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

GB/T 10596-2021

En-masse conveyor

埋刮板输送机

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Table of Contents

- 1 Scope
- 2 Normative references
- 3 Terms and Definitions

Foreword

This document is in accordance with the provisions of GB/T 1:1-2020 "Guidelines for Standardization Work Part 1: Structure and Drafting Rules of Standardization Documents" drafted: This document replaces GB/T 10596-2011 "Buried Scraper Conveyor": Compared with GB/T 10596-2011, except for editorial changes, the main The technical content changes are as follows:

- Added examples of materials with special physical properties (see Chapter 1);
- Modified the relevant content of normative references (see Chapter 2, Chapter 2 of the:2011 edition);
- Added terms and definitions chapter (see Chapter 3);
- The type and basic parameters are combined into Chapter 4 (see Chapter 4, Chapter 3 and Chapter 4 of the:2011 edition);
- Modify the vertical type to C type (see Table 1, etc., Table 1 of the:2011 edition);
- Modified the temperature range of the hot material type conveyor and increased the high temperature type conveyor (see Table 2, Table 2 of the:2011 edition);
- Modified the description of toxic permeable materials (see Table 2, Table 2 of the:2011 edition);
- Delete the model representation method (see 3:4 of the:2011 edition);
- Added two machine slot widths of 1400mm and 1600mm (see Table 3, Table 9 and Table 11);
- Revised the provisions for the height of the bearing machine slot, and changed it to the bearing height series of the machine slot (see Table 4, Table 4 of the:2011 edition);
- Added the content of welded structure bending plate chain for engineering (see 4:2:3:2);
- Added the nominal speed of 0:05m/s and 1:25m/s scraper chain (see Table 5, 4:3 of the:2011 edition);
- Added the relevant content of the chain pitch (see 4:2:5);

1 Scope

GB/T 10596-2021 is the Chinese national standard on en-masse conveyor, in the field of materials handling equipment. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 31 December 2021 by the State Administration for Market Regulation; Standardization Administration of China, and has been in force since 1 July 2022. Classification: ICS 53.040.10, CCS J81. 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 document specifies the type, basic parameters, technical requirements, test methods, inspection rules, signs, packaging and storage of buried scraper conveyors: This document applies to buried scraper conveyors that transport bulk materials: This document does not apply to buried scraper conveyors conveying the following bulk materials:

- a) highly corrosive materials;
- b) Materials with bulk density greater than 1.8t/m³;
- c) Materials with special physical properties such as adhesion, bonding, entanglement and agglomeration:

2 Normative references

The contents of the following documents constitute essential provisions of this document through normative references in the text: Among them, dated citations documents, only the version corresponding to that date applies to this document; for undated references, the latest edition (including all amendments) applies to this document:

GB/T 699-2015 High-quality carbon structural steel GB/T 985:

1 Recommended grooves for gas welding, electrode arc welding, gas shielded welding and high energy beam welding

GB/T 1184-1996 Shape and position tolerances are not marked with tolerance values

GB/T 3768 Acoustic sound pressure method to determine the sound power level and sound energy level of noise sources easy law

GB/T 7324-2010 General purpose lithium base grease

GB/T 8923:1-2011 Visual assessment of surface cleanliness of steel surface treatment before application of paint - Part 1: Uncoated The rust grade and treatment grade of the steel surface and the steel surface after comprehensive removal of the original coating

GB/T 9286-1998 Cross-cut test for paints and varnishes

GB/T 11352-2009 Cast carbon steel parts for general engineering GB/T 13306 Signs

GB/T 13384 General technical conditions for packaging of mechanical and electrical products

GB/T 15390 Welded structural bent plate chains, accessories and sprockets for engineering

GB/T 35017 Bulk material classification, symbols, performance and test methods for continuous handling equipment

JB/T 9154 Chains, scrapers and sprockets for buried scraper conveyors NB/SH/T 0587-2016 Molybdenum disulfide lithium base grease

3 Terms and Definitions

The terms and definitions defined in GB/T 35017 and the following apply to this document:

3:1 A conveyor that continuously transports bulk materials in a closed machine tank by the force of the scraper chain on the material and the internal friction of the material: 3:2