



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

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**Code for construction and acceptance of conveyor equipment
installation engineering**

输送设备安装工程施工及验收规范

(English Translation)

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equipment installation engineering, promote the technological progress, ensure the engineering quality and safety and improve the economic performance.

1.0.2 This code applies to the construction and acceptance of the installation engineering of belt conveyor, slat conveyor equipment, vertical bucket elevator, screw conveyor, roller conveyor, overhead conveyor, vibrating conveyor, en-masse conveyer, pneumatic conveyor as well as mine hoist and winch.

1.0.3 In addition to this code, the construction and acceptance of conveyor equipment installation engineering still shall be in accordance with those specified in the current relevant national standards.

4.1 Slat Conveyer

4.1.1

The assembling of frame shall meet the following provisions.

- 1 The deviation in the horizontal positions of the center line of frame and the longitudinal center line of conveyor shall not be larger than 2mm.
- 2 The straightness deviation of the center line of frame shall not be larger than 1/1000.
- 3 The difference in the length of these two diagonal lines of the cross section of frame shall not be larger than 1 per mille of the average length of these two diagonal lines or 10mm.
- 4 The deviation in the verticality of the frame to the building floor shall not be larger than 2/1000.

4.1.2

The assembling of guide tracks shall meet the following provisions.

- 1 The deviation in the horizontal positions of longitudinal center line between guide tracks and the longitudinal center line of conveyor shall not be larger than 1mm.
- 2 The permissible deviation of the track gauge is $\pm 2\text{mm}$.
- 3 The joints of guide tracks shall be flat and smooth, their displacement towards right or left shall not be larger than 0.2mm, and the difference of their height shall not be larger than 1mm.
- 4 The gap at joint shall not be larger than 2mm.
- 5 The guide surface shall be smooth and its verticality deviation shall not be larger than 10/1000.

4.1.3

The assembling the tension apparatus of cast car type conveyor shall meet the following provisions.

- 1 The joint of the traveling rail with the trapped rail shall be flat and smooth, their offset towards right or left shall not be larger than 1mm, and the difference of height shall not be

larger than 0.3mm.

2 The joint of the traveling guide track with the trapped guide track shall be flat and smooth, their displacement towards right or left shall not be larger than 0.2mm, and the difference of height shall not be larger than 1mm.

3 The sliding block of tension apparatus shall match with the slide track well, and their local gap shall not be larger than 1mm.

4.2 Light-duty Slat Feeder

4.2.1

The deviation in the longitudinal straightness of the main beam of frame shall not be larger than 1/1000; the difference in the diagonal lines of the frame shall not be larger than

8 Overhead Conveyer

8.0.1

The assembling of metal member shall meet the following provisions.

1 The verticality deviation of the hanger or upright column shall not be larger than 1/1000.

2 The levelness deviation of cantilever shall not be larger than 3/1000.

3 The deviation in the vertical and lateral levelness of the platform shall not be larger than 3/1000.

4 The offset of the longitudinal center line at the supporting point of track to the longitudinal center line of conveyer shall not be larger than 3mm.

8.0.2 When laying the track for universal overhead conveyors, the following provisions

shall be met.

1 The straightness deviation of the track within the straight segment shall not be larger than 3mm within any length of 6000mm and shall not be larger than 7mm within the full length.

2 The distortion of track within the straight segment shall not be larger 1% of the orbit altitude within any length of 6000mm.

3 The distortion of vertical curved track shall not be larger than 2% of the orbit altitude.

4 The distortion of horizontal curved track shall not be larger than 1.5% of the orbit altitude.

5 The height difference and transverse misalignment of the seating face at joint of track shall not be larger than 0.5mm.

8.0.3 When laying the track for power and free overhead conveyors, the following provisions shall be met.

1 The straightness deviation of single straight track shall not be larger than 1.5mm within any length of 1000mm and shall not be larger than 5mm within the full length.

2 The deviation in the degree of symmetry between the center line of traction rail and the center line of bearing rail shall not be larger than 1mm.

3 The distortion of straight track, horizontal curved track and vertical curved track at their both end faces shall not be larger than 1.3% of the orbit altitude.

4 The height difference and transverse misalignment of the seating face at joint of track shall not be larger than 0.5mm, and the gap at the joint shall not be larger than 1mm.

8.0.4 When laying the track for enclosed-track power and free overhead conveyors, the following provisions shall be met.

1 The straightness deviation of track shall not be larger than 2.5mm within any length of 1000mm and shall not be larger than 6mm within any length of 6000mm.

2 The deviation in the degree of symmetry between the center line of traction rail and the center line of bearing rail shall not be larger than 1mm.

3 The deviation in height of the wheel tread at outlet and inlet of curved track shall not be larger than 3mm.

8.0.5 When laying the track for overhead electrical monorail conveyors, the following

provisions shall be met.

1 The straightness deviation of track shall not be larger than 0.8/1000 and shall not be larger than 30mm.

2 The verticality deviation of track shall not be larger than 1% of the orbit altitude.

3 The distortion of track in straight segment shall not be larger than 0.5% of the orbit altitude within any length of 3000mm.

4 The distortion of curved track shall not be larger than 1.5% of the orbit altitude.

5 The misalignment of track at the joint shall not be larger than 1mm and the gap at the joint shall not be larger than 2mm.