.2.2 and 5.2.3; version 5.2.2);
- Modify the head die and clip pairs of durability requirements (1993 version 5.2.7; 5.2.4 of this version);
- Increased cutting requirements (see 5.4.1);
- Increasing the lifting device requirements (see 5.4.10);
- Modify the test conditions (1993 version 6.1; version 6.1);
- Modify the test method (1993 edition of 6.2 to 6.8; version 6.2 to 6.5);
- Modify the list of test items (1993 version 7.2.1; this version 7.3 and 7.6);
- Modify the factory inspection rework product inspection requirements (1993 version 7.2.2; version 7.4);
- Modify the type test rework product inspection requirements (1993 version 7.5; this

version of 7.8);

--- Removed the original Appendix A.

This standard proposed by the Ministry of Housing and Urban Standard and Design Institute.

This standard by the Ministry of Housing and Urban Construction Standard Technical focal points centralized.

This standard was drafted. China Academy of Building Research, Siping City British Construction Machinery Co., Ltd., Liuzhou Orv Machinery Co., Ltd.

Company, Beijing Institute of Construction Engineering Co., Ltd., Beijing municipal second company, Kaifeng Quartet prestressed company, Kaifeng Section British prestressed the company.

1 Scope

This standard specifies the prestressing tendons with hydraulic classification and type, requirements, test methods, inspection rules and signs, packaging and Storage.

This standard applies to the end of prestressed tendons cold forging upsetting device (hereinafter referred to as upsetting device).

2 Normative references

The following documents for the application of this standard is essential. For dated references, only the dated version applies to this standard quasi. For undated references, the latest edition (including all amendments) applies to this standard.

GB/T 1804 General tolerances Tolerances for linear and angular dimensions without tolerances GB/T 1239.2 Cold rolled cylindrical coil springs - Part 2. Compression springs GB/T 1239.4 hot coil cylindrical helical compression spring technical conditions GB/T 14039 hydraulic transmission fluid solid particles pollution level code GB/T 14370 tendons anchors, fixtures and connectors GB/T 16924 steel quenching and tempering GB/T 17446 hydraulic transmission systems and components terminology JB/T 5000.3 General technical requirements for heavy machinery - Part 3. Welded parts JB/T 5000.4 General specifications for heavy machinery - Part 4. Cast iron parts JB/T 5000.5 General specifications for heavy machinery - Part 5. Non - ferrous metal castings JB/T 5000.6 General specifications for heavy machinery - Part 6. Steel castings JB/T 5000.8 General specification for heavy machinery Part 8. Forgings JB/T 5000.9 General specifications for heavy machinery Part 9. Cutting parts JB/T 5000.10 General specifications for heavy machinery - Part 10. Assembly JB/T 5000.12 General specifications for heavy machinery - Part 12. Painting JB/T 5000.13 General specifications for heavy machinery - Part 13. Packaging

3 Terms and definitions

The following terms and definitions apply to this document.

Upsettingforce upsetting force Upsetting head upsetter piston in the nominal pressure of the prestressing force of the output force.

Head up stroke upsettingstroke After the clamp of the upsetter grips the tendons, the stroke of the head piston is upset.

Upsettingallowance upsetting when the clip of the upsetter clamps the tendons, the tendons extend the length of the large end of the clip.