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

GB 26485-2011

**Equipment for uncoiling, levelling and shearing line - Safety
requirements**

开卷矫平剪切生产线 安全要求

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Foreword

This standard 3.2,4.1,5.3,6.1.5,7.2,

10.1 bar is mandatory, the rest are recommended. The standard proposed by China Nonferrous Metals Industry Association. This standard Nonferrous Metals by the National Standardization Technical Committee. This standard is drafted by: Chongqing Boao Magnesium Co., LK Group Granville Technology Co., Ltd., China Nonferrous Metals Industry Standard Associate Institute of Metrology and Quality. Participated in the drafting of this standard. National Engineering Research Center of magnesium alloy, Nanjing Yunhai Special Metals Co., Ltd., Shanxi Wenxi silver magnesium (Group) Co., Ltd., Beijing Guangling Jinghua Science and Technology Co., Ltd., Beijing Nonferrous Metal Research Institute. The main drafters of this standard. Caojian Yong IMPERIAL Tao, Liu Zhaoming, Tsai Chi Heng, Yang Xiaojuan, Zhang. GB 26488-2011 Magnesium alloy die casting production safety norms

1 Scope

GB 26485-2011 is the Chinese national standard on equipment for uncoiling, levelling and shearing line - safety requirements, in the field of manufacturing engineering. It carries no /T suffix, which in the Chinese system means compliance is mandatory: a product or a practice within its scope has to meet it to be lawfully made, sold or carried out in China. It was issued on 12 May 2011 by the General Administration of Quality Supervision, Inspection and Quarantine of the People's Republic of China; Standardization Administration of China, and has been in force since 1 January 2012. Classification: ICS 25.120.10, CCS J62. 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 issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This standard specifies the production process of magnesium alloy die casting machines, peripheral equipment, furnaces, personal protection, related to the building structure and layout, Magnesium alloy waste, plant safety and other safety standards. This standard applies to all aspects related to magnesium alloy high pressure casting process.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version suitable for use herein Member. For undated references, the latest edition (including any amendments) applies to this document.

GB/T 11651 Personal protective equipment selection specification

GB 18218 hazardous chemicals major hazard identification

GB/T 20926 magnesium and magnesium alloy scrap

GB/T 28001 Occupational Health and Safety Management System

3 General Provisions

3.1 magnesium alloy die design and construction companies (including new and expansion) shall comply with the relevant national architectural design specification requirements of this standard, Does not meet the standard of existing enterprises, should develop security technologies action plan, in order to meet the requirements of production.

3.2 Corporate accordance with relevant provisions of GB 18218 and GB/T 28001 explosion of the enterprise, and other major fire hazards and functional Industry hazard factors identification, assessment, to determine the type, degree of harm dangerous hazards, the development of effective management control measures. Managers should Employee representatives and safety inspections to correct the unsafe operation and environment, to conform to the relevant provisions. Production sites should not be smoking. Should not be The use of fire operations, if you do need to use an open flame shall be approved by the manager or security officer at the scene confirmed, no security risks after listing operations.

3.3 enterprises should be combined with magnesium alloy die-casting production characteristics, the development of the enterprise security measures implementing rules and safety checklist, according to security checks Watch carefully checked. Enterprise checked at least once a month, shop at least once a week. Enterprises should do a good job of production safety education, general Magnesium alloys and safety knowledge and safety regulations, so that workers understand the characteristics of the safe production, professional staff to deal with technical and operational training, And after evaluation,

passing behind the prospective job. Enterprises should establish relevant security plan and organize exercises.

3.4 workshop near the top should have good ventilation, ventilation can not be provided in the melting furnace to prevent leaks. All security Facilities without the approval of the competent authorities, shall not be removed or diverted to other uses.

3.5 Enterprises should investigate all accidents and negligence, shall record the findings and corrective measures have to track.

4 Individual protection and rescue

4.1 Production personnel shall GB/T 11651 of the relevant provisions, the use of labor protection. Previous operators during the operation, press the Wear protective equipment requirements above, persons not wearing protective equipment is not allowed near the area of operation, are not allowed to operate the equipment.

4.2 in the workplace should use cotton clothing products, labor protection, production personnel should not be worn next to the skin making chemical fiber fabric of underwear.

4.3 non-automatic furnace feeding, should wear protective masks.

4.4 into the production site personnel should wear protective glasses. GB 26488-2011

4.5 Enterprises should develop accident rescue plan shall be approved by the competent authorities.

4.6 should be under the guidance of the local fire department, for all employees regularly put out the fire and rescue training. 5 building (structure) of the structure and layout

5.1 Buildings should be a single layer construction, lightweight roof structure is appropriate, you should use non-combustible materials, flooring materials or else water, heat.

5.2 equipment, beams, shelves, walls and other surfaces should have a structure easy to clean, and should not have an upward stitching plane.

5.3 Workshop sprinkler systems should not be used if the existing itself, the valve should be locked and wherein the water drained.

5.4 shall be a sufficient number of work area, setting a clear road signs and lighting emergency evacuation routes.

6 magnesium alloy die casting machine

6.1 Basic Safety Requirements

6.1.1 front door die-casting machine, after door, plate cover, tailgate cover, rear hinged cover plate, front cowl hinge, the hinge end of the cover plate, should have the necessary security Protection. Installation

6.1.2 magnesium alloy die-casting equipment should be in accordance with the requirements of the instructions of the equipment, equipment installation, when the first operation, should be the first point Jog motor to observe whether the motor rotation direction consistent with the direction of rotation allowed to the pump. Pump motor only in the manual mode is activated.

6.1.3 injection plunger lubricants should be water-soluble products, when using oil injection plunger lubricants, should pay attention to fire prevention.

6.1.4 die-casting mold temperature control to avoid the use of an aqueous medium heating (cooling) should be used in water-free oil heating (cooling) mode, and having Oil thermal protector mold temperature.

6.1.5 The operator shall at all sure that the machine safety features intact circumstances can start operating the machine. To ensure that the die-casting Before and after the safety door is closed, the operator should not stand in the parting surface. During operation, the operation of the workers should be thoroughly cleaned each injection nozzle, and note View Police punch is off or leaks.

6.1.6 The longer shutdown should shut off the main power supply, cooling water, compressed air and fluid release valve, the machine can not twist the arm straight locks clamping down Death, especially in the mold heating process.

6.1.7 Operation when found problems and failures is not allowed without changing the setting parameters of the technology and machinery. Die-punch should be used Piqing punch.

6.2 Basic Operation die casting machine safety norms

6.2.1 casting mold should be adjusted in manual mode, the installation of the mold should be front and rear safety door safety door open, and set a Key Selector beginning to "ON" to ensure that the mold, mold opening speed is low, the pressure is low pressure operation.

6.2.2 In the course of their work, the operator should stand when the plunger after the molten metal from the mold parting line injection on the human body without causing Guarding position hazards.

6.2.3 For operations workers into the casting mold for casting mold cavity surface was observed on the surface of the mold or repair and cleaning, Should press the emergency stop switch, the dangerous actions that might occur completely cut off.

6.2.4 For hot chamber die casting machine, injection around the mouth of the bezel not arbitrarily removed. In order to reduce the risk of molten metal splash. As for maintenance, When maintenance or removal and replacement requires the injection nozzle or removing the baffle, should be fully recovered after the order for production.

6.2.5 Isochronous it should die casting magnesium alloy cake is cooled to no risk of