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

GB/T 25155-2026

Replacing GB/T 25155-2010

Daylight presses

平板硫化机

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5 Technical Requirements

5.1 The flat vulcanizing machine shall meet all the requirements of this document and be manufactured in accordance with the drawings and technical documents approved through the prescribed procedures.

5.2 The hydraulic system shall meet the following requirements.

- a) The hydraulic system conforms to the requirements of GB/T 3766.
- b) Pressure drop in the hydraulic system when the working fluid reaches the working pressure. 1) For flat vulcanizing machines with a clamping force less than or equal to 2.5MN, a holding time greater than or equal to 10 minutes, and a pressure drop not exceeding the working pressure. 10% of the pressure; 2) For flat vulcanizing machines with a clamping force greater than 2.5MN, the holding time should be greater than or equal to 60 minutes, and the pressure drop should not exceed the working pressure. 10%.
- c) When the pressure drop of the hydraulic system exceeds the specified value, the hydraulic system has the function of automatically replenishing the pressure to the working pressure.

5.3 The hydraulic system and hot plate of the flat vulcanizing machine shall undergo a pressure resistance test and there shall be no external leakage.

5.4 The maximum operating temperature that the hot plate should be able to reach.

- a) Steam heating at 180°C;
- b) Heat the oil to 200°C;

- c) Electric heating is at 230°C;
- d) Electromagnetic induction heating at 250°C.

5.5 Temperature difference at the working surface of the hot plate when the temperature reaches a stable state.

- a) Steam heating, oil heating, and electromagnetic induction heating. should be within $\pm 1.5^{\circ}\text{C}$;
- b) Electric heating. When the hot plate size is greater than or equal to 1000mm x 1000mm, the temperature should be less than or equal to $\pm 5^{\circ}\text{C}$; when the hot plate size is less than... For 1000mmx1000mm, the temperature should be within $\pm 3^{\circ}\text{C}$.

6 Safety Requirements

The safety requirements for flat vulcanizing machines shall comply with the provisions of GB/T 25432.

7.1 No-load test

7.1.1 Before the no-load test, the following checks shall be performed in accordance with the requirements of 5.2, 5.3, 5.8,

7.1.2 The no-load test shall be carried out after the whole machine is assembled. It shall be inspected in accordance with the provisions of 5.2,

5.7 and 5.9. Only after passing the test can the load test be carried out.

7.2 Load Operation Test The load operation test shall be conducted in accordance with the provisions of 5.4, 5.5,

5.6 and 5.11. The load operation test may be conducted at the user's location.

8.1 Technical Requirements

8.1.1 Testing of the main precision and performance of the flat vulcanizing machine. It shall be carried out in accordance with the provisions of HG/T 3229.

8.1.2 Maximum Working Pressure Test. The set pressure of the steam heating and oil heating systems shall not be less than the maximum working pressure, and the pressure holding time shall be greater than or equal to the maximum working pressure. Observe for any leakage after 30 minutes.

8.1.3 Hot Plate Pressure Resistance Test. The hot plate of the flat vulcanizing machine shall be subjected to a water pressure test of not less than

1.5 MPa, and the pressure holding time shall be greater than or equal to Observe for any leakage after 1 hour.

8.2 Safety Requirements Safety requirements verification for flat vulcanizing machines shall be conducted in accordance with the provisions of GB/T 25432.

9.1 Factory Inspection

9.1.1 Each product shall be inspected and approved by the manufacturer's product inspection department before leaving the factory, and shall be accompanied by a product quality certificate.

9.1.2 Each product shall undergo a no-load test in accordance with the provisions of 7.1 before leaving the factory, and a load test may be conducted in accordance with the provisions of 7.2.

9.1.3 The factory inspection items for each product are 5.2, 5.3, 5.7, 5.8, 5.9, 5.10, 5.12 and Chapter

6. All factory inspection items must comply with... This document stipulates that it is considered qualified at the specified time.

9.2 Type Testing

9.2.1 Type testing shall be conducted under any of the following circumstances.

- When new products or old products are transferred to another factory for production;
- If significant changes occur in materials, structure, or processes after formal production, potentially affecting product performance;
- When production resumes after a long period of shutdown (2 years or more);
- When the factory inspection results differ significantly from the previous type inspection results;
- During normal production, at least one unit is randomly inspected each year.

9.2.2 Type testing shall be conducted in accordance with the provisions of this document.

9.2.3 If all type test items comply with the provisions of this document, the type is considered (qualified). One unit shall be randomly selected for each type test. If any unit fails the test, [the following should be done]. Two more units will be randomly sampled for inspection. If there are still non-conforming items, then each unit of the product should be inspected.

10 Marking, Packaging, Transportation and Storage

10.1 Each product shall have a product label affixed to a conspicuous location. The size and technical requirements of the label shall comply with the provisions of GB/T 13306. The

content of the sign should include.

- Manufacturer's name and trademark;
- Product name and model specifications;
- Main technical parameters of the product;
- Execution standard number;
- Manufacturing date and product number.

10.2 The product instruction manual shall comply with the provisions of GB/T 9969 and GB/T 25432.

10.3 After passing the no-load operation test or load operation test, before delivery for packaging, transportation, or storage, the water and... Drain the oil from the reducer.

10.4 Product packaging shall comply with the provisions of GB/T 13384.

10.5 The graphic symbols used for packaging and storage of products shall comply with the provisions of GB/T 191.

10.6 The transportation of products shall comply with the provisions of GB/T 6388.

10.7 The product should be stored in a well-ventilated, dry place free from fire sources and corrosive gases. When stored outdoors, rain protection measures should be taken.