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

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Grain and oil machinery - Roll grinding and fluting machines

粮油机械 磨辊磨光拉丝机

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Foreword

Appendix A of this standard is a normative appendix. The standard proposed by the National Food Authority. This standard by the National Standardization Technical Committee OILS. This standard was drafted. Henan University. The main drafters of this standard. Wu Wenbin, Li Yongxiang, Zhang Junling. Grain and oil machinery Roller polishing drawing machine

1 Scope

China's national standard for the machines that grind and flute the rolls of a flour mill. It specifies the terms and definitions, the working principle, the model designation and basic parameters, the technical requirements, the test methods, the inspection rules and the marking, packaging, transport and storage, and it applies to the vertical and horizontal hydraulic machines used to finish roller mill rolls. A flour mill is a series of roller mills, and the rolls are its cutting tools. The break rolls carry fine spiral flutes that open the wheat kernel and scrape the endosperm from the bran without pulverising it; the reduction rolls are smooth and ground to a fine finish, and they crush the endosperm particles progressively into flour. Both wear. A fluted roll loses the sharp edge that does the cutting, and a smooth roll loses its finish and its cylindricity - and when they do, the mill's extraction falls, the flour ash rises and the power consumption climbs, gradually enough that the miller may not notice until the product is out of specification. Rolls are therefore pulled, reground and re-fluted on a cycle, and this machine does that work. It grinds the roll to size, cylindricity and finish, and it cuts the flutes: a defined number per unit of circumference, at a defined spiral angle, with a defined profile and land. Every one of those numbers belongs to the mill's flow sheet, and a roll returned with the wrong flute count or spiral changes what that passage does to the stock. The standard specifies the machining accuracy, the flute pitch accuracy and indexing, the rigidity and workholding for a heavy roll, the drives and the cycle, and the safety of a grinding machine handling a heavy cylindrical workpiece. Issued on 29 September 2011 and in force since 1 December 2011.

This standard specifies the roller polishing drawing machine-related terms and definitions,

working principle, model and basic parameters, technical requirements, test side Method, inspection rules, marking, packaging, transportation and storage. This standard applies to the roller surface processing of vertical and horizontal hydraulic roller polished wire drawing machine.

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 191 Packaging - Pictorial signs

GB/T 1413 Series 1 freight containers - Classification, dimensions and ratings

GB/T 3768 Determination of sound pressure of sound power levels of noise sources using an enveloping surface reflectance measuring surface Simple Method

GB 4674 grinding machine safety regulations

GB 5226.1 Safety of machinery electrical equipment Part 1. General requirements

GB/T 11336 straightness error detection GB /Z18620.2 cylindrical gear inspection practice - Part 2. radial composite deviations, runout, tooth thickness and backlash test

GB/T 24854 grain and oil machinery products packaging technology

GB/T 24855 Oil Machinery assembly technology General technical requirements

GB/T 25218 Grain and Oil Painting machinery products general technical conditions GB Z158 workplace occupational hazard warning labels

3 Terms and Definitions

The following terms and definitions apply to this standard.

3.1 Roller roller Mounted on the mill for grinding material centrifugal casting alloy roll.

3.2 Polishing grinding Rotating the grinding wheel grinding surface of the roller, smooth surface to achieve the technical requirements.

3.3 Drawing groove; flute; corrugate Use screwdriver on the roller surface after polishing treatment after cutting, formed a certain inclination, offset, parallel toothed stripes.

4 Works

In ensuring the roll body shape and position tolerances and surface roughness conditions,

driven by a motor and a hydraulic cylinder, relying on the rotating wheel or drawing knife
Roller surface polished drawing, form a working roller.

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