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SB

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

SB/T 10131-2012

Replacing SB/T 10131-1992

**Technical specifications for stamping hard candy forming
machine**

(English Translation)

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard is a revision of SB/T 10131-1992 "Technical Conditions for Printed Hard Candy Forming Machines". This standard and SB/T 10131-Compared with 1992, the main technical changes are as follows.

1. In the provisions of the normative reference documents, the referenced standard adopts the latest version, and GB/T 13306 is added according to the standard terms.

GB 16798 and other standards have deleted GB/T 2828.1, GB/T 2829 and other standards.

2. In terms of terminology and definitions, a number of terms and definitions of product structure have been added.

3. In the required regulations, the terms are in accordance with general requirements, mechanical safety, electrical safety, thermal safety, hygiene, noise, performance and use, the signs, packaging, transportation, storage, etc. are rearranged in order, with emphasis on safety, hygiene and energy conservation requirements.

1) Added the following terms.

--- Mechanical safety. 4.2.1 General, 4.2.6 wear resistance of important parts;

---Hot safety. 4.4.1 General, 4.4.2 Sugar bars are safe to run, 4.4.3 Sugar bars are safely imported;

--- Hygiene. 4.5.2 to avoid food residues, 4.5.4 structural disassembly and cleaning, 4.5.5 surface coating;

---Performance. 4.7.1 General, 4.7.7 Sugar block thickness adjustment;

--- Use. 4.8.1.2 After technical training, 4.8.1.3 Obey the operating procedures.

2) The following terms have been amended.

--- The original standard 4.6.5 product electrical safety provisions are embodied, become

the standard of this standard 4.3. 4.3.1 General, 4.3.2 electrical Component quality, 4.3.3 electrical components installation, 4.3.4 electrical insulation, 4.3.5 wire color and label, 4.3.6 wire Wiring and fixing, 4.3.7 grounding, 4.3.8 electrical components waterproof, 4.3.9 electrical components insulation, 4.3.10 electrical Component heat dissipation, 4.3.11 mechanical protection of electrical equipment;

--- Change the noise limit of 95dB (A) specified in the original standard 4.3.5 to 80dB (A) of 4.6.2 of this standard;

--- The original standard 4.7 specifies the no-load and load power of the motor. This standard 4.7.2 retains the motor load power and deletes no-load power;

--- The original standard 4.3.4 and 4.5.2 stipulate the value of the sugar block parameter. The sugar block parameters specified in 4.7.3 of this standard are determined by the manufacturer, or Determined by the manufacturer and the user, and the actual measured value is within $\pm 5\%$ of the promised (or negotiated) value;

--- The original standard 4.3.2 specifies the production capacity. The production capacity specified in 4.7.4 of this standard is determined by the manufacturer or manufactured by the factory negotiates with the user to determine, and stipulates that the measured value is within $\pm 2\%$ of the promised (or negotiated) value;

--- The original standards 4.3.2 and 4.3.3 specify the logarithm of the rotary head die and the speed range. This standard 4.7.5 specifies the rotary head punch the modulus and speed of the mold are determined by the manufacturer, or determined by the manufacturer and the user, and the recommended range of values is given;

--- Change the temperature of the sugar strip in the original standard 4.2.2 from 70 ° C to 80 ° C to 80 ° C ~ 90 ° C of this standard 4.8.1.1;

---Partial provisions of the technical conditions of the original standard Appendix A wheel head are incorporated into the standard 4.2.7 parts processing and assembly Sex, 4.2.5 moving parts run smoothly.

3) The following terms have been removed.

--- Original standard 4.8.2 spindle and wheel head hole matching requirements;

---The original standard 4.9.3 thread connection requirements;

--- The original standard 4.4 product average life and trouble-free working hours.

4. In the provisions of the test method, according to the provisions of Chapter 4 of this standard, the test method of the project is correspondingly reserved and increased.

Add, modify, and delete.

5. In the provisions of the inspection rules, the inspection items and the qualification judgment conditions have been modified, according to the small batch production of the

products, the batch is not fixed.

In actual conditions, the original standard was deleted in accordance with the inspection rules stipulated in GB/T 2828.1 and GB/T 2829, and the requirements for the factory inspection project were revised.

The Ministry is qualified (6.3), the type test items are divided into key items and general items, and the key items are all qualified. The general item allows the failure rate to be 15% (6.7).

6. Added provisions for the use of information, including the scope of supply of the original standard 4.10 product package.

7. Deleted the original standard Appendix A.

This standard was proposed by the Ministry of Commerce of the People's Republic this standard is under the jurisdiction of the National Commercial Machinery Standardization Technical Committee (SAC/TC111).

This standard was drafted. Zhejiang Gongshang University, Beijing Product Quality Supervision and Inspection Institute, Beijing Service Machinery Research Institute.

1 Scope

This standard specifies the terms and definitions, requirements, test methods, inspection rules, and use of the printing type hard candy forming machine (hereinafter referred to as the product).

information.

This standard applies to the design, manufacture, use and inspection of printing hard candy forming machines.

2 Normative references

The following documents are indispensable for the application of this document. For dated references, only dated versions apply to this article.

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

GB/T 3768-1996 Acoustic sound pressure method for the determination of sound source sound power level (ISO 3746:1995) GB 5009.3-2010 National Food Safety Standard Determination of Moisture in Foods GB/T 13306 signage GB 16798-1997 Food machinery safety and health SB/T 222 Basic technical requirements for general technical conditions of food machinery SB/T 223 Food Machinery General Technical Conditions Mechanical Processing Technical Requirements SB/T 224 food machinery general technical conditions

assembly technical requirements SB/T 227-2007 Technical requirements for general technical requirements for food machinery SB/T 228 food machinery general technical conditions surface painting SB/T 229 Food Machinery General Technical Conditions Product Packaging Technical Requirements SB/T 231 General technical conditions for food machinery, marking, transportation and storage

3 Terms and definitions

The following terms and definitions apply to this document.

Print candy machine stampingcandyformingmachine Also known as the punch mode candy forming machine, referred to as the sugar machine, is the main equipment for hard candy forming. It is mainly composed of a rotating head, a cam set, a sugar roll, and a pass.

It consists of a moving device, a blade, a frame, and the like.

Rotating head formingwheel Also known as the forming wheel, it is the core component of the sugar machine. Through a set of punches that simultaneously rotate with the parts, the sugar strip cutting and compression molding are completed.

The component is generally assembled from components such as a sugar mold wheel, a die, a punch (a group of long and short), a shift fork, and a support wheel.

3.2.1

Sugar mold wheel sugarmouldwheel Located in the middle of the rotating head, it is uniformly distributed on the circumference of the cavity (fixed or embedded) of the same size as the head of the die.

The punch is heavier in the cavity of the cavity to complete the candy formation.