

ICS 77.160
CCS H72



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

GB/T 14445-2017

Replacing GB/T 14445-1993

Carbide products for coal mining tools

煤炭采掘工具用硬质合金制品

Issued on: October 14, 2017

Implemented on: May 1, 2018

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China;
Standardization Administration of China**

Table of Contents

- 1 Scope
- 2 Normative references
- 3 Requirements

Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009. This standard replaces GB/T 14445-1993 "coal mining tools carbide products." This standard and GB/T 14445-1993 Compared to the main technical changes are as follows:

- Increased M19, M25, M26, M27 four product types;
- Increase part of the type of product model;
- Specification of the product schematic;
- Canceled the general requirements of product size tolerances, improve the dimensional accuracy;
- Further refinement, a clear product burr, sticky appearance requirements;
- Detailed Chapter 4 "test methods" and Chapter 5 "Inspection Rules" of the specific content;
- Chapter 6 to add "quality manual" content;
- Increase Chapter 7 "contract (or purchase order) content." This standard is proposed by China Nonferrous Metals Industry Association. This standard by the National Non-ferrous Metal Standardization Technical Committee (SAC/TC243) centralized. This standard is mainly drafted by Zigong Cemented Carbide Co., Ltd., Chongyi Zhangyuan Tungsten Co., Ltd., Shenzhen Note into Technology Co., Ltd. The main drafters of this standard. Xue Lin, Tang Huagang, Liao Jun, Tan Qian Yu, Cao Miles, Li Juan, Xie Junjie, Zhao Guoming. This standard replaces the standards previously issued as.
- GB/T 14445-1993. Coal mining tools with carbide products

1 Scope

GB/T 14445-2017 is the Chinese national standard on carbide products for coal mining tools, in the field of metallurgy. 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 14 October 2017 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 May 2018. Classification: ICS 77.160, CCS H72. 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 requirements for coal mining tools cemented carbide products, test methods, inspection rules, signs, packaging, transportation, storage and Quality certificate and contract (or purchase order) content. This standard applies to coal mining coal drill, cone drill, rotary drill and other carbide products.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version applies to this article Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 5242 Carbide products inspection rules and test methods

GB/T 5243 cemented carbide products logo, packaging, transportation and storage

GB/T 18376.2 Carbide grades Part 2. Geology, mining tools Carbide grades

3 Requirements

3.1 classification Coal mining tools carbide products are divided into two types of flat teeth and pick-shaped teeth.

3.2 models that rules Coal mining tools with carbide products models that rules. The letter M plus the type of figures (10,11,12,13,14,19, 20, 21, 22, 23, 24, 25, 26, 27, etc.) plus a two-digit integer representing the primary parameter (less than two integers preceded by a "0" to make. When there is left and right model of the points, add the letter R after the model that the right type, plus the letter L that the left type; when the main parameters are the same, the other Parameters such as height and thickness are not the same, then add A, B and C at the back of the model to show the difference; if necessary, add -1 after the model respectively, -2, -3 for other types. See Table 1 for the model numbers for flat teeth and Example 2 for the pick teeth. Example 1. Other different parameters Right The main parameters, 15 means that the length L is 15.0mm; Flat teeth type code; Coal mining tools with carbide products. Example 2. Other different parameters The main parameter, 12 means that the diameter D is 12.0mm; Pick-shaped teeth type code; Coal mining tools with carbide products.