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

GB/T 46089.2-2025

**Conveyor machinery - Inspection and maintenance
specifications - Part 2: Scraper conveyors**

输送机械 检查与维护规范 第2部分：刮板输送机

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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 is Part 2 of GB/T 46089 "Inspection and Maintenance Specifications for Conveying Machinery". GB/T 46089 has published the following... part.

- Part 1: Belt Conveyors;
- Part 2: Scraper Conveyor.

Please note that some content in this document may involve patents. The issuing organization of this document assumes no responsibility for identifying patents.

This document was proposed by the China Machinery Industry Federation.

This document is under the jurisdiction of the National Technical Committee on Standardization of Continuous Handling Machinery (SAC/TC331).

This document was drafted by: Qingdao Daneng Environmental Protection Equipment Co., Ltd., Beijing Lifting and Transportation Machinery Design and Research Institute Co., Ltd., and Beijing...

Kezhengping Engineering Technology Testing and Research Institute Co., Ltd., Jiangmen Southern Conveying Machinery Engineering Co., Ltd., Taiyuan University of Technology, Yidu Huaxun Intelligent Energy Conveying Co., Ltd., Hubei Tianyi Machinery Co., Ltd., Hubei Yidu Zhongji Environmental Protection Engineering Co., Ltd., Yichang Xinyiyun Machinery Limited Liability Company, Hubei Yidu Yiyun Electromechanical Engineering Co., Ltd., and Guangdong Quanguan Intelligent Technology Co., Ltd.

The main drafters of this document are: Wang Yong, Li Jiye, Xing Lei, Yu Yongqiang, Wu Zhifang, Huang Xiayun, Wang Xuewen, Song Hongjiu, Zhang Guangrong, and Cao Junlin. Xin Zushan, Wu Shenghang, He Xiangkui, Zhou Jian.

Introduction

Conveying machinery is the most widely used product in continuous material handling equipment. In recent years, with the rapid development of the national economy, a large number of conveying machinery...

Once the equipment is put into operation, and as its service life increases, it becomes

increasingly important to strengthen its inspection and maintenance to ensure its safe and stable operation.

The more critical the equipment, especially the conveying equipment used in many ports and mines, the more likely it is to malfunction due to untimely or inadequate inspection and maintenance.

The occurrence of safety accidents will seriously affect the orderly conduct of production. Therefore, proper inspection and maintenance of conveyor machinery is of great significance.

Users are increasingly emphasizing the inspection and maintenance of conveyor machinery, creating a large-scale market demand. Therefore, in order to standardize...

The inspection and maintenance of conveying machinery is crucial for the safe and healthy development of the industry, and there is an urgent need to strengthen the standards for its inspection and maintenance.

The proposed standard GB/T 46089, "Inspection and Maintenance Specifications for Conveying Machinery," is divided into four parts.

- Part 1: Belt Conveyors. The purpose is to specify the basic requirements for inspection and maintenance of belt conveyors during use. This requirement.
- Part 2: Scraper Conveyors. The purpose is to specify the basic requirements for inspection and maintenance of scraper conveyors during use. This requirement.
- Part 3: Screw Conveyors. The purpose is to specify the basic requirements for inspection and maintenance of screw conveyors during use. This requirement.
- Part 4: Bucket Elevators. The purpose is to specify the basic requirements for inspection and maintenance of bucket elevators during use. This requirement.

Scraper conveyors are widely used in various industrial sectors such as power, mining, food, and chemicals, playing a crucial role in the conveying systems of these industries.

Therefore, ensuring the safe and stable operation of scraper conveyors is of paramount importance. This document aims to address this issue from the perspective of equipment inspection and maintenance.

Taking proactive measures to prevent safety accidents and reduce risks aligns with national security, health, and sustainable development strategies.

This document provides quantitative indicators and standards for the inspection and maintenance of scraper conveyors, guiding users to conduct inspections and maintenance in a scientific manner.

Learning, proper, and timely inspection and maintenance are essential to ensure the stable operation of scraper conveyor equipment, extend its service life, and reduce the probability

of safety accidents.

To ensure the safety of life and property of relevant operation and maintenance personnel.

The effective implementation of this document can solve the current situation where there are no standards or specifications to follow in the use and maintenance of scraper conveyors, and at the same time support the scraper conveyor...

High-quality development of the plate conveyor industry.

Inspection and maintenance specifications for conveying machinery Part 2: Scraper Conveyor

1 Scope

This document specifies the basic requirements for the inspection and maintenance of scraper conveyors as defined in GB/T 14521 during use. Request and check methods.

This document applies to scraper conveyors as specified in GB/T 14521.

This document does not apply to scraper conveyors used in explosive atmospheres. Other types of scraper conveyors should refer to this document for guidance.

2 Normative references

GB/T 14521

GB/T 44521-2024

3 Terms and Definitions

The terms and definitions defined in GB/T 14521 and the following terms and definitions apply to this document.

3.1 Inspection

A series of procedures performed to determine whether the scraper conveyor is functioning properly.

Note. Inspections are divided into routine inspections, periodic inspections, and special inspections.

3.2 Daily inspection

Inspections before and during each work shift.

3.3 Regular periodic inspection