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

中华人民共和国机械行业标准

JB/T 10380-2013

Pipe belt conveyor

圆管带式输送机

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Foreword

This Standard was drafted according to the rules of GB/T 1.1-2009.

This Standard replaces JB/T 10380-2002 Pipe Belt Conveyor. Compared with JB/T 10380-2002, the main technical changes are as follows:

- ADD 400mm, 560mm, 630mm, and 800mm pipe diameters (see 3.2.1);
- ADD the pulley length parameter (see 3.2.3.2);
- ADD the roller length parameter of idler set (see 3.2.4.2);
- ADD the regulations of relationship between filling factor and particle size (see 4.2);
- ADD the requirements of design life for the pulley bearing (see 4.5.13);
- INCREASE the service life of idler rollers, and DECREASE their damage rate (see 4.6.9, 4.3.8 of Version 2002);
- ADD the requirements on conveyor belt (see 4.7);
- ADD the surface adhesive and primer performance tests of the rubber covered pulley (see 5.6);
- ADD the packaging technology requirements on pipe belt conveyor (see 7.2).

This Standard was proposed by China Machinery Industry Federation.

This Standard was under the centralized management of National Technical Committee of Continuous Handling Machinery Standardization (SAC/TC331).

Responsible drafting organizations of this Standard: Taiyuan University of Science and Technology, and Beijing Materials Handling Research Institute.

Participating drafting organizations of this Standard: Sichuan Zigong Transport Machinery Co., Ltd., China Huadian Engineering Co., Ltd., Shanghai Keda Heavy Industry Group Co., Ltd., Hengyang Transport Machinery Co., Ltd., Shandong Shankuang Machinery Co., Ltd., Beijing Guodian Futong Technological Development Co., Ltd., Henan Tianlong Conveying

Equipment Co., Ltd., Beijing Yueji Tongli Mechanical Manufacturing Co., Ltd., Jiaozuo Keruisen Mechanical Manufacturing Co., Ltd., Jiaozuo Xinheng Hoisting and Conveying Machinery Co., Ltd., Anhui Shengyun Machinery Co., Ltd., Tongling Tianqi Lantian Mechanical Equipment Co., Ltd., Jiangyin Pengjin Mechanical Manufacturing Co., Ltd., Ji'an Jiaxin General Machinery Co., Ltd., Tongnhua City Hoisting & Conveying Machinery Manufacturing Co., Ltd., Pingdingshan Coal Group Donglian Mechanical Manufacturing Co., Ltd., Taiyuan Xiangming Mechanical Manufacturing Co., Ltd., Dongguan City Aoneng Practical Co., Ltd., Jiangxi Huawu Brakers Co., Ltd., Hebei Xinshan Conveyor Co., Ltd., Jiangsu Province Zhangjiagang City Liyuan Conveying Machinery Co., Ltd., Qingdao Huaxia Rubber Industry Co., Ltd.

Main Drafters of this Standard: Meng Wenjun, Wang Ying, Wu Zhifang, and Han Gang.

Release of all previous versions of standard replaced by this Standard:

- JB/T 10380-2002.

Pipe Belt Conveyor

1. Scope

This Standard specifies the type, basic parameters, technical requirements, test methods, testing rules, marks, packaging and storage of the pipe belt conveyor (hereinafter referred to as the Conveyor).

This Standard applies to the Conveyor, which continuously conveys various bulk or granular materials and other loose materials. As for the Conveyor, six or eight idler sets form a regular polygon to force the conveyor belt to form a pipe shape.

2. Normative reference

The articles contained in the following documents have become this document when they are quoted herein. For the dated documents so quoted, all the modifications (Including all corrections) or revisions made thereafter shall be applicable to this document.

GB/T 191 Packaging - Pictorial marking for handling of goods

GB/T 528 Rubber, vulcanized or thermoplastic - Determination of tensile stress-strain properties

GB/T 531.1 Rubber vulcanized or thermoplastic - Determination of indentation hardness - Part 1: Durometer method (Shore hardness)

GB/T 1184-1996 Geometrical tolerancing-Geometrical tolerances for features without Individual tolerance indications

GB/T 2828.1-2012 Sampling procedures for inspection by attributes - Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection

GB/T 3323-2005 Radiographic examination of fusion welded joints in metallic materials

GB/T 3512 Rubber, vulcanized or thermoplastic--Accelerated ageing and heat resistance tests--Air-oven method

GB/T 3767-1996 Acoustics—Determination of sound power levels of noise sources using sound pressure—Engineering method in an essentially free field over a reflecting plane

GB 3836.1-2010 Explosive atmospheres—Part 1: Equipment—General requirements

GB/T 4323 Pin coupling with elastic sleeve

GB/T 5014 Pin coupling elastomer



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