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

GB 24911-2010

Bowl-coupler type steel tube scaffolding member

碗扣式钢管脚手架构件

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Foreword

5.6 technical content of this standard is mandatory, the remaining provisions are recommended. The standard proposed by the Ministry of Housing and Urban-Rural Development of the People's Republic of China. This standard is under the jurisdiction of the Ministry of Housing and Urban Construction Engineering standard technical focal point. This standard is drafted by: China Academy of Building Research. Participated in the drafting of this standard. Datong Coal Mine Group, Hing Win Steel Plant, State Construction Engineering Quality Supervision and Inspection Center, China Construction Metal Structure Association Building fasteners Committee, Langfang Construction Machinery Co., Ltd. Kaibo. The main drafters of this standard. Wang Feng, Zhang Shulin, inexpensive into the lake, Sun Yi Ling, Guo Yu increase, Wei East. Bowl button steel scaffold member

1 Scope

GB 24911-2010 is the Chinese national standard on bowl-coupler type steel tube

scaffolding member, in the field of construction materials and building. It carries no /T suffix, which in the Chinese system means compliance is mandatory: a product or a practice within its scope has to meet it to be lawfully made, sold or carried out in China. It was issued on 9 August 2010 by the General Administration of Quality Supervision, Inspection and Quarantine of the People's Republic of China; Standardization Administration of China, and has been in force since 1 June 2011. Classification: ICS 91.220, CCS P97. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This standard specifies the terms and definitions bowl button steel scaffold member, classification, requirements, test methods, inspection rules, marking, packaging, Transport and storage. This standard applies to the construction of production bowl button steel scaffold member Cuplock steel scaffolding, templates and other supporting frames used And testing. Also used in municipal, water, chemicals, coal and ships used in the project Cuplock steel scaffolding member. Round button, the disc Type, and other plug-in steel scaffolding member can refer to these standards.

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 700 carbon structural steel

GB/T 2828.1 Sampling procedures for inspection - Part 1. by acceptance quality limit (AQL) retrieval batch inspection sampling plan

GB/T 3091 low pressure liquid delivery welded steel pipe

GB/T 5117 carbon steel electrode

GB/T 5796.2 trapezoidal thread - Part 2. The diameter of the thread series

GB/T 5796.3 trapezoidal threads - Part 3. Basic dimensions

GB/T 5796.4 trapezoidal thread - Part 4. Tolerances

GB/T 6414 casting dimensional tolerances and machining allowances

GB/T 9440 Malleable Iron Castings

GB/T 11352 Carbon steel castings for general engineering purposes Steel Engineering

Construction Quality Acceptance GB 50205

3 Terms and Definitions

The following terms and definitions apply to this standard.

- 3.1 On Bowl belshapecap Pole along the slide from the locking action Bowl node parts.
- 3.2 Under Bowl bowlshapeshocket Bowl-shaped parts are welded to the pole on the node.
- 3.3 Pole standingtube Scaffolding vertical bearing rod.
- 3.4 Crossbar flattubecross Scaffolding horizontal rod bearing.
- 3.5 Jack crowntube When using the interpolated sleeve, the top pole no connection sleeve.
- 3.6 Diagonal rod slantingsupport Ends with diagonal bars rotary joint.
- 3.7 Bearing supports A fixed base, adjustable base and fixed support bracket, adjustable bracket support collectively.
- 3.8 Adjustable base jacksupport Plugged up in the lower end of the pole, the upper load distributing passed to the foundation, and can adjust the height of the component.
- 3.9 Adjustable bracket support u-jack Inserted in the upper end of the pole, following the upper load, and adjust the height of the component.
- 3.10 Bowl node cuplockjoint Solid-type socket cover by the upper node Bowl, Bowl under, limit pin and rail joints and the like.
- 3.11 From the pole, jack, bar, tilt rods, bearings, composed of member nodes, etc. Bowl. Category 4

4.1 member type and member names, see Figure 1. Schematic diagram of the type 1 member

4.2 Main parameters and series Member of the main parameters for the length of the member. Series main parameters are shown in Table 1. Table

4.3 Code Group Code. WKJ

- cuplock steel scaffolding. Type code. SWK
- the Bowl; XWK
- Under Bowl; LG
- crossbar; XG
- Diagonal rod; KTZ
- adjustable stand; KTC

--- adjustable bracket support. Main parameters Code. A member expressed nominal length 1/10. Update code variants. either uppercase phonetic alphabet.

4.4 Model Group Code. WKJ - - Type code. LG

--- crossbar; XG

--- oblique rod; KTZ

--- adjustable base; KTC

--- adjustable support bracket Main parameters Code. nominal length with member representation 1/

10 Update code variants. phonetic alphabet is represented by uppercase

4.5 tag example.

- a) nominal length of 3000mm, the first variant of the updated Cuplock steel scaffolding pole.
- b) The nominal length of 300mm, the second variant updated Cuplock steel scaffolding crossbar.

5 Requirements

5.1 product design and structural calculations should be consistent with national safety specifications. Product according to prescribed procedures approved by the drawings and technical documents manufacture.

5.2 Material

5.2.1 raw materials qualified certificate and quality assurance, and product design in line with regulations.

5.2.2 The mechanical properties of steel shall comply with GB/T 3091 in the Q235.

5.2.3 Bowl material when using carbon steel or cast iron, its mechanical properties shall conform to GB/T 11352 in ZG270-500 Grades and GB/T 9440 in KTH350-10 grade requirements.

5.2.4 Under the bowl - use carbon steel manufacturing, its mechanical properties should be consistent with the provisions of GB/T 11352 in ZG270-500 grades using When steel stamping, the material shall comply with GB/T 700 in Q235, the plate thickness not less than 6mm, and dried (600 ~ 650) °C Aging treatment. Waste should not be used rusting steel restructuring.

5.2.5 rail joints, tilt-rod joints should be used carbon steel, its mechanical properties should be consistent with GB/T 11352 in ZG270-500 grades Provisions.