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

GB/T 32567-2016

Blast wheels

抛丸器

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Quarantine;
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Foreword

This standard is drafted in accordance with the rules given in GB/T 1.1-2009. This standard is proposed by the China Machinery Industry Federation. This standard is centralized by the National Foundry Machinery Standardization Technical Committee (SAC/TC186). The drafting unit: Qingdao Foundry Machinery Co., Ltd., Qingdao Mechanical and Electrical Engineering Society, Qingdao Three Connaught Foundry Machinery Co., Ltd., Shandong Kai Tai Shot Blasting Machinery Co., Ltd., Dongguan City Machinery Industry Quality Management Association, Qingdao Aetna Heavy Industries Machinery Co., Ltd. The main drafters of this standard: Xing Haiwei, Dong Zhiqiang, Xue Guangxu, Liu Ruowei, Liang Xiaohua, Ding Renxiang. Shot blasting machine

1 Scope

China's national standard for blast wheels. It specifies the terms and definitions, the parameters, the technical requirements, the test methods, the inspection rules and the marking, packaging and storage of these machines, and it applies to single disc and double disc blast wheels. A blast wheel is the component that throws the shot in a shot blasting machine. Abrasive is fed into the centre of a rapidly rotating wheel, picked up by an impeller, guided by a fixed control cage that determines the direction of the stream, and thrown by the blades at speeds of the order of eighty metres a second. The whole cleaning, peening or descaling capacity of a blasting machine is a property of its wheels, and a blasting machine is essentially a cabinet built around them. What distinguishes the component is that it destroys itself while working. Every part of it that the abrasive touches - the blades above all, but also the impeller, the control cage and the wheel disc - is being worn away by the same stream it is throwing, and blades are consumable items replaced on a schedule measured in hundreds of hours. That is why the standard concentrates on the things that determine how long a wheel runs and how it behaves as it wears: the balance quality, since a wheel spinning at several thousand revolutions a minute with unevenly worn blades becomes an unbalanced rotor; the vibration intensity, defined here as the maximum vibration measured on the wheel; and the mechanical strength of the housing, which is what contains a blade if one fails. Issued on 24 February 2016 and in force since 1 September 2016.

This standard specifies the terms and definitions of the blasting machine, parameters, technical requirements, test methods, inspection rules, marking, packaging and storage. This standard applies to single disc shot blasting machine, double disc shot blasting machine (hereinafter referred to as shot blasting machine).

2 Normative reference documents

The following documents are indispensable for the application of this document. For dated references, only the dated edition applies to this article. For undated references, the latest edition (including all modifications) applies to this document.

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

GB/T 6414 Casting Dimensional Tolerance and Machining Margin

GB/T 6444 mechanical vibration balance vocabulary

GB/T 9239.1-2006 Mechanical vibration - Constant (rigid) rotor balance - Quality requirements - Part 1. Specification and balance tolerances test GB/T 13306 signs

GB 20905 Safety requirements for foundry machinery

GB/T 23570 general technical conditions for welding of metal cutting machine tools

GB/T 23576 General technical conditions for shot blasting equipment

GB/T 25370 Terminology for Foundry Machinery Measurement method of sound pressure level for foundry machinery

GB/T 25371 General technical requirements for foundry machinery GB/T General technical conditions for free forgings on hammers

3 Terms and definitions

GB/T 6444, GB/T 25370 and the following terms and definitions are applicable to this document.

3.1 Vibration intensity The vibration intensity of the blasting machine is expressed by the maximum value of the measured effective value of the vibration velocity in the measurement points of the predetermined shot blasting machine, Expressed in mm/s.

3.2 Valid values virtualvalue The rms value of the vibration velocity measured at a specified operating condition (eg, at rated speed, current, steady operating temperature) is vibration The effective value of speed.

Note. When evaluating the vibration of a rotating machine, the root mean square value of the vibration velocity is usually taken into account, since this value is related to the vibration

energy. Other amount, such as Displacement, acceleration, and peak values instead of rms can also be used, and in this case additional criteria are required, which are based on rms values There may not be a simple link.

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