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

GB 13691-2008

Replacing GB 13691-1992

**Code for the dust protecting technique of the ceramic
production**

陶瓷生产防尘技术规程

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Foreword

All the technical contents of this standard is mandatory. This standard replaces GB 13691-1992 "ceramic production Code of dust." This standard compared with GB 13691-1992 main changes are as follows:

- The main structure in accordance with the ceramics production process layout, ease of use and the corresponding provisions of the lookup;
- Increasing the normative references and definitions of terms;
- Increasing the relevant provisions of the dedusting equipment maintenance;
- Increasing the relevant provisions of the personal protection;
- Increased dust management in the relevant provisions of education and training. The Standard Appendix A, Appendix B normative appendix. This standard was proposed by the State Administration of Work Safety. This standard produced by the National Technical Committee of Standardization Technical Committee of dust and poison safety. This standard was drafted. Capital University of Economics, Sinosteel Maanshan Institute of Mining Research, Beijing Center for Disease Control and Prevention. The main drafters of this standard. Jiang Kang, Cho Yong, Guo Jinfeng, Guo Jianzhong, Wang Yongyi, had Yao, Sheng Haitao. This standard replaces the standards previously issued as follows:
- GB 13691-1992. Dust ceramic production technical regulations

1 Scope

GB 13691 is the mandatory dust control code for ceramic works, where the raw materials are crushed, milled, screened, glazed and fired and every one of those steps releases silica-bearing dust. It sets the technical requirements for the plant layout, the enclosure and ventilation of dust-producing equipment, the extraction and collection systems, the wet processes that replace dry ones where possible, and the monitoring and management that keep exposure down. It is the document an inspector applies when assessing a ceramic plant for occupational dust hazard. Issued on 23 December 2008, in force since 1 December 2009, replacing GB 13691-1992. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the edition it replaces are taken from there. The clause text, the tables and the numeric limits are not reproduced on this page - they are in the document itself, which is delivered in full in English translation.

This standard specifies the basic requirements of ceramic dust production and technical measures. This standard applies to household and architectural ceramics factory raw material processing, molding, baking design, transformation and production management. For ceramic production Sagger, plaster dust processing and painting process, reference should be used.

1.1.4 Chute blanking at the closed position of the exhaust port cover

1.5 times the width at the outlet tube slide. A.

1.1.5 For two belt transporter unloading landing place, set the air vents in the cover tape

whereabouts closed, exhaust hood location side landing point Surface of the hood edge 150mm ~ 300mm appropriate. A.

1.1.6 When the belt conveyor in conveying the material size of less than 0.5mm, the speed should be controlled in less than 1m/s, when the diameter of delivery When the 0.4mm ~ 4mm material, the speed should be controlled within 1.25m/s. A.

1.1.7 should adopt impedance device (such as a hammer-type feeders, etc.) as much as possible to reduce the dust when the whereabouts of the material. A.

1.1.8 tape head, ...

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 16758 hood classification and technical conditions

GB 50019 Heating, ventilation and air conditioning design

GB 50187 for General graphic design specification

GB 50243 Construction Quality Acceptance of Ventilation and Air Conditioning Engineering

3 Terms and Definitions

The following terms and definitions apply to this standard.

3.1 Clay, quartz and other natural silicate raw materials through grinding, molding, drying and calcining the typical production process of a certain shape obtained And strength products, polycrystalline, inorganic non-metallic solid heterogeneous silicate materials and products commonly known.

3.2 Dusting equipment and locations. 4 site, factory and plant

4.1.1 The site selection should be away from residential and other buildings, and located in towns, industrial enterprises and residential areas adjacent to the minimum annual frequency of wind Windward side.

4.1.2 Production areas and living areas should maintain the necessary protective distance and take the greening measures.

4.2 plant layout

4.2.1 The main raw materials warehouse and chimney should be arranged on the upwind side of a non-production area plant annual minimum frequency of wind direction and non-dust production area.

4.2.2 The plant should be arranged according to shorten the process and reduce dust points required to determine and facilitate the building ventilation, lighting.

4.3 plant construction

4.3.1 plant construction airtight as possible, building elements inside the plant should be easy to reduce the dust of concave and convex portions. All inner walls, roofs Surface smooth as possible.

4.3.2 Open side windows inside the plant should be located in annual minimum frequency wind windward side of the wall, the height from the ground is generally not less than 1m.

4.3.3 dust production shop floor should be smooth and slippery, slope drainage system should be established, and a wash floors and walls of the facility.

4.3.4 multi-plant quarantine measures should be taken to prevent the dusty air in series.

4.3.4.1 stairwell leading to the doorway should be installed on each floor can be self-closing doors or curtains.

4.3.4.2 Connections between floors when setting simple ladders, the position should be chosen from the dust-exposed point distant site.

4.3.4.3 for all kinds of equipment, Chute, the interlayer holes through floors and partitions on the pipeline, the gap should be sealed; all kinds of equipment, slide tube, Pipes should be closed, reducing the connection point or intermediate links, reduce material gap.

5 production process requirements

7.1.1 Basic requirements

7.1.1.1 ore crushing process of feeding, crushing, the material, it should be used to transport mechanical linkage operations, centralized control. Feeding, crushing should be set Horizon in the following order in the collecting and cutting.

7.1.1.2 When using a ball mill grinding process to prepare a large amount of mud workshop, should the feed, transportation, weighing, discharging processes to achieve mechanization; mud system A small amount of semi-mechanized workshops should be provided jobs and feeding platform.

7.1.1.3 using Raymond machine grinding process of the workshop, all the processes should adopt mechanization and automation of operations, dust control room and work area should be adopted Take quarantine measures.

7.1.1.4 easy to diffuse dust feed point, transit point and material discharge point, you must