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

GB 24388-2009

Noise limits for press brake and flanging machine

折弯机械 噪声限值

(English Translation)

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Foreword

3.1.1,3.2.1 this standard, as recommended in Chapter 4, the other mandatory.

The standard proposed by China Machinery Industry Federation.

This standard by the National Forging Machinery Standardization Technical Committee.

1 Scope

This standard specifies the mechanical bending of sound power level and sound pressure level of the noise limits.

This standard applies to bending machinery, including various types of sheet metal bending machine, folding machine.

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 23281-2009 forging machinery noise level measurement method GB/T 23282-2009 forging machinery sound power level measurement

3 Noise limits

Bending mechanical noise into sound power level, sound pressure level requirements, and according to the type of bending machine are given noise limits.

Noise limits 3.1 plate bending machine

3.1.1 Plate bending machine sound power level limits

Plate bending machine during continuous idling noise A-weighted sound power level LWA shall not exceed specified in Table 1.

Table 1

Plate bending machine Transmission Nominal force/kN limit sound power level LWA/dB (A)
 Mechanical transmission ≤ 630 100 $> 630 \sim 2500$ 110 Hydraulic transmission ≤ 630 95 $> 630 \sim 2500$ 100 > 2500 105

3.1.2 Plate bending machine sound pressure level limit

Table 2

Mechanical transmission ≤ 630 85 $> 630 \sim 250$ 090 Hydraulic transmission ≤ 630 82 $> 630 \sim 250$ 085 > 250 088 Impulse noise 3.1.3 plate bending machine SPL Specified in Table 3.

Table 3

≤ 630 95
 $> 630 \sim 2500$ 100

Noise limits 3.2 hemming machine

3.2.1 Flap machine sound power level limits

Folding machine during continuous idling noise A-weighted sound power level LWA shall not exceed the table 4.

Table 4

The number of swings folding beam can be folded thickness/mm sound power level limit value LWA/dB (A) ≤ 4 ≤ 2.5 95 > 102 2.5 > 4 ≤ 2.5 98 > 105 2.5

3.2.2 Flap machine sound pressure level limit

Table 5

≤ 2.5 82

> 2.5 86

<=2.5 84

> 2.5 88

3.2.3 Impulse noise folding machine SPL

Table 6

<=2.5 92

> 2.5 96

<=2.5 94

> 2.5 98

4.1 SPL Measurement

Noise level measurement method presses shall comply GB/T 23281-2009 of.

4.2 Sound power level measurement

Sound power level measurement of the press shall comply with GB/T 23282-2009 of.

4.3 Noise Measurement Description

4.3.1

factory test only measures the noise level.

4.3.2

The new design or improve the design, technology, materials, new products after the noise level should be measured during the performance test; can also be measured Sound power level to the noise level of conformity assessment basis.