

CCS D 93

MT

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

MT/T 183-1988

**Scraper conveyor central trough
(English Translation)**

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1 Scope of application 1

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3 Product Category 1

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Central trough of scraper conveyor

1 Application

This standard is applicable to the unsealed middle tank (hereinafter referred to as the middle tank) of the scraper conveyor and the transfer machine in the coal mine.

2 Reference standards MT 102 Slotted Conveyor Central Slot Test Specification MT 105 General Specifications for Scraper Conveyor for Working Surface General specifications of MT 106 forwarder MT 149 Scraper Conveyor Type and Size MT 150 Scraper Conveyor and Recycler Packaging General Specifications General technical conditions of Q/ZB71 forgings Q/ZB74 welding general technical conditions

3 Product Categories

3.1 Product type

Types of central grooves. The central grooves are divided into three types. type I, type II, and type III, as shown in Figure 1, Figure 2, and Figure 3.

3.2 Dimension parameters the outer dimensions and connection dimensions of the three middle grooves shall meet the requirements of Figure 1 and Table 1, Figure 2 and Table 2, Figure 3 and Table 3, respectively.

Figure 1 Type I middle groove

Table 1 mm

HAL L1 L2 L3 L4 L5 L6 S 150 520 1200----->=6 150 520 1500 150 230 485 715 970 1200
 >=10 150 630 1500 150 230 485 715 970 1200 >=12 (180) (620) 1500----->=10 (180)
 (620) 1500 230 208 416 624 832 1040 >=10 190 630 1500 230 208 416 624 832 1040
 >=14 190 730 1500 230 208 416 624 832 1040 >=14 222 764 1500 230 208 416 624 832
 1040 >=20 222 830 1500 230 208 416 624 832 1040 > 20 Note. Newly designed products
 do not use bracketed values.

Figure 2 Type II central groove

Table 2 mm

HAL L1 L2 L3 L4 L5 L6 S 222 630 1500 150 230 485 715 970 1200 >=16 (220) 630 1500
 (185) (226) (452) (678) (904) (1130) >=16 222 730 1500 150 230 485 715 970 1200 >=16
 (220) 730 1500 (185) (226) (452) (678) (904) (1130) >=16 222 730 1500 150 230 485 715
 970 1200 >=20 (220) 730 1500 (185) (226) (452) (678) (904) (1130) >=20 222 830 1500
 150 230 485 715 970 1200 > 20 Note. Newly designed products do not use bracketed
 values.

Figure 3 Type III central groove

Table 3 mm

HALS

125 280 1200 >=4

150 320 1200 >=6

150 420 1200 >=6

4 Technical requirements

4.1 Basic requirements

4.1.1 The central groove shall comply with the requirements of this standard and shall be manufactured in accordance with the drawings and technical documents approved by the prescribed procedures.

4.1.2 Medium single-chain, side double-chain and medium double-chain hot-rolled channel steel shall comply with the provisions of MT 149.

4.2 Structural requirements

4.2.1 The central groove steel and middle plate used for mechanized coal mining shall meet its supporting use of shearer and hydraulic support.

The need for force.

4.2.2 The middle groove of the installation baffle or coal shovel board shall be welded with supports on the grooves on both sides.

4.2.3 The middle groove adopts structures such as press-bend overlap or butt overlap in the middle plate.

4.2.4 The connecting device between the middle grooves shall ensure that the scraper conveyor or the transfer machine has good bending performance and a good Alignment performance.

4.3 Performance requirements

4.3.1 The material selected for the central groove steel and the middle plate and connecting parts shall meet the requirements of strength, wear resistance and welding performance.

4.3.2 The central groove shall have sufficient mechanical strength, and various strength indexes shall meet the requirements of MT 102.

4.3.3 The strength and wear resistance of the central groove should meet the requirements for use, and the underground service life of the central groove should meet MT 105 Table 1 or MT

106 Table 1 provisions.

4.4 Manufacturing and assembly requirements

4.4.1 Raw materials and parts shall be inspected in accordance with their respective technical requirements to prove that their quality meets the technical requirements before they can be used.

4.4.2 All forgings shall meet the requirements of Q/ZB71.

4.4.3 The manufacture of hot-rolled channel steel in the central groove shall comply with the relevant provisions of the Ministry of Metallurgical Industry on the standard of hot-rolled channel steel for mining. Cold pressed groove steel Meet the requirements of product design documents.

4.4.4 Each support shall be welded to the channel steel at its four corners (see Figure 1, Figure 2) .The welding strength of the support shall comply with the relevant requirements of MT 102.

Regulations.

4.4.5 The upper and lower parts of the middle slot plate are welded continuously or intermittently. The welding strength should meet the relevant regulations of MT 102 and use

with requirements.

4.4.6 The welding of the central groove shall comply with the relevant regulations of Q/ZB74.

4.4.7 Strengthening treatment shall be applied to the easily worn parts of the central groove steel.

4.4.8 After the middle groove is assembled, the top and bottom of the interface between the middle groove and the middle groove, between the middle groove and the adjustment groove, and between the middle groove and the transition groove the staggered volume should be no more than 2mm, and the staggered volume should be no more than 3mm.

4.4.9 After the middle grooves are assembled, the maximum horizontal bending angle and vertical bending angle between the middle grooves should conform to the product design documents.

Regulations.

4.5 Appearance and Oil Quality Requirements After the middle groove is qualified for processing and inspection, the surface should be painted, and the quality of the paint should meet the requirements of the product design documents.

4.6 Product Quality Assurance in the case where the user complies with the storage, transportation, installation, and use regulations, within one year from the date of shipment by the manufacturer, any problem caused by manufacturing quality in the event of damage or malfunction, the manufacturing unit shall repair or replace the product (parts) for the user free of charge.

5 Test method

The test items and methods of the central tank shall comply with the provisions of Chapter 4 and Chapter 5 of MT 102.

6 Inspection rules

6.1 General

6.1.1 Products must pass the inspection of the manufacturer's technical inspection department before leaving the factory. When leaving the factory, documents must be attached to prove that the product is qualified.

6.1.2 The test shall be arbitrarily selected in the middle groove of the finished product, and the sample shall not have any coating covering the defect.

6.1.3 The factory inspection is generally carried out in the manufacturer, and the type inspection should be carried out in the testing unit authorized by the state.

6.2 Product inspection category Product inspection is divided into two types. factory