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

GH/T 1188-2021

**Gear milling machine
(English Translation)**

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Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for Standardization Work Part 1: Structure and Drafting Rules of Standardization Documents" drafted.

This document replaces GH/T 1188-2017 "Gear Milling Machine". Compared with GH/T 1188-2017, except for structural adjustments and editorial changes in addition, the main technical changes are as follows.

- a) Changed the scope of application to the tooth milling machine suitable for milling saw blade of sawtooth deburring machine, deleted saw blade of sawtooth ginning machine (see Chapter 1);
- b) terms and definitions are added (see Chapter 3);
- c) Changed the product model and added milling cutter specifications (see Chapter 4);
- d) Deleted the product drawing and technical file manufacturing procedure of the gear milling machine (see 4.1 of the 2017 edition);
- e) When the normal work is changed, the power consumption per hour shall not be greater than 1kW·h (see 5.1.2);
- f) When the no-load is changed, the working noise is not more than 85dB(A) (see 5.1.3);
- g) Changed the milling cutter shaft to move flexibly without jamming (see 5.2.2.2);
- h) Added the requirement of automatic feeding system (see 5.2.3);
- i) It is added that each bearing part works continuously for more than 30min, and the temperature rise should not exceed 20°C (see 5.3.2);
- j) The vibration intensity at the bearing should not be greater than 5.0mm/s (see 5.3.3);

- k) Added requirements for safety guards (see 5.4);
- l) The appearance inspection method is added (see 6.1);
- m) The method for measuring the hardness of milling cutter teeth is added (see 6.2);
- n) The method for determining the milling cutter axis is added (see 6.3);
- o) Added the automatic feed system measurement method (see 6.4)
- p) Added no-load noise measurement method (see 6.5);
- q) The test method for bearing temperature rise has been added (see 6.6);
- r) The measurement method of power consumption is added (see 6.7);
- s) The measurement method of vibration intensity has been added (see 6.8).

Please note that some content of this document may be patented. The issuing agency of this document assumes no responsibility for identifying patents.

1 Scope

This document specifies the product model, technical requirements, test methods, inspection rules and signs, packaging, transportation and storage of milling and sawing machines.

Manufacturing process of gear milling machine.

This document is applicable to tooth milling machines for milling saw blades of serrated deburring machines.

2 Normative references

The contents of the following documents constitute essential provisions of this document through normative references in the text. Among them, dated citations documents, only the version corresponding to that date applies to this document; for undated references, the latest edition (including all amendments) applies to this document.

GB/T 191 Graphical signs of packaging, storage and transportation GB/T 6388 Receipt and Delivery Marks for Transport Packaging GB/T 6075.1 Mechanical Vibration - Measurement and Evaluation of Machine Vibration on Non-rotating Parts - Part 1: General GB 18399 Safety Requirements for Cotton Processing Machinery

3 Terms and Definitions

There are no terms and definitions that need to be defined in this document.

4.1 Product model

MC --- -- - Gear Milling Machine improvement number Distance between two adjacent milling cutters Number of milling cutters Feature number. Tooth machining Category number. Cotton processing machinery

4.2 Milling cutter specifications

- a) Milling cutter diameter series (mm). $\phi 25$, $\phi 28$, $\phi 32$;
- b) Milling cutters are divided into type I single conical and type II double conical, the shapes are shown in Figure 1 and Figure 2;