

ICS 25.120.30
CCS J 61



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

GB/T 31561-2025

Replacing GB/T 31561-2015

**Clay bonded sand reclaiming complete equipment - Technical
specifications**

粘土砂再生成套设备 技术规范

Issued on: October 31, 2025

Implemented on: May 1, 2026

**Issued by: State Administration for Market Regulation;
Standardization Administration of the PRC**

Table of Contents

1.Scope	1
2 Normative References	1
3.Terms and Definitions	2
4.Technical Requirements	3
6 Inspection Rules	8
11 Figure A.1 Typical clay sand recycling process flow chart.....	10

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 31561-2015 "Technical Conditions for Clay Sand Regeneration Equipment". Compared with GB/T 31561-2015, Apart from structural adjustments and editorial changes, the main technical changes are as follows:

- a) The provisions concerning hydraulic systems have been deleted (see 4.1.8 of the.2015 edition);
- b) Change the description of "heating equipment" to "roasting furnace" and add relevant provisions regarding the detailed structure and piping of the roasting furnace (see...). 4.4 (4.3 in the.2015 edition).
- c) Change the term "recycling machine" to "friction regeneration equipment" and delete the provisions concerning film removal rate and reuse rate (see 4.6,.2015). Version 4.4);
- d) The provisions concerning dust removal systems are deleted (see 4.12 of the.2015 edition);
- e) Separate "idle operation" and "load operation" into separate categories and provide detailed regulations for each (see 4.14, 4.15,.2015 edition 4.14).
- f) Incorporate the requirements for operating time into the "Test Methods" (see 5.3, 4.14.2 in the.2015 edition).
- g) The provisions concerning gas emissions are deleted (see 4.14.20 of the.2015 edition);

1 Scope

GB/T 31561-2025 is the Chinese national standard covering the plant that recovers green sand from a foundry's spent moulds - the crushing, magnetic separation, scrubbing and classification, the quality of the reclaimed sand against new sand, and the dust and heat the line generates. Issued on 31 October 2025, it has been in force since 1 May 2026, replacing GB/T 31561-2015.

This document specifies the technical requirements for clay sand regeneration equipment, describes the corresponding test methods, and stipulates inspection rules and marking procedures. Packaging, transportation and storage. This document applies to the manufacture of equipment for the regeneration of clay sand using thermal regeneration.

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are listed below. 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 150 (All Parts) Pressure Vessels

GB/T 191 Pictorial Symbols for Packaging and Storage

GB/T 1804-2000 General tolerances - Tolerances for linear and angular dimensions without specified tolerances

GB/T 2684 Test methods for foundry sand and its mixtures

GB/T 3098.1-2010 Mechanical properties of fasteners - bolts, screws and studs

GB/T 3098.2-2015 Mechanical Properties of Fasteners - Nuts

GB/T 5226.1 Electrical Safety of Machinery - Electrical Equipment of Machinery - Part