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

DL/T 1964-2019

**Ring type distribution machine
(English Translation)**

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009 "Guidelines for Standardization Work Part 1: Standard Structure and Compilation".

Please note that certain contents of this document may involve patents. The issuing agency of this document is not responsible for identifying these patents.

This standard was proposed by the China Electricity Council.

This standard is under the jurisdiction of the Electric Power Industry Standardization Technical Committee for Coal-fired Machinery.

The organizations responsible for drafting this standard. Huadian Zhengzhou Machinery Design & Research Institute Co., Ltd., China Huadian Science and Industry Group Co., Ltd.

1 Scope

This standard specifies the type, basic parameters, technical requirements, test methods, inspection rules, signs, packages of circular silo ring distributors Loading, transportation and storage.

This standard applies to circular silo ring distributors with a diameter of 30m and above.

2 Normative references

The following documents are indispensable for the application of this document. For dated reference documents, only the dated version applies to this document.

For undated references, the latest version (including all amendments) applies to this document.

GB/T 191 Packaging, storage and transportation pictorial signs GB/T 231.1 Brinell hardness test of metallic materials Part 1: Test method GB/T 699 High-quality carbon structural steel GB/T 700 carbon structural steel GB/T 708 Size, shape, weight and allowable deviation of cold rolled steel plate and steel strip GB/T 709 Hot-rolled steel plate and strip size, shape, weight and allowable deviation GB/T 985.1 Recommended grooves for gas welding, electrode arc welding, gas shielded welding and high energy beam welding GB/T 985.2 Recommended groove for submerged arc welding GB/T 1184-1996 shape and position tolerance without tolerance value GB/T 1348 Ductile iron castings GB/T 1591 Low-alloy high-strength structural steel GB/T 1801 Geometric Technical Specifications for Products (GPS) Limits and Fitting Contour Method Tolerance Zones and Fitting Selection GB/T 1804 General Tolerance Tolerance of linear and angular dimensions without tolerance GB/T 3323 Radiography of metal fusion welding welded joints GB 4053 Safety requirements for fixed steel ladders and platforms GB/T 5117 Non-alloy steel and fine grain steel electrode GB/T 5118 hot-strength steel electrode GB/T 8110 Carbon steel and low alloy steel welding wire for gas shielded arc welding GB/T 8923.1 Visual assessment of surface cleanliness of steel plate surface treatment before coating. Part 1: Uncoated steel surface and the rust grade and treatment grade of the steel surface after the original coating is completely removed GB/T 9286 Cross-cut test of paint and varnish film GB/T 10045 Carbon steel flux cored welding wire GB/T 10595 belt conveyor GB/T 13306 signs GB/T 13384 General technical conditions for packaging of mechanical and electrical products GB/T 13452.2 Determination of paint film thickness of paints and varnishes GB 14784 Safety Code for Belt Conveyor GB/T 19804 General dimensional tolerances and geometric tolerances of welded structures GB 20426 Pollutant Emission Standard for Coal Industry GB 50034 Architectural Lighting Design Standard GB 50055 General Electric Equipment Power Distribution Design Code GB 50431 Engineering Design Code for Belt Conveyor GB/T 50549 Coding Standard for Power Plant Identification System GBZ 1 Hygienic Standard for Design of Industrial Enterprises DL/T 678-2013 General technical conditions for welding power steel structures JB/T 5000.6 General technical conditions for heavy machinery Part 6: Steel castings JB/T 5000.12 General technical conditions for heavy machinery Part 12: Painting JB/T 6392 crane wheel NB/T 47013.1~47013.6 Non-destructive testing of pressure equipment

3.1 Type expression method

The type expression method of the ring cloth machine is as follows.

3.3 Basic parameters

3.3.1

The basic parameters of the ring cloth machine should be given priority to the values specified in Table 1.

3.3.2

The combination of the rated productivity of the ring cloth machine and the belt speed and bandwidth shall be given priority to the values specified in Table 2.

4.1 General requirements

4.1.1

The technical requirements of the ring cloth machine shall meet the requirements of this standard, and shall be prepared in accordance with the drawings and technical documents approved by the prescribed procedures.

The rated production capacity should meet the label requirements.

4.1.2

Outsourcing accessories should meet the corresponding product standards and have product inspection certificates.

4.1.3

The belt conveyor should meet the requirements of GB/T 10595, GB/T 14784, and GB/T 50431.

4.1.4

The rotating parts can rotate flexibly without jamming. The lubrication part is well sealed, and there is no grease leakage. Bearing temperature rise is not more than 40°C, bearing temperature does not exceed 80°C.

4.1.5

The sealing cover of the belt conveyor should be provided with an observation door.

4.2 Materials

4.2.1

The materials of the main structural parts and parts should be certified by the manufacturer.

4.2.2

The performance of carbon structural steel for steel structure should meet the requirements of GB/T 700; the performance of low-alloy structural steel should meet the requirements of GB/T 1591;

The performance of high-quality carbon structural steel should meet the requirements of GB/T 699.

4.2.3

All important parts of the castings are not allowed to have sand holes and pores that affect

the strength, and the total area of the sand holes and pores on the secondary parts is not allowed to exceed More than 5% of the defect area, the depth of the recess should not exceed 1/5 of the wall thickness at this place, and the defect on each casting should not exceed 3 places.

4.3 Welding

4.3.1

The welding rod, wire and flux should be compatible with the material to be welded, and the manufacturer's certificate of conformity should be provided.

4.3.2

The welding rod shall meet the requirements of GB/T 5117 or GB/T 5118.

4.3.3

The welding wire should meet the requirements of GB/T 10045 or GB/T 8110.

4.3.4

The weld must meet the requirements of GB/T 985.1 or GB/T 985.2.

4.3.5

Classification of welds of steel structures.

a) Belt conveyor frame, drive frame, head and tail frame, walking trolley frame, support, base, pin tooth support of slewing support device, Components such as sealing truss shall be Type II welded components.

b) The belt conveyor head, tail funnel, sealing cover, dust hopper and other parts should be three types of welded seam components.

4.3.6

The inspection items, inspection scope and standards to be implemented for various welds are shown in Table 3.

4.4 Steel structure

4.4.1

The steel plate and section steel punching and shearing parts should be deburred.

4.4.2

The size, shape and allowable deviation of the steel plate shall meet the requirements of GB/T 708 and GB/T 709.