

JB

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

JB/T 8532-1997

Pulse-jet bag filters

脉冲喷吹类袋式除尘器

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1 Scope

This Standard specifies technical requirements, test methods, inspection rules, marking, packaging, transportation and storage of pulse-jet bag filters.

This Standard is applicable to pulse-jet bag filters (hereinafter referred to as bag filter).

2 Normative References

The following standards contain provisions which, through reference in this text, constitute provisions of this standard. For dated reference, subsequent amendments to, or revisions (excluding amended content) of, any of these publications do not apply. However, the parties whose enter into agreement according to these specifications are encouraged to research whether the latest editions of these documents are applied or not. For undated

references, the latest edition of the normative document referred to applies.

GB/T 699 Quality Carbon Structural Steels

GB/T 700 Carbon Structural Steel (GB/T 700-2006, ISO 630.1995, NEQ)

GB/T 702 Hot-rolled Round and Square Steel Bars - Dimension, Shape, Weight and Tolerance (GB/T 702-2004, ISO 1035.1~1035-2.1980, MOD)

GB/T 704 Hot-rolled Flats - Dimensions, Shape, Weight and Tolerances (GB/T 704-1988, neq ISO 1035-4.1982)

GB/T 706 Hot-rolled beam steel - Dimensions, Shape, Weight and Tolerances (GB/T 706-1988, neq FOTC 8239.1972)

GB/T 707 Hot-rolled Channel Steel - Dimensions, Shape, Weight and Tolerances (GB/T 707-1988, neq FOTC 8240.1972)

GB/T 912 Hot-rolled Plates and Strips of Carbon Structural Steels and High Strength Low Alloy Structural Steels

GB/T 985-1988 Basic Forms and Sizes of Weld Grooves for Gas Welding Manual Arc Welding and Gas-shielded Arc Welding

GB/T 986-1988 Basic Forms and Sizes of Weld Grooves for Submerged Arc Weld

GB/T 1804-2000 General Tolerances - Tolerances for Linear and Angular Dimensions without Individual Tolerance Indications (eqv ISO 2768-1.1989)

JB/T 5916-2004 Electro-magnetic Pulse Jet Valve for Bag-house Filters

JB/T 5917-2006 Bag Cage for Baghouse Filters

JB/T 8471-1996 Technical Requirement and Acceptance Regulation for Bag Filter Erection

JB/T 10191-2000 Bag Filter - Safety Rules - Manifold for Pulse-jet Bag Filter

3 Terms and Definitions

For the purposes of this Standard, the following terms and definitions apply.

3.1 Pulse-jet bag filter

Bag filter that removes dust by shock vibration and counterblast -- using the compressed gas ejected instantly by the pulse jetting mechanism with compressed gas as dust removal power so as to induce multiples of secondary gas to inject into the filtering bag and make the filtering bag expended sharply.

3.2 Contrary flow pulse-jet bag filters

Pulse-jet bag filter in which jetting air flow is reverse to the clean air flow in the filtering bag (house) and clean air is discharged from the upper clean air box.

3.3 Consistent flow pulse-jet bag filters

Pulse-jet bag filter in which jetting air flow is consistent to the clean air flow in the filtering bag after filtering and clean air is discharged from the lower clean air box.

3.4 Two directions pulse-jet bag filters

Pulse-jet bag filter in which jetting air flows are injected from upper and lower positions of the filtering bag and the clean air is discharged from the clean air manifold.

3.5 Round gap ejector pulse-jet bag filters

Pulse-jet bag filter in which round gap jet exhaustor is used for contrary jetting.

4.7.1

Surface rust, residue, oil stain, dust and other dirt shall be cleaned up before bag filter painting. Derusting method and grade shall meet the requirements of GB/T 8923; where ejecting or blast cleaning is used, the derusting grade shall not be lower than Sa2; where hand scrubber or power tool is used for derusting, the derusting grade shall not be lower than St2.

4.7.2

For whole-set bag filter to be delivered, their external surfaces shall be painted with two passes of primer and two passes of finish coats; for large scale bag filter transported to site in a split way, last pass of finish coat is painted on site.

4.7.3

Paint film of bag filter shall be uniform and solid-colored, and free of defects like crisping, flaking, cracking, curling and brush mark; the paint film thickness shall not be less than 50μm.

5.1

Tests for outlet dust concentration and equipment resistance of bag filter shall meet the requirements of GB/T 12138-1989; bag filters may be tested in the operating conditions half a year after completing the field installation.

5.2

Air leakage rate of bag filter is the ratio of the difference between outlet air volume and inlet air volume to the inlet air volume of bag filter. Air leakage rate is tested in the condition where the bag filter runs normal filtering; stable negative pressure shall be kept in the system during the test. The test condition is that negative pressure in bag filter clean air box is

2000Pa. When there is deviation of negative pressure, it is calculated according to the following formula.

Where,

ϵ -- The air leakage rate, %;

ϵ_1 -- The measured air leakage rate, %;

p -- The averaged negative pressure in the clean air box, Pa.

5.3

Bag filter film thickness shall be tested with paint film thickness gauge, and the number of test points shall not be less than two per square meter.

5.4

Inspection of paint film adhesive force shall comply with the requirements of JB/T 5000.12.

6.1 Inspection Classification

Inspections of bag filter include type inspection and end-of-manufacturing inspection.

6.2.1

Each product may be delivered upon it passes the inspection performed by the manufactory quality inspection department and is accompanied by the quality certificate.

6.2.2

End-of-manufacturing inspection shall comply with the requirements of Chapter 4, and it shall cover the items blow.