

ICS 83.140.99

CCS G 47



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

GB/T 39697.2-2020

**Rubber or plastics covered rollers - Specifications - Part 2:
Surface characteristics**

Issued on: December 14, 2020

Implemented on: November 1, 2021

**Issued by: State Administration for Market Regulation, China National
Standardization Administration**

Table of Contents

Foreword

Introduction

1 Scope

2 Normative references

3 Terms and definitions

0 $y_x()$ dx or approximately $Ra\sim$

Foreword

GB/T 39697 "Rubber or plastic coated roller specifications" is divided into 3 parts:

---Part 1: Hardness requirements;

---Part 2: Surface characteristics;

---Part 3: Dimensional tolerance:

This part is Part 2 of GB/T 39697:

This section was drafted in accordance with the rules given in GB/T 1:1-2009:

The translation method used in this section is equivalent to ISO 6123-2:2015 "Rubber or Plastic Covered Roll Specification Part 2: Surface Characteristics":

The Chinese documents that have a consistent correspondence with the international documents cited in this section are as follows:

---GB/T 6062-2009 Product Geometric Technical Specification (GPS) Surface structure contour method contact (stylus) type instrument standard

Characteristic (ISO 3274:1996, IDT);

---GB/T 10610-2009 Product Geometric Technical Specification (GPS) Surface structure profile method to evaluate the rules of surface structure

And methods (ISO 4288:1996, IDT):

This part was proposed by the China Petroleum and Chemical Industry Federation:

This part is organized by the National Rubber and Rubber Products Standardization Technical Committee Rubber Miscellaneous Technical Committee (SAC/TC35/SC7)

Focus:

Drafting organizations of this section: Guangzhou Derun Rubber Products Co., Ltd., Zhejiang Zhengrong Roll Co., Ltd., Hebei Tongchang Rubber Roll Co., Ltd., He

Beichunfeng Yinxing Rubber Roller Co., Ltd., Nanjing Dongrun Special Rubber and Plastic Co., Ltd., Nanjing Gubai Rubber and Plastic Products Co., Ltd:

Introduction

Rubber or plastic coated rollers are usually made of cylindrical metal roller cores covered with rubber or plastic, and can be made into various

Size and hardness level:

Specification for rubber or plastic coated rollers

Part 2: Surface characteristics

1 Scope

This part of GB/T 39697 stipulates that rubber or plastic coated rollers (hereinafter referred to as coated rollers) are based on surface quality (or defects) and surface

It also describes the method for measuring surface roughness:

2 Normative references

The following documents are indispensable for the application of this document: For dated reference documents, only the dated version applies to this article

Pieces: For undated references, the latest version (including all amendments) applies to this document:

ISO 3274 Product Geometric Technical Specification (GPS) Surface Structure: Nominal Characteristics of Profile Method Contact (Stylus) Instruments

[GeometricalProductSpecifications(GPS)-Surfacetexture:Profilemethod-Nominalcharacteristics of

contact(stylus)instruments]

ISO 4288 Product Geometric Technical Specification (GPS) Surface Structure: Rules and Methods for Evaluating Surface Structure by Profile Method [Geomet-

ricalProductSpecifications(GPS)-Surfacetexture:Profilemethod-Rulesandproceduresforthe assessmentofsurfacetexture]

ISO 23529 Rubber-General procedures for the preparation and adjustment of rubber physical test methods

preparing and conditioning test pieces for physical test methods)

3 Terms and definitions

The following terms and definitions apply to this document:

3:1

Arithmetical mean deviation of the profile

R_a

The arithmetic mean deviation of the contour refers to the arithmetic mean of the absolute value of the contour deviation within the sampling length (l):

$R_a =$

$\frac{1}{l} \int_0^l |y(x)| dx$ or approximately $R_a \approx$

$\frac{1}{n} \sum_{i=1}^n y_i$

Where:

n ---

The number of discrete contour offsets:

Note: In practice, the value of R_a is determined within the evaluation length, which includes several sampling lengths: According to ISO 3274, the nominal sampling length

The value is equal to the cutoff wavelength:

3:2

Ten-point height of microscopic irregularities

R_z

The ten-point height of microscopic unevenness refers to the average of the 5 largest profile peak heights and the average of the 5 largest profile valley depths within the sampling length

The sum of values:

$R_z = \frac{1}{10} \sum_{i=1}^5 y_{pi} + \frac{1}{10} \sum_{i=1}^5 y_{vi}$

The sum of values:

$R_z = \frac{1}{10} \sum_{i=1}^5 y_{pi} + \frac{1}{10} \sum_{i=1}^5 y_{vi}$

y_{pi}

y_{vi}

i=1

yvi()/5

chinastandards.org · PREVIEW