



# 检验报告

## Testing Report

报告编号: 2019X-0099

样品名称: 迷你丁烷气瓶

规格型号: BDP-120-JR (SZ)

生产单位: 岩谷气具(珠海)有限公司

委托单位: 岩谷气具(珠海)有限公司

检验类别: 型式检验

中国市政工程华北设计研究总院有限公司城市燃气热力研究院





中国市政工程华北设计研究总院有限公司城市燃气热力研究院



2018X-0096

### 产品质量检验报告

样品名称	迷你丁烷气瓶	标注商标	岩谷
检验类别	型式检验	来样方式	送样
样品编号	2019X-0099	规格型号	BDP-120-JR (SZ)
样品数量	25个	出厂编号	/
到样日期	2019年7月23日	检讫日期	2019年8月15日
生产单位	岩谷气具(珠海)有限公司		
委托单位	岩谷气具(珠海)有限公司		
检验依据	Q/IWA 2-2017《迷你丁烷气瓶》		
判定依据	Q/IWA 2-2017《迷你丁烷气瓶》		
检验结论	<p>经检验, 所检项目符合标准要求, 检验结论为合格。</p> <p>本报告仅对该样品负责, 检验数据见后。</p> <p>报告有效期限: 壹年</p> <p>报告签发日期: 二〇一九年八月十五日</p> <div style="text-align: center;"> </div>		
备注	报告中“/”表示无此项或此项不适用, “——”表示此项不检验。		

批准:

审核:

主检:

一、检验样品简介:

样品名称:	迷你丁烷气瓶
填充气体:	丁烷气
填充质量:	120g

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二、检验数据

检验项目		标准要求	检验结果																		
			1	2	3	4	5	6	7	8	9	10	11	12	13						
气密性		在55℃水中110s, 应无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	
标志		标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	
气瓶及阀门尺寸		瓶体高度	120.04mm	120.14mm	119.94mm	119.90mm	119.96mm	119.94mm	119.94mm	120.14mm	120.14mm	119.94mm	119.94mm	120.14mm	120.14mm	120.14mm	120.14mm	120.14mm	120.14mm	119.90mm	
		瓶体外径	65.74mm	65.72mm	65.70mm	65.74mm	65.74mm	65.74mm	65.74mm	65.74mm	65.74mm	65.74mm	65.74mm	65.74mm	65.74mm	65.74mm	65.74mm	65.74mm	65.74mm	65.74mm	65.74mm
		瓶下缘外径	65.28mm	65.22mm	65.20mm	64.98mm	64.94mm	64.94mm	64.98mm	64.94mm	64.94mm	64.94mm	64.94mm	64.98mm	64.98mm	64.94mm	64.94mm	64.94mm	64.94mm	64.94mm	64.98mm
		瓶上缘外径	63.14mm	63.20mm	63.20mm	63.12mm	63.10mm	63.14mm	63.12mm	63.14mm	63.12mm	63.12mm	63.14mm	63.10mm	63.20mm	63.12mm	63.12mm	63.14mm	63.14mm	63.14mm	63.08mm
		阀门外径	44.44mm	44.42mm	44.40mm	44.34mm	44.34mm	44.36mm	44.34mm	44.36mm	44.36mm	44.36mm	44.36mm	44.36mm	44.42mm	44.36mm	44.34mm	44.34mm	44.34mm	44.34mm	44.34mm
		阀杆高度	5.80mm	5.74mm	5.98mm	5.96mm	5.98mm	5.92mm	5.96mm	5.92mm	5.96mm	5.96mm	5.92mm	5.96mm	5.96mm	5.96mm	5.96mm	5.96mm	5.96mm	5.96mm	5.96mm
		阀杆外径	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm
		阀杆长	7.56mm	7.52mm	7.46mm	7.42mm	7.46mm	7.46mm	7.42mm	7.46mm	7.46mm	7.46mm	7.46mm	7.46mm	7.24mm	7.22mm	7.22mm	7.22mm	7.22mm	7.22mm	7.22mm
		凸台外径	10.60mm	10.54mm	10.52mm	10.54mm	10.58mm	10.54mm	10.54mm	10.54mm	10.54mm	10.54mm	10.54mm	10.58mm	10.60mm	10.60mm	10.60mm	10.60mm	10.60mm	10.60mm	10.54mm
		阀切口宽度	10.00mm	10.00mm	10.00mm	10.02mm	10.04mm	10.04mm	10.02mm	10.04mm	10.04mm	10.04mm	10.04mm	10.04mm	10.04mm	10.04mm	10.04mm	10.04mm	10.04mm	10.04mm	10.00mm
阀门行程尺寸		最大行程	1.7~4.0mm	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	
初喷行程		0.2~1.0mm	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	
灌装量误差		-2.0%~+1.0% (额定灌装量120g)	-1.47%	-1.67%	-1.47%	-1.57%	-1.63%	-1.57%	-1.57%	-1.57%	-1.57%	-1.57%	-1.43%	-1.48%	-1.55%	---	---	---	---	---	
气瓶容积		4285ml	299.7mL	299.7mL	299.7mL	299.7mL	299.7mL	299.7mL	299.7mL	299.7mL	299.7mL	299.7mL	299.8mL	299.7mL	299.7mL	299.7mL	299.7mL	299.7mL	299.7mL	299.7mL	
耐压性		变形及泄漏	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	
密封性能		破裂	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	
		-10℃	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---
		+40℃	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---
		-10℃	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---
C <sub>4</sub> H <sub>10</sub> 含量		C <sub>4</sub> H <sub>10</sub> 含量>95%	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---
丁烷气异味		空气中有1/1000丁烷气时即可嗅出异味	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---
阀杆压缩力		12~20N	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---
振动试验		10Hz的频率, 全振幅5mm, 上下、左右各30min后应无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏
耐用性		每秒钟一次的速度, 把阀杆压缩到最大行程, 100次无泄	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---



二、检验数据 (续)

检验项目	标准要求	检验结果														单项判定	
		14	15	16	17	18	19	20	21	22	23	24	25				
气密性	在水中110s, 应无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	合格
标志	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	标志齐全	合格
气瓶及阀门尺寸	瓶体高度	120.04mm	119.94mm	119.90mm	119.94mm	119.96mm	119.94mm	119.94mm	119.94mm	119.94mm	119.94mm	119.94mm	119.94mm	120.14mm	120.14mm	120.14mm	合格
	瓶体外径	65.74mm	65.82mm	65.70mm	65.70mm	65.70mm	65.70mm	65.70mm	65.70mm	65.70mm	65.74mm	65.74mm	65.74mm	65.74mm	65.74mm	65.80mm	合格
	瓶下缘外径	65.22mm	65.20mm	65.28mm	65.28mm	65.28mm	65.28mm	65.28mm	65.28mm	65.28mm	64.98mm	64.98mm	64.98mm	64.98mm	64.94mm	64.86mm	合格
	瓶上缘外径	63.14mm	63.14mm	63.14mm	63.14mm	63.14mm	63.14mm	63.14mm	63.14mm	63.14mm	63.12mm	63.12mm	63.12mm	63.12mm	63.12mm	63.14mm	合格
	阀门外径	44.42mm	44.40mm	44.40mm	44.40mm	44.40mm	44.40mm	44.40mm	44.40mm	44.40mm	44.34mm	44.34mm	44.34mm	44.34mm	44.36mm	44.34mm	合格
	阀杆高度	5.80mm	5.74mm	5.74mm	5.74mm	5.74mm	5.74mm	5.74mm	5.74mm	5.74mm	5.98mm	5.98mm	5.98mm	5.98mm	5.98mm	5.98mm	合格
	阀杆外径	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	4.00mm	合格
	阀杆长	7.2±0.5mm	7.46mm	7.56mm	7.56mm	7.56mm	7.56mm	7.56mm	7.56mm	7.56mm	7.22mm	7.22mm	7.22mm	7.22mm	7.22mm	7.22mm	合格
	凸台外径	10.5~10.8mm	10.60mm	10.52mm	10.52mm	10.52mm	10.52mm	10.52mm	10.52mm	10.52mm	10.60mm	10.60mm	10.60mm	10.54mm	10.54mm	10.60mm	合格
	阀切口宽度	10.3±0.3mm	10.00mm	10.00mm	10.00mm	10.00mm	10.00mm	10.00mm	10.00mm	10.00mm	10.04mm	10.04mm	10.04mm	10.04mm	10.00mm	10.04mm	合格
阀门行程	最大行程 初喷行程	1.7~4.0mm 0.2~1.0mm	---	---	---	---	---	---	---	---	3.12mm	3.12mm	3.18mm	3.46mm	3.22mm	合格	
灌装量误差	-2.0%~+1.0% (额定灌装量120g)	---	---	---	---	---	---	---	---	---	---	---	---	0.82mm	0.78mm	合格	
气瓶容积	≤285ml	---	---	---	---	---	---	---	---	---	---	---	---	---	---	合格	
耐压性	变形及泄漏	无变形 无泄漏	无变形 无泄漏	无变形 无泄漏	无变形 无泄漏	无变形 无泄漏	无变形 无泄漏	无变形 无泄漏	无变形 无泄漏	无变形 无泄漏	无变形 无泄漏	无变形 无泄漏	无变形 无泄漏	无变形 无泄漏	无变形 无泄漏	合格	
	破裂	无破裂	无破裂	无破裂	无破裂	无破裂	无破裂	无破裂	无破裂	无破裂	无破裂	无破裂	无破裂	无破裂	无破裂	无破裂	合格
密封性能	瓶体	---	---	---	---	---	---	---	---	---	---	---	---	---	---	合格	
	阀杆	---	---	---	---	---	---	---	---	---	---	---	---	---	---	合格	
C <sub>4</sub> H <sub>10</sub> 含量	瓶体	---	---	---	---	---	---	---	---	---	---	---	---	---	---	合格	
	阀杆	---	---	---	---	---	---	---	---	---	---	---	---	---	---	合格	
丁烷气异味	空气中有1/1000丁烷气时即可嗅出异味	---	---	---	---	---	---	---	---	---	---	---	---	---	---	合格	
阀杆压缩力	12~20N	---	---	---	---	---	---	---	---	---	---	---	---	---	---	合格	
振动试验	10Hz的频率, 全振幅5mm, 上下、左右各30min后应无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	无泄漏	合格	
耐用性	每秒钟一次的速度, 把阀杆压缩到最大行程, 100次无泄	---	---	---	---	---	---	---	---	---	---	---	---	---	---	合格	

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