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

GB/T 36054-2018

Top rollers for float glass

浮法玻璃拉边机

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009. This standard is proposed by China Federation of Building Materials. This standard is under the jurisdiction of the National Building Materials Equipment Standardization Technical Committee (SAC/TC465). This standard is drafted by: China National Building Material International Engineering Group Co., Ltd., Luoyang Zhongye Heavy Industry Group Co., Ltd. Participated in the drafting of this standard. China National Building Material Machinery Industry Association, Yancheng Institute of Technology, Kai Kai Shing Engineering Technology Co., Ltd., Qinhuangdao Open Huafa Electrical and Mechanical Development Co., Ltd. and Sinoma Equipment Group Co., Ltd. The main drafters of this standard. Peng Shou, Xing Baoshan, Yang Peiguang, Zhang Yanan, Chen Dejun, Zhang Yangping, Liu Rui, Xia Penghua, Lu Peich, Zheng Xiu, Liu Pingcheng, Liu Jiangyan, Dong Chaoli, and Cai Zhongjie. Float glass machine

1 Scope

China's national standard for the top rollers used on a float glass line. It specifies the terms and definitions, the types, models and basic parameters, the requirements, the test methods, the inspection rules and the marking, packaging and transport. Top rollers are the knurled wheels that grip the edges of the glass ribbon as it floats on the molten tin, and they are what sets its width and thickness. Glass poured onto tin naturally settles to about seven millimetres - its equilibrium thickness - and every other thickness is produced by pulling the ribbon: the rollers grip the edges and drive them outward and forward to stretch it thinner, or hold it back to let it run thicker. They work at around a thousand degrees C, in the reducing atmosphere the tin bath needs, gripping glass that is soft enough to mark, and they must not contaminate it. That combination is why they are a specified consumable rather than a machine part, and why a float line's product range depends on them.

This standard specifies the terms and definitions, types, models and basic parameters, requirements, and tests of the float glass edger (abbreviated below). Methods, inspection rules and signs, packaging, transportation and storage. This standard applies to 0.15mm ~ 25mm float glass process edge machine.

2 Normative references

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

GB/T 1184-1996 Tolerance values for shape and position tolerances

GB/T 1804-2000 Tolerances for tolerances of linear and angular dimensions for general tolerances

GB 2894 Safety Signs and Guidelines for Use

GB 5226.1 Mechanical electrical safety machinery electrical equipment Part 1. General technical conditions General requirements for the design and manufacture of

GB/T 8196 mechanical safety guards fixed and movable guards GB/T 13306 signage

GB/T 14048.1 Low-voltage switchgear and control equipment - Part 1. General

GB/T 16754 mechanical safety emergency stop design principles

GB/T 19804-2005 General dimensional and form tolerances for welded structures General requirements for

GB/T 20641 low-voltage switchgear and control equipment

GB/T 25480-2010 Basic environmental conditions and test methods for transportation and storage of instruments and meters

GB/T 26336 Industrial Communication Network Industrial Communication Network Installation

GB 50235-2010 Code for Construction of Industrial Metal Pipeline Engineering

GB 50435-2016 flat glass factory design specification JC/T 402-2006 Cement machinery paint anti-rust technical conditions

3 Terms and definitions

The following terms and definitions apply to this document.

3.1 Edge machine top roller Equipment for forming auxiliary glass on both sides of the float glass tin tank, including rotation of the edge puller, walking in and out of the tin bath, horizontal swinging, lifting Drop, press, quick lift mechanism and electrical control system.

3.2 Edge bar shaft A rod-shaped member consisting of a double-layer cooling circulation circuit, a shaft, and a shaft drive, including a pull-top machine, and a pull-up wheel provided at the front end of the shaft Bite in the edge of the glass band.