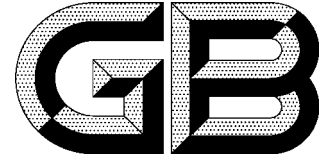


ICS 77.150.30
H 62



National Standard of the People's Republic of China

GB/T 20928—2007

Seamless inner grooved copper tube

Issue date 2007-04-30

Implementation date 2007-11-01

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

National Standard of the People's Republic of China
Seamless inner grooved copper tube
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NUBN: 155066 • 7-29807

Foreword

This standard is established combining Chinese inner grooved copper tube current conditions. The dimension and tolerance of this Standard refers to the technical requirements for seamless inner grooved copper tube of Kobe, Sumitomo and Hitachi etc, and finally confirmed by comprehensively considering the main new fin and specification for inner grooved copper tube. Other technical requirements refer to EN 12735-02: 2001 *Copper and Copper Alloy Seamless Round Tubes for Air Conditioning and Refrigeration*, JIS H 3300—2006 *Copper and Copper Alloy Seamless pipes and tubes* and ASTM B280-03 *Seamless Copper Tube for Air Conditioning and Refrigeration Field Service*.

Annexes A and B in this Standard are normative Annexes.

Annex C in this standard is informative Annex.

This standard was proposed by China Nonferrous Metals Industry Association.

This standard is under the jurisdiction of China National Non-Ferrous Metals Standardization Technical Committee.

This standard was drafted by Golden Dragon Precise Copper Tube Group Inc. , Gao Xin Zhang Tong Corporation and Zhejiang Hailiang Corporation.

Major drafters of this standard are Li Changjie, Guo Zhaoxiang, Feng Hailiang, Zhang Jinli, Wei Bi, Cao Jianguo, Liu Aikui, Wang Xiangdong, Yang Cunli, Wang Hu, Ma Junhuan.

Technical Committee of China National Non-Ferrous Metals Standardization is subject to the explanation of this standard.

Seamless inner grooved copper tube

1 Scope

This standard specifies the technical requirements, testing methods, inspection rules, packaging, marking, transportation and storage for seamless inner grooved copper tubes.

This standard is applicable to seamless inner grooved copper tube for air-conditioning and refrigeration.

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this national standard. For dated reference, subsequent amendments (excluding correction of error) to, or revisions of, any of these publications do not apply. However, parties to agreements based on this national standard are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies.

GB/T 228 Metallic Materials—Tensile testing at ambient temperature

GB/T 242 Metallic materials—tube Drift expanding test

GB/T 2828.1 Sampling procedures for inspection by attributes—Part 1: Sampling schemes indexed by Acceptance of Quality Limit (AQL) for lot-by-lot inspection

GB/T 5121 Methods for chemical analysis of copper and copper alloys

GB/T 5231 Wrought copper and copper alloys chemical composition limits and forms of wrought products

GB/T 5248 Copper and copper alloy seamless tubes-Eddy-current testing method

GB/T 8888 Wrought heavy non-ferrous metal products-Packing, marking, transporting and storing

YS/T 347 Copper and copper alloy-Estimation of average grain size

3 Terms and definitions

The following terms and definitions are applicable to this Standard.

3.1

seamless inner grooved copper tube

The tubes shall be smooth on outside surface with regular groove of certain numbers on the inside surface and continuously circled at section area.