



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

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**Code for construction and acceptance of crushing and grinding
equipment installation engineering**

破碎、粉磨设备安装工程施工及验收规范

(English Translation)

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1.0.1

This code is established in order to improve the construction level of crushing and grinding equipment installation engineering, promote technological progress, ensure engineering quality and safety and improve economic benefit.

1.0.2

This code is applicable to the construction and acceptance of crushing and grinding equipment installation engineering for minerals, coal, fire retardant materials, building materials, chemical materials, food, fodder and medicinal materials.

1.0.3

Except meeting this code, the construction and acceptance of crushing and grinding equipment installation engineering shall also be in accordance with the provisions of current relevant national standard.

6.0.1

The crosser laid on the foundation of roll crusher shall be in accordance with the specification of engineering design or accompanying technical document.

6.0.2

The installation level of frame shall be inspected by longitudinally and transversely placing level meter on frame, and shall not be larger than 0.20/1000.

6.0.3

When assembling sliding bearing, the bushing and spherical face tile shall be carried out with re-scrape, and shall be in accordance with the following requirements.

- 1 The contact angle of bushing and journal should be $100^{\circ}\sim 120^{\circ}$;
- 2 For the contact point number on contact face, the brasses shall not be less than 3 and the bearing metals tile shall not be less than 2 in each 25mmx25mm area;
- 3 The top gap between bushing and journal should be 1 per thousand~1.5 per thousand of journal diameter; the side gap should be 50%~70% of top gap;
- 4 The contact area of spherical face tile shall not be less than 60% of total area of spherical face tile and shall be concentrated on middle position; the contact point number on contact face shall not be less than 2 in each 25mmx25mm area.

6.0.4

The roller assembling shall meet the following requirements.

- 1 The gap between rolls shall not be larger than 5mm, and the gap difference shall not be larger than 1mm;
- 2 The axial misalignment of two rolls shall not be larger than 3mm;
- 3 The parallel deviation of axis of movable roll and fixed roll shall not be larger than 0.20/1000, and the stress of spring at both sides shall be uniform.

6.0.5

When assembling gear roller, the cusp of roller shall collimate the tooth socket of another roller.

6.0.6

After V belt wheel installation, the relative displacement of symmetrical plane of wheel width shall not be larger than 2 per thousand of central distance, and the tightness degree of each root V belt shall be consistent.

7.0.1

For the installation level of machine base, the transverse shall not be larger than 0.10/1000, and the longitudinal shall not be larger than 0.50/1000.

7.0.2

The parallel deviation of rotor body for machine base and upper frame body joint surface shall not be larger than 0.20/1000, and the installation level of major axis shall not be larger than 0.10/1000.

7.0.3

The gap between hammerhead top of rotator and grid section and between grid sections shall be in accordance with the specification of accompanying technical document.

During detection, the hammerhead shall be fixed on arm disc of rotator with wedge, the movable arm of disc shall be in any position to make each hammerhead vertical with major axis, after that, the gap between both shall be inspected.

7.0.4

When assembling sliding bearing, the bushing shall be carried out with re-scrape, and the coordination of bushing and journal shall be in accordance with the following requirements.

- 1 The contact angle should be 80°~100°;
- 2 The contact point number on contact face shall not be less than 3 in each 25mmx25mm area;
- 3 The side gap should be 1 per thousand~1.2 per thousand of journal diameter;
- 4 The top gap shall be 1.5 times of side gap.

7.0.5

The hammerhead on rotator shall not be dismantled, if necessary, it shall be assembled according to indicated mark by manufacturer.

7.0.6

The sealing of joint between upper and lower frames and joint between all door covers and frame shall be tight without leak.

4 When the sleeve shaft diameter is larger than 2200mm, the sum of side gaps of both sides should be 1.5 per thousand~2 per thousand of journal diameter of sleeve shaft.

9.1.7

After journal metal and bearing seat assembling, the cooling water system shall be tested with 0.5MPa water pressure, and the pressure shall be maintained with 10min, and then without leakage.

9.1.8

The oil pipe channel of hydraulic oil of journal metal shall be tested with 32MPa oil pressure after assembling; the pressure shall be maintained with 5min, and then without leakage.

9.2.1

The drum and end cover shall be inspected before assembling; the straightness deviation of drum surface shall not be larger than 1 per thousand of total length of drum, and the roundness deviation of both ends of drum shall not be larger than 1.5 per thousand of drum diameter.

9.2.2

When assembling drum and end cover, the joint surface shall be cleaned first, and then coated with antirust and sealing material; the contact of joint surface shall be tight without adding any adjusting gasket.

9.2.3

The drum and end cover shall be assembled according to mark, the alignment pin must be fully loaded, and the bolts shall be uniformly tightened up after meeting assembling requirements.