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National Standard of the People's Republic of China

GB/T 3632-2008

Replace GB/T 3632~3633-1995

钢结构用扭剪型高强度螺栓连接副

Sets of torshear type high strength bolt hexagon nut and plain washer

for steel structures

Issue Date: Mar 03, 2008

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**Issued by the General Administration of Quality Supervision, Inspection and Quarantine of
the People's Republic of China & Standardization Administration of China**

Foreword

This standard replaces GB/T 3632-1995 "Type and Dimension for Sets of Torshear Type High Strength Bolt Hexagon Nut and Plain Washer for Steel Structures" and "Technical Requirement for sets of Torshear Type High Strength Bolt Hexagon Nut and Plain Washer for Steel Structures" GB/T 3633-1995.

The main differences between this standard and standards GB/T 3632-1995 and GB/T 3633-1995 adopted are as follows:

- - it adds M27 and M30 thread specification and recommended materials: 35VB and 35CrMo (see table 1-table 6);
- - it adds materials: ML20MnTiB and ML35 (see 5.1 and table 6);
- - it specifies that through mutual agreement of the parties, it may also use materials not specified in table 6, but it shall be indicated in the purchase contract, and add marks T (lay close to S or H) (see 5.1, table 6 and 8.3) on screw bolt or screw nut products;
- - it cancels pattern of double chamfering screw nut ("selectable pattern" in figure 3 of GB/T 3632 - 1995);
- - it replaces dimension code of washer thickness with "h" (see figure 4 and table 5);
- - it makes correspondent adjustment for relevant mechanical property names and symbols according to provisions in GB/T 228 (see table 7);
- - it adjusts hardness range for screw nut (see table 11);
- - it adds sampling plan for sets of mechanical test (see 7.3);
- - it cancels appendix A in GB/T 3632-1995 and adds a new appendix A.

This standard is one of the national standards on "bolting sets for steel structure" product series, and the series include:

- - GB/T 1228-2006 High Strength Bolts with Large Hexagon Head for Steel Structures
- - GB/T 1229-2006 High Strength Large Hexagon Nuts for Steel Structures
- - GB/T 1230-2006 High Strength Plain Washers for Steel Structures
- - GB/T 1231-2006 Specifications of High Strength Bolts with Large Hexagon Head, Large Hexagon Nuts, and Plain Washers for Steel Structures
- - GB/T 3632-2008 Sets of Torshear Type High Strength Bolt Hexagon Nut and Plain Washer for Steel Structures

Appendix A of this standard is normative.

This standard was proposed by China Machinery Industry Federation.

This standard is under the jurisdiction of National Technical Committee on Fasteners Standardization Administration of China (SAC/TC 85).

Drafting organizations of this standard are: Central Research Institute of Building and Construction, MCC and China Productivity Center for Machinery.

Other drafting organizations of this standard: Shanghai High-Strength Bolt Factory, Shanghai Shenguang High Strength Bolts Co., Ltd, Shanghai Jinma High Strength Fastener Co., Ltd, Shandong Gaoqiang Fastener Co., Ltd, Hebei Renxian High Strength Bolt Co., Ltd, China Railway Shanhaiguan Bridge Group Co., Ltd, NingBo JiuLong Fasteners Manufacture Co., Ltd, Gem-Year Industrial Co., Ltd, Ningbo

Zhong jing United Hi-Tech Industry Co., Ltd, Zhejiang Zeen Fasteners Co., Ltd, Huangzhou Hualing High-Strength Bolts Co., Ltd and Anhui Province Chaohu Casting Factory Co., Ltd.

Secretariat of National Technical Committee on Fasteners Standardization Administration of China is responsible for the explanation of this standard.

Issuing conditions on all previous editions of this standard are:

- - GB 3632-83 and GB/T 3632-1995;
- - GB 3633-83 and GB/T 3633-1995

Sets of Torshear Type High Strength Bolt Hexagon Nut and Plain Washer for Steel Structures

1 Scope

This standard specifies type and dimension, technical requirements, test method, marking method and acceptance and packing for Sets of torshear type high strength bolt hexagon nut and plain washer for steel structures with thread specification is M16-M30.

This standard is applicable to industrial and civil architecture, bridge, tower structure, boiler steel structure, hoisting machinery and other sets of torshear type high strength bolt hexagon nut and plain washer for steel structures.

2 Normative References

The following normative documents contain provision which, through reference in this text, constitute provisions of this national standard. For dated reference, subsequent amendments to, or revisions of, any of these publications do not apply. For undated references, the latest edition of the normative document referred to applies.

- GB/T 90.1 Fasteners - Acceptance Inspection (GB/T 90.1 - 2002, idt ISO 3269: 2000)
- GB/T 196 General Purpose Metric Screw Threads - Basic Dimensions (GB/T 196 - 2003, ISO 724: 1993, ISO general purpose metric screw threads - Basic dimensions, MOD)
- GB/T 197 General Purpose Metric Screw Threads - Tolerances (GB/T 197 - 2003, ISO 965-1: 1998, ISO general purpose metric screw threads - Tolerances - Part 1: Principles and basic data, MOD)
- GB/T 228 Metallic Materials - Tensile Testing at Ambient Temperature (GB/T 228 - 2002, eqv ISO 6892: 1998)
- GB/T 229 Metallic Materials-Charpy Notch Impact Test (GB/T 229 - 1994, eqv ISO 148: 1983, ISO 83: 1976)
- GB/T 230.1 Metallic Rockwell Hardness Test - Part 1: Test Method (scales A, B, C, D, E, F, G, H, K, N, T) (GB/T 230.1 - 2004, ISO 6508-1: 1999, Metallic materials - Rockwell hardness test - Part 1: Test method, MOD)
- GB/T 699 Quality Carbon Structural Steels
- GB/T 1237 Designation System for Fasteners (GB/T 1237 - 2000 eqv ISO 8991: 1986)
- GB/T 3077 Alloy Structure Steels
- GB/T 3098.1 Mechanical Properties of Fasteners-Bolts, Screws and Studs (GB/T 3098.1 - 2000, idt ISO 898-1: 1999)
- GB/T 3098.2 Mechanical Properties of Fasteners - Nuts - Coarse Thread (GB/T 3098.2 - 2000, idt ISO 898-2: 1992)
- GB/T 3103.1 Tolerances for Fasteners - Bolts, Screws, Studs and Nuts (GB/T 3103.1 - 2002, idt ISO 4759-1: 2000)
- GB/T 3103.3 Tolerances for Fasteners-Plain Washers (GB/T 3103.3 - 2002, idt ISO 4759-3: 2000)

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