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

中华人民共和国机械行业标准

JB/T 5000.11-2007

Replace JB/T 5000.11-1998

**Heavy mechanical general techniques and
standards-Part 11: Attached piping**

重型机械通用技术条件 第 11 部分：配管

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Foreword

JB/T5000 Heavy Mechanical General Techniques and Standards is divided into fifteen parts:

- ___ Part one: Product Inspection
- ___ Part two: Oxygen cutting workpiece
- ___ Part three: Welding
- ___ 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 workpiece
- ___ Part ten: Assembly
- ___ Part eleven: Attached piping
- ___ Part twelve: Painting
- ___ Part thirteen: Packing
- ___ Part fourteen: Cast steel nondestructive examination
- ___ Part fifteen: Forging steel nondestructive examination

This part is the eleventh part of JB/T5000.

This part takes the place of JB/T5000.11-1998 Heavy Mechanical General Techniques and Standards: Attached piping.

Comparing with JB/T5000.11-1998, the differences are as follows:

- ___ Flatness of cross section in Table 1 has been deleted;
- ___ Requirements on Unmarked Pipeline tolerance and Manufacturing pipe have been added.
- ___ Compensating welding defected seam has been added.
- ___ Appendix B prefabrication drawing of attached piping has been added.

Appendix A of this part is normative appendix. Appendix B is documental appendix.

This part is raised by China Machinery Industry Federation.

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

Draft out responsible unit: First Heavy Machinery Group Co.,

Draft out attended unit: Xi'an Heavy Machinery Research Institute.

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This part's previous edition:

—JB/T 5000.11—1998

Heavy Mechanical General Techniques and Standards

Part 11: Attached piping

1 Scope

This part of JB/T5000 specifies the techniques and safety requirements.

This part is applicable to the oil and grease lubricating, hydraulic and Pneumatic and industrial water attached piping for the main part of heavy machinery.

This part is inapplicable to the pressure vessel attached piping.

2 Normative Reference

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 applicable to this part. However, each part who 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 3765-1983 bite type fittings techniques and standards

GB/T 7306.1 55° Sealed piping screw Part1: Inner cylinder screw and outer cone screw (GB/T 7306.1-2000, eqv ISO 7-1: 1994)

GB/T 7306.2 55° Seal piping screw Part2: Inner cone screw and outer cylinder screw (GB/T 7306.2-2000, eqv ISO 7-1: 1994)

GB/T 7307 55° Unsealed piping screw (GB/T 7307-2001, eqv ISO 228-1: 1994)

GB/T 12716 60° Seal piping screw (GB/T 12716-2002, eqv ASME B 1.20.1: 1992)

GB/T 14383 steel bearing welding fittings

JB/T 5000.1 Heavy machinery general techniques and standards Part one: Product Inspection

JB/T 5000.3 Heavy machinery general techniques and standards Part three: Welding

JB/T 5000.12 Heavy machinery general techniques and standards Part twelve: Painting

3 Technical requirements on manufacturing attached piping

3.1 Inspection before assembling the materials and components

3.1.1 Any components made by the manufacturer must pass the inspection of the relevant quality inspection department before assembling.

3.1.2 Any outsourcing materials and components must meet the requirements of JB/T 5000.1.

3.1.3 Confirm the diameter, material and wall thickness of the pipe.

3.2 The pipe must be cut with saw or by grinding machine, while it is unavailable for flame. The perpendicularity of section while cutting the pipe must be in accordance with the description in Table 1.

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