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NATIONAL STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

GB/T 19568-2025

Replacing GB/T 19568-2017

Wind energy generation systems - Assembling and installation specification of wind turbines

风能发电系统 风力发电机组装配和安装规范

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Standardization Administration of the PRC

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Foreword

This document complies with the provisions of GB/T 1.1-2020 "Standardization Work Guidelines Part

1.Structure and Drafting Rules of Standardization Documents". Drafting. This document replaces GB/T 19568-2017 "Specifications for Assembly and Installation of Wind Turbine Generator Sets". Compared with GB/T 19568-2017, Apart from structural adjustments and

editorial changes, the main technical changes are as follows:

a) The "General Requirements" have been changed (see 4.1.4, 4.1.6, 4.1.7, 4.1.8, and

3.1 in the.2017 version);

b) The requirements for screw, bolt, and stud connections have been changed (see 4.2.1.1~4.2.1.3, 4.2.1.5, and

3.2.1 in the.2017 version);

c) Added installation requirements for ring groove rivet connections (see 4.2.6);

d) The content of "Main Bearing Housing Composition and Gearbox Assembly" has been changed to "Transmission Chain Assembly" requirements (see 5.2,.2017 version). 3.3.2);

e) The content of "Yaw and pitch bearing assembly" has been changed to "Yaw, pitch bearing, and yaw gear assembly" (see 5.3). (Version 3.3.3,.2017)

f) Assembly requirements for passive mechanical brakes and hydraulic gearbox elastic supports have been added (see

5.4.2 and 5.6.2);

g) Increased requirements for generator assembly (see 5.8);

h) Security requirements have been changed (see 6.1,

4.1 in the.2017 version);

1 Scope

GB/T 19568-2025 is the Chinese national standard covering erecting a turbine - the receipt and storage of the components, the pre-assembly on the ground, the lift sequence and the wind limits for each stage, the alignment and the connections, and the commissioning checks before the machine is handed over. It replaces GB/T 19568-2017, with the fastener installation standard GB/T 33628-2025. In force from 1 May 2026. Issued on 31 October 2025, it has been in force since 1 May 2026, replacing GB/T 19568-2017.

This document specifies the general requirements for the assembly and installation of wind turbine generator sets, the assembly requirements for key components, the installation requirements for wind farms, and the inspection requirements. Seek and verify the method. This document applies to the assembly and installation of wind turbine generator sets.

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are not included. For references to documents, only the version corresponding to that date applies to this

document; for undated references, the latest version (including all amendments) applies. This document.

GB/T 9327-2008 Crimp and mechanical connections for conductors of power cables with rated voltage of 35kV (Um=40.5kV) and below Fittings Testing Methods and Requirements

GB/T 19072 Wind Turbine Generator Tower

GB/T 20319 Acceptance Specification for Wind Turbine Generator Sets

GB/T 33628 Technical requirements for the installation of high-strength threaded connections in wind turbine generator sets

GB/T 37898 Safety Technical Specification for Lifting Wind Turbine Generator Sets DL/T 796 Safety Regulations for Wind Power Plants

3 Terms and Definitions

This document does not contain any terms or definitions that need to be defined.

4.1 General Requirements

4.1.1 All personnel involved in assembly should undergo three levels of safety education and on-the-job skills training. Those in special trades (crane operators, special equipment operators) should hold relevant certificates. Only those with the corresponding qualification certificates are allowed to work, and operators of key processes and special processes must be trained and qualified before they can work.

4.1.2 Before assembly, all parts should be inspected to ensure that their models and specifications meet the requirements of the configuration list.

4.1.3 Before assembly, the parts entering the assembly area should be inspected. Assembly can only proceed if they meet the following requirements.

a) It bears a certificate of conformity after passing inspection;

b) Review the main mating dimensions and part numbers of key components and record them in the warranty card;

c) The mating dimensions adjusted by the fitter shall be re-inspected by the quality inspection department of the complete machine manufacturer and recorded in the warranty card.

4.1.4 Each assembly process should have an assembly process control card, which should be recorded and stored in the wind turbine generator set file.

4.1.5 Parts should be cleaned or washed before assembly and should be free of burrs, flaked edges, scale, rust, chips, oil, colorants, and dust. Before assembly, sharp corners or high points on mating surfaces should be trimmed. Unless otherwise specified, sharp

corners and edges of parts should be rounded off before assembly. (Assembly process...)