

ICS 65.060.99

CCS B92



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

GB 7681-2008

Replacing GB 7681-1997

Safety technical requirements for choppers

铡草机 安全技术要求

Issued on: August 28, 2008

Implemented on: October 1, 2009

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China;
Standardization Administration of China**

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Foreword

All the technical contents of this standard is mandatory. This standard is GB 7681-1997 "chaff safety technical requirements" of the amendment. This standard compared with GB 7681-1997, the main changes are as follows:

- Redefined Normative contents of the file;
- Adjust the feed roller and the feed inlet hood horizontal distance requirements;
- Increased the cutter wheel requirements. Since the implementation of this standard replaces GB 7681-1997. Appendix A of this standard is the data appendix. The standard proposed by China Machinery Industry Federation. This standard by the National Standardization Technical Committee of agricultural machinery. This standard was drafted. Chinese Academy of Agricultural Mechanization Sciences Branch of Hohhot, Fengcheng, Liaoning Province, Dongfeng Machinery Factory. The main drafters of this standard. Yang Tiejun, Wang Jianping, LI Xiu-rong. This standard replaces the standards previously issued as follows:
 - GB 7681-1987, GB 7681-1997. Chaff Safety requirements

1 Scope

GB 7681-2008 is the Chinese national standard on safety technical requirements for choppers, in the field of agriculture. 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 28 August 2008 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 October 2009. Classification: ICS 65.060.99, CCS B92. 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.

12.9 Tightening torque tolerance value M6 11.5 13.5 18 M8 30 40 48 M10 50 70 85 M12 90 125 150 M16 225 310 375 M20 435 610 735 $\pm 20\%$ A.

2 Tightening torque measurement method The determination of the fastener tightening torque, the first marking the assembled position, then relax about 1/4 turn, using a torque wrench Back to the marking bit Home, this time the torque wrench values measured at this time is the fastener tightening torque.

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 3098.1 Mechanical properties of fasteners Bolts, screws and studs (GB/T 3098.1-2000, idt ISO 898-1.1999)

GB/T 3098.2 Mechanical properties of fasteners - Nuts - Coarse thread (GB/T 3098.2-2000, idt ISO 898-2.1992)

GB/T 9239.1 Mechanical vibration steady state (rigid) rotor balance quality requirements - Part 1. Specification and balance tolerance test (GB/T 9239.1-2006, ISO 1940-1.2003, IDT)

GB 10395.1 Tractors and machinery for agriculture and forestry - Safety requirements - Part 1. General (GB 10395.1-2001, eqv ISO 4254-1. 1989)

GB 10396 agricultural and forestry tractors and machinery, lawn and garden equipment - Safety signs and hazard pictorials - General principles (GB 10396- 2006, ISO 11684.1995, MOD)

3 Safety design requirements

3.1 chaff cutter design must meet the requirements of this standard.

3.2 chaff shall comply with the requirements of GB 10395.1, operating parts and feed entrance must have solid and reliable protection.

3.3 chaff should feed roll. When productivity is greater than 0.4t/h, the feed mechanism should clutch device.

3.4 chaff cutter outer edge of the feed roller feed inlet hood horizontal distance L shall meet the following requirements, shown in Figure 1. A) The productivity of not more than 0.4t/h, L should not be less than three times the width of the feed inlet;

b) productivity is greater than 0.4t/h when h, L should be not less than 550mm;

c) Where When using other agencies to meet the feed safety, L unrestricted. 1

--- feed inlet shield; 2

--- on the feed roller; 3

--- lower feed roll. Figure 1

3.5 Productivity greater than 2.5t/h of chaff cutter, automatic feed mechanism should be set up.

3.6 on the cabinet with locking devices, and secure.

3.7 Fixed, fixed blade fasteners mechanical performance levels should be consistent with GB/T 3098.1 and GB/T 3098.2 regulations bolt (screw) should not Less than 8.8; nut is not less than 8; and a reliable locking device.

3.8 Productivity greater than 2.5t/h of chaff, should be set overload protection device.

3.9 cutter wheel without cracks, may not affect the strength and appearance of porosity, shrinkage, trachoma and other casting defects.

4 Manufacturing and acceptance requirements

Chaff and acceptance must be manufactured according to the requirements of the standard. In the housing and feeding parts should be obvious entrance guard safety signs, safety signs shall comply with the provisions of GB 10396.

5 Safety requirements

You must be familiar with the instructions before using the

5.2 product specification shall detail the safe use regulations, which includes.

a) require the use of the instructions before starting to adjust and maintenance; check whether the fastener tightened, the cutter wheel steering whether the provisions In the same direction, whether the cabinet lock and so on.

b) chaff workplace should be spacious and equipped with reliable fire safety.

c) should be used in accordance with the motor's nameplate chaff. Are not allowed to arbitrarily increase the spindle speed, not allowed to freely tear down the various parts of the guard Means.

- d) Replace the move, when the fixed blade fastener can not be replaced with ordinary fasteners.
- e) In case of abnormal noise when the job should immediately stop inspection, troubleshooting is prohibited while the machine is running.
- f) has not mastered the rules of safe use of chaff are not allowed to work alone.
- g) prohibited minors and drink, fatigue sick person or the boot job.

Appendix A

(Informative) Fixed, fixed blade fastener tightening torque values and their determination A.
1 move, fixed blade fastener tightening torque should not be less than Table A. Provisions 1.
Table A.