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JB

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

中华人民共和国机械行业标准

JB/T 5000.9-2007

Replace JB/T 5000.9-1998

**Heavy mechanical general techniques and standards
—Part 9: Cutting**

**重型机械通用技术条件
第 9 部分：切削加工件**

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Forward

JB/T5000 Heavy Mechanical General Techniques and Standards contain 15 parts:

- ___ Part one: Product Inspection
- ___ Part two: Fire-cutting
- ___ Part three: Welding parts
- ___ Part four: Iron casting
- ___ Part five: Cast nonferrous metal
- ___ Part six: Cast steel
- ___ Part seven: Cast Steel repair welding
- ___ Part eight: Forging
- ___ Part nine: Cutting
- ___ Part ten: Assembly
- ___ Part eleven: Tubing
- ___ Part twelve: Painting
- ___ Part thirteen: Packing
- ___ Part fourteen: Cast steel nondestructive examination
- ___ Part fifteen: Forging steel nondestructive examination

This part is the ninth part of JB/T5000.

This part takes the place of JB/T5000.9-1998 Heavy Mechanical General Technique and Standard: cutting.

Comparing with JB/T5000.9-1998, the main differences are as follows:

- unstated chamfer is changed from a definite value to a range, and the oversize of chamfer is modified;
- inapplicable range of length and unstated angular tolerance is added;
- positional tolerance of treaded hole and unthreaded hole is stated as cylindrical unstated positional tolerance. Some words are modified.
- illustrations of unstated surface roughness and positions that is permitted according to the shape of tools are added; Some words are modified.
- chapter of rolling depression is added.

This part is raised by China Machinery Industry Federation.

This part is centralized management by the Engineering Industry Metallurgical Equipment Technical Committee for Standardization.

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This part's previous edition:

—JB/T 5000.9—1998.

Heavy Mechanical General Technique and Standard:

Part 9: Cutting

1 Scope

This part of JB/T5000 specifies the general requirements and unstated tolerance of cutting, and specific requirements of key slot, diameter of holes, center holes, unstated surface roughness and permitted shape of tools.

This part is applicable to the cutting of parts of heavy machinery.

Any drawings and standards without special requirements must meet the requirements of this part.

2 Normative references

Items in the following documents, which are quoted by this part of JB/T5000, become items of this part. Any quoted documents if they are dated, the following modify notification (not including the errata contents) or modify edition are not apply to this part. But, each part which reaches agreement according to this part will be encouraged to make studies on using these latest versions. Any latest edition of undated quoted documents can apply to this part.

GB/T 3 regular thread ending, shoulder distance, tool escape and chamfer (GB/T 3-1997, eqv ISO 3508: 1976, ISO 4755: 1983)

GB/T 197-2003 regular thread tolerance (ISO 965-1: 1998, MOD)

GB/T 1184-1996 shape and position tolerance unstated tolerance (eqv ISO 2768-2: 1989)

GB/T 1804-2000 general tolerance linear and angular tolerance of unstated tolerance (eqv ISO 273: 1979)

3 General requirements

3.1 Finished parts must meet the requirements of drawings, technical standards, and this part.

3.2 Parts must be test and accept according to the sequence. The parts can be transferred to the next sequence unless the former sequence is finished.

3.3 If defects such as sand holes, shrink holes, slag, cracks are found on the finished surfaces of steel casting, under the condition of the strength and property are not decreased, steel casting, iron casting, and nonferrous casting and forgings are permitted to be repaired according to the requirements after finished, and can be machined again only if after tested as qualified.

3.4 Burrs are not permitted on the finished parts. Unless other wise stated in the drawing, sharp angles and sharp edges are not allowed.

3.4.1 If it is not stated in the drawing, parts are chamfered according to the Table 1 and Figure 1. Non-revolving parts are chamfered according to Table 1; main parameter D(d) takes the shorter one of the two adjacent factors as chamfer.

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