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

YC/T 10.9-1993

Replacing YC/T 10.9-2006

**Tobacco machinery. General requirements - Part 9: Forgings
(English Translation)**

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Table of Contents

- Foreword
- 1 Scope
- 2 Normative references
- 3 General requirements
 - 3.1 Heat treatment
 - 3.2 Forging material
 - 3.3 Forging quality

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 ninth 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 10.9-2006 "General Technical Conditions for Tobacco Machinery Part 9. Forgings", and YC/T 10.9-2006 in contrast to the editorial changes, the main technical changes are as follows.

- Increased the requirements for heat treatment of forgings (see 3.1);
- Revised the test item and inspection quantity table for the forging grade (see 3.3.8, 3.2.8 of the 2006 edition).

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).

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1 Scope

This part of YC/T 10 specifies the technical requirements, test methods and inspection rules for forgings for general use of tobacco machinery.

This section applies to forgings freely forged on hammers of ordinary carbon steel, high quality carbon steel and alloy structural steel in tobacco machinery products. its Forgings formed by his method, when there is no special standard, refer to this section.

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.

Permissible deviation of chemical composition of finished products of GB/T 222 steel
Low-magnification structure and defect acid etching test method for GB/T 226 steel GB/T 228.1 tensile testing of metallic materials - Part 1 GB/T 229 metal material Charpy pendulum impact test method GB/T 231.1 Brinell hardness test for metallic materials - Part 1. Test methods GB/T 1979 structural steel low-fold tissue defect rating map GB/T 12363 forgings functional classification GB/T 21469 General requirements for machining allowances and tolerances for steel free forgings on hammers GB/T 21470 hammered steel free forgings machining allowance and tolerance plate, column, ring, cylinder GB/T 21471 hammered steel free forgings machining allowance and tolerance shaft GB/T 25136

General rules for the inspection of steel free forgings Ultrasonic testing of JB/T 8467 forged steel parts

3.1 Heat treatment

Forgings should be cooled or heat treated after forging to prevent forging damage and ensure good forging properties.

3.2 Forging material

3.2.1

Forgings can be directly made of killed steel ingots, steel ingots should be marked with the furnace number, and a certificate of inspection is attached.

3.2.2

Forgings can be forged from steel slabs forged from rolled or ingots. These steels should have a factory certificate of conformity.

3.2.3

When the chemical composition verification analysis of forgings is required, it shall be in accordance with GB/T 222.

3.3 Forging quality

3.3.1

When forging forgings with steel ingots or billets, the surface defects affecting the quality of the forgings shall be removed before forging. There should be enough at both ends of the ingot the amount of removal.