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

FZ/T 90074-2021

**Painting for the products of textile machinery
(English Translation)**

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard replaces FZ/T 90074-2004 "Textile Machinery Product Coating", compared with FZ/T 90074-2004, the main technical changes as follows.

---Add "antistatic" mechanical parts painting requirements (see 3.3, 2004 edition 3.3);

---In order to decorate and beautify the appearance of the equipment, you can choose "art paint" to be modified to "orange paint" (see 3.6, 2004 version 3.6);

---The basic color of the coating film is changed from "textile green" to gray, and "warning color" is added (see 4.1, 2004 edition of 4.1);

---Adjusted the standard structure. According to the standard compilation rules, the "coating film quality requirements and inspection methods" in the original standard are divided into coating film quality Two chapters on requirements and inspection methods; at the same time, the "Requirements for Textile Instruments and Meters" are combined and compiled, and no separate list is listed (see Chapters 5 and 6).

Chapter, Chapter 5 of the 2004 edition);

--- Modified the appearance requirements of the coating film, and added the appearance grade feature description (see 5.2, 5.1.2 and 5.3.2 of the 2004 edition);

---Added coating film thickness requirements (see 5.3) and inspection methods (see 6.1);

---Added the gloss requirements of orange powder coating film (see 5.4.2);

---Added the provision of coating film drying (time) (see 5.5);

---The adhesion requirements of the coating film have increased the requirements for the adhesion level of the primer (see 5.6);

---Added coating film antistatic requirements (see 5.14) and testing methods (see 6.16);

---Modified the method for measuring the gloss of the coating film. Refer to GB/T 9754 "Paints and varnishes 20°, paint film of color paints without metallic pigments, 60° and 85° Specular Gloss Measurement" instead of GB/T 1743-1979 "Coating Film Gloss Measurement Method" as the coating film gloss measurement method (See 6.2, 5.1.3 of the 2004 edition);

---Modified the test method for corrosion resistance of coating film, and quoted GB/T 9274 "Determination of Paint and Varnish Resistance to Liquid Medium" instead GB/T 1763-1979 "Determination of Chemical Resistance of Paint Films" (see 6.13~6.15, 5.1.12 of the 2004 edition).

This standard was proposed by the China National Textile and Apparel Council.

This standard is under the jurisdiction of the National Textile Machinery and Accessories Standardization Technical Committee (SAC/TC215).

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Co., Ltd., China Textile Machinery (Group) Co., Ltd., Jingwei Textile Machinery Co., Ltd., Zhejiang Sci-Tech University, Shaoxing Quality Technology Supervise the testing institute.

1 Scope

This standard specifies the general rules for the coating of textile machinery products, the surface color of the coating film, the quality requirements of the coating film and the inspection methods.

This standard applies to the surface coating of textile machinery, textile instruments and other products.

2 Normative references

The following documents are indispensable for the application of this document. For dated reference documents, only the dated version applies to this article Pieces. For undated reference documents, the latest version (including all amendments) is applicable to this document.

GB/T 1720 Determination of paint film adhesion GB/T 1728 Determination of drying time of paint film and putty film GB/T 1731 Test method for flexibility of paint film GB/T 1732 Test

Method for Impact Resistance of Paint Film GB/T 1733 Determination of Water Resistance of Paint Film GB/T 1735 Determination of heat resistance of paints and varnishes GB/T 1740 Test Method for Resistance to Humidity and Heat of Paint Film GB 2893 safety color GB/T 6739 Paint and varnish pencil method for determination of paint film hardness GB/T 9274 Determination of the resistance of paints and varnishes to liquid media GB/T 9286 Cross-cut test of color and varnish film GB/T 13452.2 Determination of paint film thickness of paints and varnishes

3 General

3.1

The surface of the unprocessed part of the machine should be painted, except for special requirements.

3.2

The surface of the machined part shall be painted according to the design and process requirements.

3.3

The parts with anti-static, heat-resistant, oil-resistant and corrosion-resistant requirements shall be coated with corresponding anti-static, heat-resistant, oil-resistant and corrosion-resistant coatings.

3.4

The surface of wooden parts is generally varnished.

3.5

The inner surface of container equipment is generally not painted unless there are special regulations.

3.6

In order to decorate and beautify the appearance of the equipment, orange paint can be used.

3.7

Working surface of machine parts, polished or surface-treated oxidation, passivation and plating surfaces, stainless steel and some non-ferrous metal parts Surfaces, of non-metallic parts other than wood, and surfaces that cannot be painted for other reasons are generally not painted.

4 Coating surface color

4.1

The basic color of the coating film is gray (light gray and dark gray), and the appropriate color can also be selected according to product characteristics and user needs. Warning color should be used Yellow specified in GB 2893.

4.2

Under the condition of selecting the basic color of the equipment, partial color matching can be carried out in order to beautify the appearance.