

ICS 65.160
CCS X 94

YC

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

YC/T 10.10-2018

Replacing YC/T 10.10-2006

**Tobacco Machinery General Technical Conditions Part 10: Metal
Plating and Chemical Treatment
(English Translation)**

Issued on: April 3, 2018

Implemented on: April 15, 2018

Issued by: State Tobacco Monopoly Administration

Table of Contents

- Foreword
- 1 Scope
- 2 Normative references
- 3 General requirements
- 3.1 Selection of metal plating

Foreword

YC/T 10 "General Technical Conditions for Tobacco Machinery" is divided into 16 parts.

- Part 1. Cutting parts;
- Part 2. Cold work;
- Part 3. Welded parts;
- Part 4. Gray cast iron parts;
- Part 5. Ductile iron castings;
- Part 6. Cast carbon steel parts;
- Part 7. Copper alloy castings;
- Part 8. Aluminum alloy castings;
- Part 9. Forgings;
- Part 10. Metal plating and chemical treatment;
- Part 11. Painting;
- Part 12. Assembly;
- Part 13. Packaging;
- Part 14. Electrical control systems;
- Part 15. Electrical control system assembly;
- Part 16. Polished and brushed stainless steel parts.

This part is the 10th part of YC/T 10.

This part is drafted in accordance with the rules given in GB/T 1.1-2009.

This part replaces YC/T 10.10-2006 "General Technical Conditions for Tobacco Machinery

Part 10. Metal Plating and Chemical Treatment", and Compared with YC/T 10.10-2006, the main technical changes except editorial changes are as follows.

- Revised the representation of metal plating and the marking requirements on the drawings (see Appendix B, Appendix B of the 2006 edition);
- Revised the quality requirements of the parts to be plated (see 3.4.1, 3.4.1 of the 2006 version);
- Modified the requirements of the zero (part) parts and springs after grinding or flaw detection (see 3.4.2, 2006 edition) 3.4.2);
- Increased the requirements for the plating of zero (part) parts after heat treatment (see 3.4.3);
- Increased the requirements before welding of welded parts (see 3.4.4);
- Revised the surface quality requirements of the zero (part) parts after sand blasting (see 3.4.6, 3.4.5 of the 2006 edition);
- Revised the requirements for different parts of the plating type (see 3.4.9, 3.4.8 of the 2006 version);
- Revised the quality requirements of galvanizing, copper plating, nickel plating, hard chrome plating (see 3.5.1~3.5.4, 3.5.6, 3.5.8~3.5.10, 2006 edition) 3.5.1~3.5.4, 3.5.6, 3.5.8~3.5.10);
- Increased the quality requirements of two common plating treatments of "metal thermal spraying" and "steel ceramics" (see 3.5.11, 3.5.12);
- Modified the content of the detection method for different plating treatments (see 4.4, 4.4 of 2006 edition);
- Revised the thickness and hardness test rules (see 5.2, 5.4, 2006 editions 5.2, 5.4);
- Revised the standard metal standard electrode potential (see Table A.3 in Appendix A, Table A.3 in 2006).

This part is proposed by the National Tobacco Monopoly Bureau.

This part is under the jurisdiction of the National Tobacco Standardization Technical Committee Smoke Machine Subcommittee (SAC/TC144/SC3).

This section drafted by. China Tobacco Machinery Technology Center Co., Ltd., Kunming Marine Equipment Group Co., Ltd., Shanghai Tobacco Machinery Limited liability company, Changde Tobacco Machinery Co., Ltd., Xuchang Tobacco Machinery Co., Ltd., Qinhuangdao Tobacco Machinery Co., Ltd.

1 Scope

This part of YC/T 10 stipulates the general metal plating and chemical treatment (hereinafter referred to as plating) of the zero (part) parts of tobacco machinery.

Technical requirements, inspection methods and inspection rules.

This section applies to the plating of parts (parts) of tobacco machinery.

2 Normative references

The following documents are indispensable for the application of this document. For dated references, only the dated version applies to this article.

Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 4955 metal cover layer thickness measurement anode dissolution coulometric method GB/T 4956 magnetic substrate on non-magnetic covering layer thickness measurement magnetic method GB/T 4957 Non-conductive coating on non-magnetic base metal, thickness measurement of eddy current method GB/T 5267.1 fastener plating Review of GB/T 5270 metal-clad electrodeposited layer and chemically deposited layer adhesion strength test method GB/T 6462 metal and oxide coatings for measuring thickness microscopy Aluminium and aluminium alloys - Determination of thickness of anodized oxide film - Part 2. mass loss method GB/T 8754 Aluminium and aluminium alloys - An GB/T 9790 metal coating and other related coatings Vickers and Knoop microhardness test GB/T 9792 Determination of membrane mass per unit area of s GB/T 9797 metal-clad nickel-chromium and copper-nickel-chromium plating GB/T 10125 artificial atmosphere corrosion test salt spray test GB/T 11374 Non-destructive measurement method for thermal spray coating thickness GB/T 11376 metal phosphate conversion film GB/T 12334 Metals and other non-organic coverings Definitions and general rules for thickness measurement GB/T 12611 metal zero (part) parts before plating quality control technical requirements GB/T 13911 metal plating and chemical treatment marking method GB/T 13913-2008 Specification and test methods for electroless nickel-phosphorus alloy coatings QB/T 3824 Lightweight ferrous metal chemical protective coatings - Test method

3.1 Selection of metal plating

Reasonable choice of metal plating method depends on metal matrix material, use conditions, metal protection characteristics, metal electrification couple, metal parts See Appendix A for factors such as structure and plating process.