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**Grain and oil machinery - Complete processing equipment for
dried noodles**

粮油机械 挂面成套生产设备

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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 National Food and Strategic Reserves Administration. This document is under the jurisdiction of the National Technical Committee on Standardization of Grain and Oil (SAC/TC 270) and is managed by the National Technical Committee on Standardization of Food Processing Machinery. The meeting (SAC/TC 551) is under the deputy jurisdiction of the committee. This document was drafted by: Qingdao Haikejia Intelligent Technology Co.,

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1.Scope This document specifies the model, basic parameters, composition, working conditions, and technical requirements of complete sets of noodle production equipment (hereinafter referred to as complete sets of equipment). Requirements for inspection, marking, packaging, transportation and storage are specified, and corresponding test methods are described. This document applies to complete sets of noodle production equipment.

4 Model, basic parameters, composition and operating conditions

4.1 Model Number Designation Method Follow Appendix A.

4.2 Basic Parameters Information such as model number, specifications, production capacity, motor power, speed, and dimensions should be clearly indicated in technical documents such as the instruction manual.

4.3 Composition

4.3.1 A complete set of noodle production equipment should include the following basic configurations;

- a) Intelligent control system;
- b) Powder supply system;
- c) Liquid supply system (automatic water dispenser);
- d) Dough mixing equipment (powder-water mixer, dough mixer);
- e) Curing equipment;
- f) Dough sheet forming machine;
- g) Continuous tablet press (tablet rolling mill, tablet press, calendering equipment);
- h) Strip cutter;
- i) Mounting device;
- j) Drying oven conveyor system;

- k) Intake and exhaust systems;
- l) Hot air mixing system;
- m) Temperature and humidity control system;

4.4 Working Conditions

4.4.1 The working environment temperature is 10 °C~35 °C, and the relative humidity is 50%~70%.

4.4.2 The power supply voltage should be stable, and the deviation from the rated voltage should meet the usage requirements of the equipment.

4.4.3 The compressed air source pressure should be

0.6 MPa to

0.8 MPa. The compressed air purification level should comply with GB/T 13277.1-2023. The specified grades are: solid particles (Grade 4), water (Grade 4), and oil (Grade 3).

5.1 General Requirements

5.1.1 The equipment should operate smoothly, and the moving parts should move accurately, sensitively, and in a coordinated manner, without jamming or abnormal noise.

5.1.2 The air passages and lubrication systems of the equipment should be unobstructed and leak-free.

5.1.3 The powder supply system and liquid supply system shall have the function of automatic proportioning according to the formula.

5.1.4 The dough mixing equipment should have a function to stop the machine when the lid is opened.

5.1.5 The drive motors of the strip cutter, drying oven conveyor, and hot air mixing system should have automatic speed regulation function.

5.1.6 The temperature and humidity control system shall meet the requirements of

5.6.3 in JB/T 13179-2017.

5.1.7 The instruction manuals for complete sets of equipment and individual equipment shall comply with the provisions of GB/T 9969.

5.2 Performance Requirements

5.2.1 Production Capacity It should meet the rated production capacity requirements.

5.2.2 Dimensional Acceptance Rate

5.2.2.1 The thickness and width deviation of the noodles should not exceed 5%.

5.2.2.2 The deviation of the hanging length should not be greater than ± 10 mm.

5.2.2.3 The dimensional compliance rate shall not be less than 95%.

5.2.3 Drop Rate The rod drop rate during production should not exceed 0.3%.

5.2.4 Mean Time Between Failures (MTBF) The mean time between failures (MTBF) should not be less than 500 hours.

5.2.5 Energy conservation and environmental protection requirements

5.2.5.1 Under normal operating conditions, the operating noise (sound power level) of the equipment should not exceed 80 dB(A).

5.2.5.2 Energy-saving equipment such as air source heat pumps and geothermal energy should be used, and the overall energy consumption of the finished product should not exceed

0.25 kW·h/kg.

Note. Calculated in electrical energy equivalent.

5.3 Intelligent Control Requirements

5.3.1.1 The temperature and humidity of different zones in the drying room should be monitored online.

5.3.1.2 It should be able to automatically acquire the process operating parameters of the complete set of equipment. The process operating parameters are shown in Appendix B.

5.3.1.3 It should have the function of automatic capacity matching and adaptation.

5.3.1.4 It should have intelligent alarm functions such as fault alarm, over-temperature alarm, and leakage alarm.

5.3.1.5 It should have linkage protection function, as well as data statistics and data storage functions.

5.3.1.6 During system operation, manual adjustment should be allowed, and adaptive manual adjustment function should be available.

5.4 Safety Requirements Structural material requirements, equipment structure, and equipment configuration and installation requirements shall comply with the provisions of GB 16798.