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CCS D92



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

GB/T 13343-2008

Replacing GB/T 13343-1992

Blast hole tricone rock bits

矿用三牙轮钻头

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Foreword

This Standard replaces GB/T 13343-1992 "Blast hole tricone rock bits". Compared with GB/T 13343-1992, the main changes of this Standard are as follows: - In the technical requirements, ADD the requirements for welding electrode, weld tensile strength and weld quality after the bit is assembled; - Further STANDARDIZE the content of test methods and inspection rules; - ADD the packaging requirements for bits; - CANCEL the color requirements for protective paint. This Standard was proposed by China Machinery Industry Federation. This Standard shall be under the jurisdiction of National Technical Committee on Mining Machinery of Standardization Administration of China (SAC/TC 88). Drafting organization of this Standard. Luoyang Mining Machinery Engineering Design and Research Institute Co., Ltd. Main drafters of this Standard. Zhou Shengyong, Guo Ming, Yang Xianli, Wang Yadong, Huang Jialin. The previous released version replaced by this Standard is as follows: - GB/T 13343-1992. Blast hole tricone rock bits

1 Scope

GB/T 13343-2008 is the Chinese national standard on blast hole tricone rock bits, in the field of mining and minerals. 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 9 July 2008 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 February 2009. Classification: ICS 73.100.10, CCS D92. 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 product classification, technical requirements, test methods, inspection rules and marking, packaging, transportation and storage of blast hole tricone rock bits. This Standard is applicable to air-cooled and gas pressure deslagging tricone bits (hereinafter referred to as bits). The bit is mainly used for piercing blast hole in metallurgy, coal, chemical engineering, building materials, mining, etc.

2 Normative references

The following documents contain the provisions which, through reference in this Standard, become the provisions of this Standard. For dated references, their subsequent amendments (excluding corrigendum) or revisions do not apply to this Standard. However, the parties who enter into agreement based on this Standard are encouraged to investigate whether the latest versions of these documents are applicable. For undated reference documents, the latest versions apply to this Standard.

GB 150-1998 Steel pressure vessels

GB/T 2527 Hard metal (carbide) inserts for mining and oil-field rock bits

GB/T 9253.1-1999 Threads on rotary shouldered connections for petroleum industry

3 Terms and definitions

For the purpose of this Standard, the following terms and definitions apply.

3.1 air-cooled and gas pressure deslagging bit A bit cools the bearings and removes the slag from the blast hole with compressed air

3.2 integrated bit A bit that is directly welded together by three jaws assembled with cones.

4 Product classification

4.1 According to assembly forms, bits can be divided into.

4.2 According to structural characteristics, bits are divided into steel tooth bits and inserted bits (see Table 1).

4.3 According to scope of use, bits are divided into 8 series (see Table 1).

5 Technical requirements

5.1 Bits shall comply with the requirements of this Standard and be manufactured in accordance with the drawings and technical documents approved by the prescribed procedures. Bit diameter D Diameter deviation Thread specification A B

5.2 The nozzle of bits is recommended to be assembled type.

5.3 When the bit is drilled into the water burst blast hole, the bit shall be provided with means to prevent mud from entering the bearing.

5.4 Cones and claws are made of alloy steel.

5.5 Die forgings are recommended for cones and jaw blanks.

5.6 The threaded joint body of separated bits is made of high-quality carbon steel or steel castings. Steel castings shall be free of cracks. After the surface is cleaned, it shall be smooth and flat. There shall be no defects such as shrinkage, burnt-on sand and slag, which affect the strength and appearance of the product.

5.7 Carbide teeth used in cone bits shall comply with the requirements of GB/T 2527.

5.14 The height tolerance of each cone to the end face of the shoulder of threaded joint of bits shall comply with the requirements of Table 5.

6 Test methods

6.1 The diameter of bits is measured with a measuring ring.

6.2 Inspection of the assembly quality of bits.

6.3 The running time of the test bench load test shall be not less than 4 h.

7 Inspection rules

7.1 Inspection classification The inspection is divided into factory-exit inspection and type inspection.

7.2 Factory inspection

7.3 Type inspection In any of the following cases, no less than 3 bits shall be taken on the test bench or at the site for type inspection.

7.4 Type inspection shall include all requirements of this Standard.

8 Marking, packaging, transportation and storage

8.1 The non-working end face of the threaded joint of each bit shall be printed with the following markings.

8.2 The connecting thread and nozzle seat hole shall be applied with anti-rust grease and

shall be protected.

8.3 In addition to connecting threads, the other surfaces of bits shall be painted with protective paint.

8.4 The specifications of packaging box of bits shall meet the requirements for container transportation.

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