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

GB/T 21538-2026

Replacing GB/T 21538-2008

Rubber rollers for metal sheet coating

金属薄板用涂覆胶辊

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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 21538-2008 "Coating Rollers for Sheet Metal". Compared with GB/T 21538-2008, the only changes are structural adjustments. Aside from editorial changes, the main technical changes are as follows:

- a) Added regulations for classifying coating rollers (see 5.1);
- b) The tagging method and tagging examples have been changed (see 5.2, 4.2 from the 2008 version);
- c) The physical property requirements for the adhesive compound used for coating rollers have been changed (see 6.1, 5.4 of the 2008 edition);
- d) The requirements for apparent hardness deviation of coating rollers have been changed (see 6.3.1, 5.1 of the 2008 edition);
- e) The dimensional tolerance requirements have been changed (see 6.3.2, 5.2 of the 2008 edition);
- f) The requirements for geometric tolerances have been changed (see 6.3.3, 5.3 in the 2008 edition);
- g) The requirements for the surface properties of the coating rollers have been changed (see 6.3.4,

1 Scope

GB/T 21538-2026 is the Chinese national standard covering the rubber covered roller of a coil coating line - the covering material and its hardness, the concentricity and surface finish, and the resistance to the solvents and the heat of the coating it applies to a moving steel strip. It replaces GB/T 21538-2008. It was issued on 27 February 2026 and has been in force since 1 September 2026, replacing GB/T 21538-2008. The document is under the responsibility of the China Petroleum and Chemical Industry Federation. This page is published from the official record of the 2026 edition; the clause text of a standard this recent is not yet in circulation, and the figures, limits and tables it contains are those of the document itself, delivered in full with the English translation.

4.Determination by Shore hardness tester (Shore hardness) Constant indentation hardness

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 528 Determination of tensile stress-strain properties of vulcanized rubber or thermoplastic rubber

GB/T 529 Determination of tear strength of vulcanized rubber or thermoplastic rubber (trouser-shaped, right-angled and crescent-shaped specimens)

GB/T 1690 Test methods for resistance to liquids in vulcanized or thermoplastic rubbers

GB/T 4459.5 Representation of Center Holes in Mechanical Drawing

GB/T 9239.1 Mechanical vibration constant-state (rigid) rotor balance quality requirements - Part

GB/T 39693.4 Determination of hardness of vulcanized or thermoplastic rubber - Part

GB/T 39693.6 Determination of hardness of vulcanized or thermoplastic rubber - Part

3 Terms and Definitions

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

4 Product Structure

The basic structure of the coating roller consists of a coating layer, a roller core, and an

adhesive layer, as shown in Figure 1.

6 Determination of apparent hardness of rubber rollers by the IRHD method

GB/T 39693.7 Determination of hardness of vulcanized or thermoplastic rubber - Part

7 Shore hardness test for apparent hardness of rubber rollers hardness

GB/T 39697.2 Specification for rubber or plastic coated rollers - Part