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

中华人民共和国国家标准

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GB 50386-2006

**Code for acceptance of engineering installation
for mechanical equipment of rolling mill**

轧机机械设备工程安装验收规范

Issued on September 06, 2006

Implemented on April 01, 2007

Jointly issued by Ministry of Housing and Urban-Rural Development of the People's

**Republic of China and General Administration of Quality
Supervision, Inspection and Quarantine of the People's Republic
of China (AQSIQ)**

NATIONAL STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

Code for acceptance of engineering installation for mechanical equipment of rolling mill

GB 50386-2006

Editorial department in chief: China Metallurgical Construction Association

**Approval department: Ministry of Housing and Urban-Rural Development of the
People's**

Enforcement date: April 1, 2007

China Planning Press

2007·Beijing

Announcement of Ministry of Construction of the People's Republic of China

No. 489

Announcement of Ministry of Construction on Issuing National Standard *Code for Acceptance of Engineering Installation for Mechanical Equipment of Rolling Mill*

Hereby approve *Code for Acceptance of Engineering Installation for Mechanical Equipment of Rolling Mill* as national standard, which is numbered GB 50386—2006 and will be implemented from April 1. Article (clause) 2.0.4, 2.0.9 (4) , 2.0.14, 7.5.1 (5) , 11.6.1, 14.2.1, 14.2.4, 14.3.1, 14.4.1, 14.5.1 and 15.12.1 are mandatory and must be strictly enforced.

This Code is published and distributed by China Planning Press, which is organized by Ministry of Construction of the People's Republic of China Standard Rating Research Institute.

Ministry of Construction of the People's Republic of China

September 6, 2006

Foreword

This Code is organized by China Metallurgical Construction Association and specifically prepared by China Twentieth Metallurgical Construction Company jointly with other organizations concerned according to the requirements in Notice on *Printing and Distributing 'Engineering Construction Standard Specifications Preparation and Revision Plan (Second Batch) for 2005'* (Jiao Biao Han [2005] No.124).

In preparation process, specification preparation group studied relevant existing national laws, regulations and standards, made an investigation, summed up experience on quality acceptance of engineering installation for mechanical equipment of rolling mill, conducted repeated revisions and discussions for provisions of the Code, extensively solicited opinions of relevant units and experts and finalized it after review.

This Code is divided into 15 chapters, including general principles, basic regulations, foundation bolt and base plate, equipment and material approaching, installation works of host rolling mill column equipment, installation works of shearing machine, installation works of recoiling machine uncoiling machine, installation works of roller way, installation works of cooling bed, installation works of rolled products transportation equipment, installation works of overturn and transfer equipment, installation works of straightening machine, installation works of looping equipment, installation works of heating furnace, installation works of other devices of rolling mill as well as 4 annexes. Clauses of chapter 3 "Equipment foundation, foundation bolt and base plate" and chapter 4 "equipment and material approaching" involve sub-divisional works and are quality control elements that sub-divisional works have common character, so it is listed in a separate chapter.

Boldface clauses in this Code are mandatory and must be strictly enforced.

Ministry of Construction is in charge of this Code and responsible for interpretation of mandatory provisions of this Code; China Twentieth Metallurgical Construction Company is responsible for interpretation of specific technical contents.

In order to improve quality of the Code, please try to sum up experience and accumulate data during implementation of this Code and feed relevant opinions and suggestions back to technology department of China Twentieth Metallurgical Construction Company (address: No. 777, Pangu Road, Baoshan District, Shanghai Postal code: 201900,

E-mail: jishubu — 20mcc @ 126.com) at any time for reference in future revision.

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Contents

1 General Principles	11
2 Basic Regulations	12
3 Equipment Foundation, Foundation Bolt and Base Plate	22
3.1 General Provisions	22
3.2 Equipment Foundation	22
3.3 Foundation Bolt	23
3.4 Base Plate	23
4 Equipment and Material Approaching	25
4.1 General Provisions	25
4.2 Equipments	25
5 Installation Works of Rolling Mill Host Column Equipment	26
5.1 General Provisions	26
5.2 Rolling Mill Rack Installation.....	26
5.3 Rolling Mill Rack Installation.....	28
5.4 Roller Adjustment Device Installation	34
5.5 Transmission Gear Installation of Rolling Mill	36
5.6 Mill Roll Changing Device Installation	39
5.7 Test Run of Rolling Mill Host Column Equipment	43
6 Installation Works of Shearing Machine	45
6.1 General Provisions	45
6.2 Shearing Machine Foundation Installation	45
6.3 Billet Shearing Machine Rack Installation	45
6.4 Billet Shearing Machine Blade Changing Device Installation	47
6.5 Transmission Reduction Gear Installation	48
6.6 Flying Shear Rack Installation.....	49
6.7 Steel Plate Shearing Machine Installation.....	49
6.8 Test Run of Shearing Machine	52
7 Installation Works of Coiling Machine and Uncoiling Machine.....	54
7.1 General Provisions	54

7.2 Installation of Cold-Rolled Strip Steel Coiling Machine and Uncoiling Machine ..	54
7.3 Installation of Cold-Rolled Dual-Drum Rotary Strip Steel Coiling Machine Installation.....	55
7.4 Hot-rolled Strip Steep Rolling Machine and Uncoiling Machine Installation.....	57
7.5 Test Run of Coiling Machine and Uncoiling Machine.....	60
7.6 Auxiliary Equipment Installation of Coiling Machine and Uncoiling Machine.....	61
7.7 Test Run of Coiling Machine and Uncoiling Machine Auxiliary Equipment.....	62
8 Track Installation Works.....	64
8.1 General Provisions	64
8.2 Installation of centralized drive roller table	64
8.3 Installation of Single Drive Roller Table.....	66
8.4 Installation of Lifting, Moving and Swing Roller Tables	68
8.5 Test Run of Roller Table	70
8.6 Special Roller Installation	71
8.7 Test Run of Special Roller	73
9 Cooling Bed Installation Works.....	75
9.1 General Provisions	75
9.2 Rotary Stepping Rack Cooling Bed.....	75
9.3 Test Run of Rotary Stepping Rack Cooling Bed	78
9.4 Installation of Chained and Rope Hauling Machine Cooling Bed	79
9.5 Test Run of Chained and Rope Hauling Machine Cooling Bed	83
9.6 Installation of Riding Wheel Ramp Stepping Cooling Bed	84
9.7 Test Run of Riding Wheel Ramp Stepping Cooling Bed Body.....	89
9.8 Rolled Cooling Rack Installation	90
10 Rolled Products Transport Equipment Installation Works	92
10.1 General Provisions	92
10.2 Stepping Beam Transfer Machine Installation.....	92
10.3 Test Run of Stepping Beam Transfer Machine.....	93
10.4 Installation of Steel Coil Chained Conveyor.....	94
10.5 Test Run of Steel coil Chained Conveyor.....	96

10.6 Double Chained Scraper Conveyor Installation	96
10.7 Test Run of Double-Chained Scraper Conveyor.....	98
10.8 Installation of Spiral Pipe Conveyor	99
10.9 Test Run of Spiral Pipe Conveyor	100
10.10 Ingot Vehicle Installation.....	101
10.11 Test Run of Ingot Vehicle.....	102
10.12 Installation of Steel Coil Transport Trolley.....	103
10.13 Test Run of Coil Transport Trolley	104
11 Tipping and Transfer Equipment Installation Work.....	106
11.1 General Provisions	106
11.2 Manipulator Installation.....	106
11.3 Test Run of Manipulator.....	108
11.4 Installation of Rack-Type Pusher and Discharge Machine	109
11.5 Test run of rack-type pusher and discharge machine	113
11.6 Installation of long-stroke charge machine.....	113
11.7 Test run of long-stroke charge machine	115
11.8 Installation of horizontal acquiring (feeding) device of slender mill bar	116
11.9 Test run of horizontal acquiring (feeding) device of slender mill bar.....	117
11.10 Installation of turnover device.....	118
11.11 Test run of turnover devices.....	123
11.12 Installation of revolving platform	125
11.13 Test run of revolving platform	126
11.14 Installation of sheet piler.....	127
11.15 Test run of sheet piler	129
12 Installation engineering of straightener	131
12.1 General provisions	131
12.2 Installation of gag straightener	131
12.3 Installation of roll straightener	131
12.4 Installation of tension straightener	134
12.5 Installation of crossroll straightener.....	135

12.6 Test run of straightener.....	137
13 Installation engineering of looping device	139
13.1 General provisions	139
13.2 Structure installation of looping steel.....	139
13.3 Installation of looping car track.....	140
13.4 Installation of swing gate.....	141
13.5 Installation engineering of looping car.....	143
13.6 Installation of looping band steel carrier roller and carrier roller car.....	144
13.7 Installation of looping winch	145
13.8 Test run of looping devices.....	147
14 Installation engineering of heating furnace.....	149
14.1 General provisions	149
14.2 Installation of stepping heating furnace	149
14.3 Installation of annular heating furnace	153
14.4 Installation of band steel continuous-type annealing furnace.....	156
14.5 Installation of roller-bottom heating furnace.....	158
14.6 Test run of heating furnace.....	160
15 Installation engineering of other devices of rolling mill.....	164
15.1 General provisions	164
15.2 Installation of sawing machine	164
15.3 Test run of sawing machine.....	166
15.4 Installation of shear gauge	167
15.5 Test run of shear gauge.....	169
15.6 Installation of printer	170
15.7 Test run of printer.....	172
15.8 Installation of weighing machine	173
15.9 Test run of weighing machine.....	176
15.10 Installation of bundling machine.....	177
15.11 Test run of bundling machine.....	178
15.12 Installation of automatic band steel welding machine.....	179

15.13 Test run of automatic band steel welding machine	181
15.14 Installation of heat coil box	182
15.15 Test run of heat coil box	184
Annex A quality acceptance record of subdivisional work of the rolling mill mechanical equipment project installation	186
Annex B quality acceptance record of subdivisional work of the rolling mill mechanical equipment project installation	188
Annex C quality acceptance record of unit project of rolling mill mechanical equipment project installation	190
Annex D record of test run of equipment without load	195
Explanation of the wording in this Code	198

1 General Principles

1.0.1 In order to strengthen engineering installation quality management of rolling mill, unify inspection and acceptance of engineering and installation for mechanical equipment of rolling mill and ensure engineering quality, this Code is hereby developed.

1.0.2 This Code applies to quality acceptance of engineering installation for new and renovated mechanical equipment of rolling mill.

1.0.3 Engineering technical document and contract adopted in engineering installation for mechanical equipment of rolling mill shall not be lower than the specification in this Code.

1.0.4 Besides conforming to provisions of this Code, quality acceptance of engineering installation for mechanical equipment of rolling mill shall also conform to the provisions of relevant existing national standard.

2 Basic Regulations

2.0.1 Installation and construction unit of mechanical equipment of rolling mill shall have appropriate engineering construction qualification; construction site shall have appropriate construction technical standard, sound quality management system, quality control and inspection system as well as construction organization design, construction scheme, job design and other technical documents that are approved by technical director of project.

2.0.2 Revision of construction drawing must be subject to design change notice or technical verification certificate of design unit.

2.0.3 Quality inspection and acceptance of engineering installation for mechanical equipment of rolling mill must through measuring instrument that passes metrological verification and calibration.

2.0.4 Welders for engineering installation for mechanical equipment of rolling mill must take exam and obtain a certificate of qualification and conduct welding for qualified items in approval scope.

2.0.5 Engineering installation for mechanical equipment of rolling mill shall follow required procedures; there shall be handing over inspection between related types of professional work to form a record; working procedures of the profession shall follow construction technical standard for quality control; inspection shall be carried out to form a record each time after a working procedure is completed. The construction shall not be continued if previous working procedure is not inspected and approved.

2.0.6 Second grouting and other concealed works of equipments in engineering installation of mechanical equipment of rolling mill shall be inspected for acceptance by the unit concerned before concealing that is notified by construction unit; acceptance document shall also be formed.

2.0.7 Quality acceptance of engineering installation for mechanical equipment of rolling mill shall be conducted based on sub-divisional work, partitioned project and unit project. Division of partitioned project and sub-divisional work better follows the provisions in table 2.0.7; unit project may be divided based on process system or production line. For large scaled production lines with a large number equipments, division of unit project may also be based on entrance section, technology section and exit section.



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