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

**GBZ/T 287-2017**

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**Guidelines for prevention and control of occupational hazards  
in wood processing industry**

木材加工企业职业危害预防控制指南

**(English Translation)**

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### Foreword

This standard is formulated in accordance with the Law of the People's Republic this standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard was drafted. Wood Conservation Development Center, National Wood and Wood Products Performance Quality Supervision and Inspection Center, China Wood Protection Worker Industry Association, China Wood and Wood Products Circulation Association.

### 1 Scope

This standard stipulates the basic requirements for the prevention and control of occupational hazards in wood processing enterprises, the identification and distribution of occupational hazards, and occupational hazards.

Critical control measures, personal protection, accident emergency, occupational health management and education, occupational health monitoring and other requirements.

This standard is applicable to occupational hazard prevention and control of enterprises involved in wood processing, wood product manufacturing and storage.

## 2 Normative references

The following documents are indispensable for the application of this document. For dated references, only the dated version applies to this document.

For undated references, the latest edition (including all amendments) applies to this document.

GBZ 1 industrial enterprise design hygiene standard GBZ 2.1 Occupational exposure limits for workplace hazards Part 1. Chemically harmful factors GBZ 2.2 Occupational exposure limits for workplace hazards Part 2. Physical factors GBZ 158 workplace occupational hazard warning sign GBZ 188 Occupational Health Monitoring Technical Specifications GBZ 203 High-toxic goods operation post occupational disease hazard notification specification GBZ/T 224 Occupational Hygiene Terminology GB 6514 Painting operation safety regulations Painting process safety and ventilation purification GB/T 11651 personal protective equipment selection specification GB 15603 Common chemical dangerous goods storage rules Classification and technical conditions of GB/T 16758 exhaust hood GB 17916 Poisonous commodity storage and maintenance technical conditions GB/T 18259 wood-based panel and its surface decoration terminology GB .20101 Safety rules for painting operations - Safety regulations for organic waste gas purification devices GB/T 28202 furniture industry terminology GB 50019 Heating, Ventilation and Air Conditioning Design Code GB 50033 Architectural Lighting Design Standard GB 50034 Architectural lighting design standard

## 3 Terms and definitions

GBZ/T 224, GB/T 18259, GB/T 28202, and the following terms and definitions apply to this document.

Wood processing

The production of wood products by wood or semi-finished products is made mechanically or chemically. Including wood cutting, drying, gluing, Basic processing such as surface decoration, as well as functional processing such as wood protection and modification. The main product types include wood-based panels, flooring and wood Furniture, etc.

## 4 Basic requirements

### 4.1

The occupational hazard prevention and control work of wood processing enterprises should adhere to the work principle of prevention and prevention.

#### 4.2

The construction of wood processing, manufacturing, storage and other engineering construction projects should follow the principle of "three simultaneous", and its occupational hazard protection facilities should be related to the main the physical engineering is designed, constructed and put into use at the same time.

#### 4.3

Wood processing enterprises should adopt new processes, new equipment and new technologies to improve the level of mechanization and automation and reduce the production process.

Occupational hazards. For processes, sections and equipment that generate dust, electromagnetic radiation, chemical poisons, it is advisable to adopt a closed or isolated side.

To control occupational hazards to the smallest possible extent.

#### 4.4

It is not advisable to use the fully enclosed, mechanized and automated production methods to effectively control the influence of dust, chemical poisons and other factors.

Closed ventilation, dust removal and detoxification technical measures, and the use of air supply and ventilation devices to reduce the dust, chemical poisons and other harmful factors in the overall operating environment influences.

#### 4.5

The post-operating personnel who are exposed to occupational hazards should strengthen their personal protection and distribute effective personal protective equipment.

#### 4.6

A warning sign and an occupational hazard notification card should be set up in a conspicuous position in the production section or post. The warning sign should be set in accordance with GBZ the requirements of 158, the setting of the Occupational Disease Hazard Notification Card shall comply with the requirements of GBZ 203.

#### 4.7

Wood processing enterprises should conduct regular inspections on the environment of wood processing, manufacturing and storage operations, and should continue to improve through Control measures to make the concentration or intensity of occupational hazards meet the requirements of occupational exposure limits for harmful factors specified in GBZ 2.1 and GBZ 2.2.

## **5.1 Identification of occupational hazards**

Wood processing enterprises should scientifically identify and determine the types, nature and concentrations of occupational hazards present in the production process of the unit.

(strength).

## **5.2 Main process**

The main process flow of wood-based panels is. machining (saw, cutting,, drilling, planing, milling, grinding) -> drying -> sizing -> hot pressing and bonding -> after Processing -> packaging the main process of wooden floor is. machining (saw, cutting,, drilling, planing, milling) -> drying -> coating -> blanking -> thermoforming ->

Sanding->Coating->Curing->Opening Groove->Packaging the main technological process of wooden furniture is. machining (saw, cutting,, drilling, planing, milling) -> drying -> painting -> curing -> grinding -> loading Match -> packaging Other products are implemented with reference to the above three types of products.

## **5.3.1 Productive dust**

### **5.3.1.1**

Productive dust mainly exists in the process of machining and post-processing in the production of wood-based panels; machining in the production of wooden flooring, Sanding, grooving and other processes; machining, grinding and other processes in the production of wooden furniture.

### **5.3.1.2**

The production dust is mainly wood dust, which is mainly found in sawing, cutting, planing, sanding, grinding and grinding of wood materials.

## **5.3.2 Chemical poisons**

### **5.3.2.1**

Chemical poisons mainly exist in the process of sizing, gluing, etc. in the production process of wood-based panels;

Processes such as finishing and curing; processes such as finishing and curing in the production of wooden furniture.

### **5.3.2.2**

Chemical poisons are mainly organic volatiles in adhesives and paints, mainly in sizing, hot pressing, finishing and curing.