

ICS 25.120.30

CCS J 61



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

GB/T 47253-2026

**Foundry machinery - Ladles, pouring machines and associated
equipment - Safety technical specification**

铸造机械 浇包、浇注机及相关设备 安全技术规范

Issued on: February 27, 2026

Implemented on: September 1, 2026

**Issued by: State Administration for Market Regulation;
Standardization Administration of the PRC**

Table of Contents

1.Scope	1
2 Normative References	1
3.Terms and Definitions	2
4.1 General Rules	4
4.2 General Requirements	5
4.3 Specialized Equipment Requirements	7
5.Verification of safety requirements and/or risk reduction measures	14
5.1 Verification Method	14
5.2 Verification Checklist	15
6.Information	15
6.1 General Requirements	15
6.2 Signal and Warning Devices	15
6.3 Signs, Symbols (Pictographic) and Written Warnings	15
17 Table B.1 Verification Checklist for Safety Requirements and/or Risk Mitigation Measures	19

Foreword

This document complies with the provisions of GB/T 1.1-2020 "Standardization Work Guidelines Part

1.Structure and Drafting Rules of Standardization Documents". Drafting. Please note that some content in this document may involve patents. The issuing organization of this document assumes no responsibility for identifying patents. This document was proposed by the China Machinery Industry Federation. This document is under the jurisdiction of the National Technical Committee on Standardization of Foundry Machinery (SAC/TC186). This document was drafted by: Weihai Gongyou Foundry Machinery Co., Ltd., Shandong Jiechuang Machinery Co., Ltd., and Qingdao Zhongzhida Environmental Protection Smelting Equipment. Limited Liability Company, Qingdao Kaijie Heavy Industry Machinery Co., Ltd., Nan'an Zhongji Standardization Research Institute Co., Ltd., Xiamen CIMC Xinzhi Testing Equipment Co., Ltd. Limited Company, Qingdao Beno Magnetic & Electric Technology Co., Ltd., Zhejiang Wanfeng Technology Development Co., Ltd., Zhejiang Kabo Copper Industry Co., Ltd., Jinhua Hao Xiangqi Parts Co., Ltd., Shenyang Yate Heavy Equipment Manufacturing Co., Ltd., China Automotive Engineering Co., Ltd., Jiangsu Dongfang Zhonglian Industrial Technology Co., Ltd. Technology Co., Ltd., Fujian Minxuan

Technology Co., Ltd., Jinan Foundry & Forging Institute Inspection and Testing Technology Co., Ltd., Qingdao Huihong Liangtai Intelligent Equipment Co., Ltd. Equipment Co., Ltd., Jiangyin Foundry Equipment Factory Co., Ltd., Qingdao Qingli Environmental Protection Equipment Co., Ltd., Baoding Weier Foundry Machinery Co., Ltd. Company, Qingdao Antai Heavy Industry Machinery Co., Ltd., Anhui Anhuang Machinery Co., Ltd., China Machinery Research Institute (Beijing) Co., Ltd. The main drafters of this document are. Chi Yingjie, Zhao Peng, Zhang Jie, Duan Jinting, Su Liguang, Ke Zhenzhen, Xiang Yang, Li Haichun, Wu Jinhua, Wu Jun, and Jiang Baiqing. Yang Hao, Yang Liangqun, Jia Chunyang, Li Yansong, Liu Xiaolong, Wang Ridong, Zhu Bin, Wu Jiqiu, Qiang Zicong, Li Chen, Wang Hua, Nie Yuhang, Chen Liang, Xia Xinhai Ma Minghui, Hou Ruoxian, Wang Qingfeng, Ding Shimiao, Zhang Xiaofei.

According to the classification of GB/T 15706-2012, this document belongs to Class C standards. This document is particularly relevant to the following stakeholders related to machinery safety.

---Machine manufacturer;

---Health and Safety Agency. Other stakeholders affected by the level of mechanical safety include.

---Machine owner;

---Machine users;

---Service personnel. All of the aforementioned stakeholders may participate in the drafting of this document. The scope of the machines covered in this document, as well as the hazards, hazardous conditions, and hazardous events covered, is given in the scope of this document. When the requirements in this document differ from those in Category A or Category B standards, for machines designed and manufactured in accordance with this document... For this instrument, the requirements in this document take precedence over the requirements in other standards. Foundry machinery, ladles, casting machines and related equipment Safety Technical Specifications

1 Scope

GB/T 47253-2026 is the Chinese national standard covering moving and pouring molten metal - the ladle and its trunnions and tilting gear, the transport and the automatic pouring machine, and the requirement that a full ladle cannot be dropped or tipped by a single failure. It is one of seven foundry machinery safety standards published together on 27 February 2026, which between them cover a whole foundry: melting, moulding and coremaking, pouring, shakeout, blasting, sand plant and die casting. First edition, in force since 1 September 2026. It was issued on 27 February 2026 and has been in force since 1 September 2026, as a first edition. The document is under the responsibility of the China Machinery Industry Federation. This page is published from the official record of the 2026

edition; the clause text of a standard this recent is not yet in circulation, and the figures, limits and tables it contains are those of the document itself, delivered in full with the English translation.

This document specifies the safety requirements and/or risk mitigation measures and usage information for ladles, casting machines, and related equipment, and describes the corresponding... Verification method. This document outlines the intended use of ladles, casting machines, and related equipment, as well as their use under conditions of misuse that the manufacturer could reasonably foresee. Examples of major hazards, hazardous conditions, or hazardous events associated with this type of equipment (see Appendix A). This document applies to the design, manufacture, and acceptance of ladles, casting machines, and related equipment.

Note. This document applies to equipment including ladles, pouring ring tracks, ladle dryers, pouring machines, and automatic molten metal transfer systems.

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are not included. For references to documents, only the version corresponding to that date applies to this document; for undated references, the latest version (including all amendments) applies. This document.

GB 2894 Safety Colors and Safety Signs

GB/T 3766-2015 General rules and safety requirements for hydraulic transmission systems and their components

GB/T 4208-2017 Degrees of protection provided by enclosures (IP code)

GB/T 5226.1-2019 Electrical Safety of Machinery - Electrical Equipment of Machinery - Part