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

GB/T 25936.4-2024

**Rubber and plastics size reduction machines - Part 4: Safety
requirements for agglomerators**

橡胶塑料粉碎机械 第4部分：团粒机安全要求

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Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for standardization work Part

1. Structure and drafting rules for standardization documents" Drafting is required. This document is part 4 of GB/T 25936 Rubber and Plastics Crushing Machinery. GB/T 25936 has been published in the following parts. -- Part

1 Scope

GB/T 25936.4-2024 is Part 4 of the Chinese safety series for rubber and plastics size reduction machinery, and covers agglomerators - the machines that densify film, fibre and foam scrap by frictional heating until it balls up, then shock it with water. The hazard set is broader than a cutting machine's, because the material inside is hot enough to burn and can ignite, the process releases dust and fumes, and the operator works at a charging opening above a fast rotor. The standard sets the safety requirements and protective or risk reduction measures for the general case, the mechanical hazards, the thermal hazards, the noise hazards, the hazards from dust, fumes and gases, the electrical hazards, the

emergency stop, stop and start functions, unexpected start-up, and falls from height, then the verification of those measures and the information for use, covering the instruction handbook, the marking and the warning signs. It takes effect on 1 July 2025.

2.General rules for the design and testing of pressure-sensitive edges and pressure-sensitive rods

3.Pressure-sensitive buffers, pressure-sensitive plates, pressure-sensitive wires and similar devices General principles for design and testing

2 Normative references

The contents of the following documents constitute the essential clauses of this document through normative references in this document. For referenced documents without a date, only the version corresponding to that date applies to this document; for referenced documents without a date, the latest version (including all amendments) applies to This document.

GB/T 3767 Acoustics - Determination of sound power level and sound energy level of noise source by sound pressure method - Engineering method for approximate free field above reflecting surface

GB/T 5226.1-2019 Electrical safety of machinery Electrical equipment of machinery Part

GB/T 17248.2 Acoustic machines and equipment emit noise above a reflecting surface with negligible environmental correction approximate free Field determination of emission sound pressure levels at working positions and other specified locations

GB/T 17248.3-2018 Acoustics - Noise emitted by machines and equipment measured at working positions and other locations using approximate environmental corrections Emission sound pressure level at a specified location

GB/T 17248.5-2018 Noise emitted by acoustic machines and equipment is measured using accurate environmental corrections for working positions and other indicators. Emission sound pressure level at a fixed position

GB/T 17454.2 Safety of machinery - Pressure-sensitive protective devices - Part

GB/T 17454.3 Safety of machinery - Pressure-sensitive protective devices - Part

GB/T 17888 (all parts) Safety of machinery - Fixed devices for access to machinery

GB/T 18153 Safety of machinery - Ergonomic data for determining hot surface temperature limits - Accessible surface temperature

GB/T 18831 Design and selection principles for interlocking devices related to mechanical safety and protective devices

3 Safety requirements for shredders; -- Part

4.Safety requirements for pelletizers. This document replaces GB 25936.4-2010 "Rubber and plastics crushing machinery Part

4.Safety requirements for pelletizers" and is consistent with GB 25936.4- Compared with.2010, in addition to structural adjustments and editorial modifications, the main technical changes are as follows:

- a) The scope of this document has been changed (see Chapter 1, Chapter 1 of the.2010 edition);
- b) Three terms and definitions such as "agglomerator" have been changed (see 3.1 to 3.3, 3.1, 3.3, 3.6 of the.2010 edition);
- c) The terms and definitions of "feeding and discharge openings on the pelletizing chamber", "fixed feeding device" and "feeding system" have been deleted (see.2010 versions 3.2, 3, 4 and 3.5);
- d) Added the requirements for the performance level PLr of the safety-related components of the control system (see 4.2.1.1, 4.2.1.3, 4.2.1.6, 4.2.1.7, 4.2.2, 4.2.3.1, 4.7.1, 4.7.2, 4.8);
- e) Added requirements for openings exceeding 500 mm x 400 mm (see 4.2.1.4);
- f) Added requirements when manual rotation of pelletizing cutter is not possible (see 4.2.1.6);
- g) Added requirements to prevent blockage of pelletizing cutters (see 4.2.1.7);
- h) Changed the requirements for feeding of non-pre-cut materials (see 4.2.2, 5.2.2 of the.2010 edition);
- i) The requirements for parts or materials to be ejected from the pelletizing chamber and the strength of the pelletizing chamber have been deleted (see