

HG

Professional Standard of the People's Republic of China

HG/T 20627-2009

Replace HG 20627-1997, HG 20629-1997

钢制管法兰用非金属平垫片 (Class 系列)

Non-metallic Flat Gaskets for Use with Steel Pipe Flanges

(Class Designated)

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China**

Non-metallic Flat Gaskets for use with Steel Pipe Flanges

(Class Designated)

1. Scope

This standard specifies the type, dimension and technical requirements of non-metallic flat gaskets (with insertion or without insertion) for use with steel pipe flanges.

This standard is applicable to the non-metallic flat gaskets for use with steel pipe flanges whose nominal pressures from Class150 (PN20)-Class600 (PN110) are specified in HG/T 20615 and HG/T 20623.

Note: As for the use of the gaskets in which contain the material of asbestos, it shall meet the requirements of the relevant laws and regulations. If the aforesaid gaskets are used, the protective measures shall be adopted to prevent man from damaging.

2. Normative References

The articles contained in the following documents have become this standard when they are quoted herein. For the dated documents so quoted, all the modifications (excluding corrections) or revisions made thereafter shall not be applicable to this Standard. For the undated documents so quoted, the latest editions shall be applicable to this Standard.

GB/T 528 "Rubber, Vulcanized or Thermoplastic--Determination of Tensile Stress-strain Properties"

GB/T 539 "Oil-resisting compressed asbestos fiber jointing"

GB/T 3280 "Cold rolled stainless steel plate sheet and strip"

GB/T 3985 "Compressed asbestos fiber jointing"

HG/T 20615 "Steel Pipe Flange (Class Designated)"

HG/T 20623 "Major Diameter Steel Pipe Flange (Class Designated)"

HG/T 20635 "Specification for Selection of Steel Pipe Flange, Gaskets and Bolting (Class designated)"

JB/T 6613 "The classification code and sign of flexible graphite sheets/strip"

JB/T 6628 "Reinforced flexible graphite (sheets) gaskets"

JB/T 7758.2 "Specifications of flexible graphite sheets"

QB/T 3625-1999 "PTFE sheet"

3. Material and Working Conditions

3.0.1 Material category

The materials of the non-metallic flat gaskets for use with steel pipe flanges contain:

- 1 Natural rubber, neoprene, styrene-butadiene rubber, chemigum, ethylene propylene diene copolymer and viton;
- 2 Paronite and oil-proof paronite;
- 3 Non asbestos fiber rubber sheet;
- 4 PTFE sheet, expansion PTFE plate (strip) and stuffing modified PTFE sheet;
- 5 Reinforced flexible graphite sheets;
- 6 High-temperature mica composite sheet.

Note:

1 Non asbestos fiber rubber sheet is formed through compacting such materials as organic fiber and/or inorganic fiber and rubber.

2 Reinforced flexible graphite sheet is formed through compounding the impacting or punch stainless steel plate: 0Cr18Ni9 (304), 0Cr17Ni12Mo2 (316) or 00Cr17Ni14Mo2 (316L) with expanded graphite layer.

3 High-temperature mica composite sheet is formed by combining the 316 two-way impacting stainless steel plate with mica layer.

3.0.2 Material Property

- 1 Gasket material of rubber sheets shall meet the requirements of Table 3.0.2.

Table 3.0.2 Gasket Material of Rubber Sheets

Test item	Test method	Rubber variety			
		Neoprene (CR)	Chemigum (NBR)	Ethylene propylene diene copolymer (EPDM)	Viton (FKM)
Hardness (Shaw A)	GB/T531	70±5			
Expansion and contraction strength (MPa)	GB/T 528	≥10			
Maximum elongation (%)		≥250	≥150		

2 Paronite materials shall meet the requirements of GB/T 3985 and GB/T 539.

3 PTFE sheet materials shall meet the requirements of SFB-2 of QB/T 3625-1999.

4 For PTFE material is of cold-flow property, the applicable operational condition as well as sealing surface type of the flange shall be considered when it is adopted.

5 Reinforced flexible graphite sheet is compounded by stainless steel impacting or punch drying plate and expanded graphite particle. And stainless steel impacting or punch drying plate plays a role in enhancement. Reinforced flexible graphite sheet shall meet the requirements of JB/T 6628. And the materials of flexible graphite layer shall meet the requirements of JB/T 7758.2. Thereinto, content of chloride ion shall be less than or equal to 50×10^{-6} .

6 If the gaskets of expansion PTFE plate/strip and stuffing modified PTFE plate are adopted, the recognized manufacturer's brand shall be indicated. The applicable pressure, temperature and maximum (P×T) value of the gaskets shall be determined according to the working condition.

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