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

GB/T 25218-2010

**Grain and oil machinery - General specification for the painting
of products**

粮油机械 产品涂装通用技术条件

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Quarantine;
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Foreword

This standard is proposed by the National Grain Bureau. This standard by the National Grain Standardization Technical Committee. The drafting of this standard unit. Henan University of Technology, Jiangsu Shepherd Group Co., Ltd. The main drafters of this standard. Wu Wenbin, Wang Yuanming, Wang Xin. General technical conditions for coating of grain and oil machinery products

1 Scope

China's national general specification for the painting of grain and oil processing machinery. It specifies the surface preparation, the coating systems, the application, the requirements and the inspection for the paint finish of grain and oil machinery. Painting a machine is normally treated as a finishing operation and specified loosely, and this standard exists because in this industry it cannot be. Grain and oil machinery works in three conditions that punish a coating and one that makes a failed coating a food safety matter. The atmosphere is dust-laden and abrasive, so a soft or thin film is worn through at every point where product moves against it. The plant is washed down, and in oil processing it meets hot oil, solvent and steam, which soften and lift coatings not chosen for them. The equipment stands in unheated buildings and outdoors in silo installations, through condensation cycles that corrode from beneath a film that has lost adhesion. And the machinery is in contact with food: a coating that chalks, flakes or leaches puts its own material into the grain or the oil, so the choice of system on contact surfaces is a compositional question as well as a protective one. The standard therefore fixes the surface preparation and its grade, which is where nearly all coating failures actually originate; the coating systems appropriate to each part of a machine, distinguishing food contact surfaces, wetted surfaces, external surfaces and machined surfaces protected temporarily; the film thickness and the number of coats; the application conditions; and the inspection - adhesion, thickness, appearance and the absence of defects. Issued on 26 September 2010 and in force since 1 March 2011.

This standard specifies the terms and definitions of product coating, technical requirements, test methods, inspection rules, transportation and storage requirements. This standard applies to grain and oil machinery coating.

2 Normative reference documents

The terms of the following documents are hereby incorporated by reference into this standard. Whichever is the date of the reference file, which is followed by all (Excluding corrigenda) or revisions do not apply to this standard, however, encourage the parties to reach an agreement under this standard Whether you can use the latest version of these files. For undated references, the latest edition applies to this standard.

GB/T 1727 film general preparation method

GB/T 1732 Determination of impact resistance of paint film Test method for moisture resistance of paint film GB/T Methods for rating aging of paints and varnishes - Coatings GB/T 1766-2008

GB/T 3181 film color standard Paints and varnishes - Adhesion test of GB/T 5210-2006

GB/T 6739 Paint and varnish pencil method for determination of film hardness

GB 7691 Painting Operation Safety Code Safety Management General

GB/T 9754 Paints and varnishes Metallic paint-free paint finish at 20 °, 60 ° and 85 ° specular gloss

GB/T 13452.2 Paints and varnishes - Determination of film thickness

3 Terms and definitions

The following terms and definitions apply to this standard.

3.1 Coatings Painted on the surface of the object anti-corrosion or decorative role in a variety of oils, paints, plastics and pigments.

3.2 Painted paint The coating process is applied to the surface of the machine and the component.

3.3 Coatings paintingfilm A film formed on the surface of an object.

3.4 Brush marks Coated with paint coating, drying the surface of the film after leaving the brush pattern.

3.5 Orange peel After coating and drying with paint, the surface of the coating film is similar to orange peel.