

ICS 65.160
CCS X 94

YC

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

YC/T 10.11-2018

Replacing YC/T 10.11-2006

**Tobacco machinery General technical conditions Part 11:
Painting
(English Translation)**

Issued on: April 3, 2018

Implemented on: April 15, 2018

Issued by: State Tobacco Monopoly Administration

Table of Contents

Foreword

1 Scope

2 Normative references

3 Terms and definitions

Foreword

YC/T 10 "General Technical Conditions for Tobacco Machinery" is divided into 16 parts.

Part 1. cutting parts;

Part 2. cold work;

Part 3. welded parts;

Part 4. grey iron castings;

Part 5. ductile iron castings;

Part 6. Cast carbon steel parts;

Part 7. copper alloy castings;

Part 8. Aluminum alloy castings;

Part 9. forgings;

Part 10. Metal plating and chemical treatment;

Part 11. painting;

Part 12. Assembly;

Part 13. Packaging;

Part 14. Electrical control systems;

Part 15. Assembly of electrical control systems;

Part 16. Polished and brushed stainless steel parts.

This part is the 11th part of YC/T 10.

This part is drafted in accordance with the rules given in GB/T 1.1-2009.

This part replaces YC/T 10.11-2006 "General Technical Conditions for Tobacco Machinery Part 11. Painting", and YC/T 10.11-Compared with 2006, the main technical changes

except editorial changes are as follows.

- Added terms and definitions, general content (see Chapter 3, Chapter 4);
- Increased the content of the coating classification (see 5.1);
- Increased the content of standard fasteners in the painted part, fully enclosed welded parts [see 5.2 f), g)];
- Increased paint when the user does not require it (see 5.3.6);
- Increased the coating of the inner surface of parts that need to be in contact with tobacco and other materials in the special parts or warning parts of the equipment.

Paint requirements [see g. 5.4.2), h), i), j)];

- Removed the appearance of the paint film, the use of environmental conditions (see 2006 edition of 3.4, 3.5);
- In the surface treatment and quality requirements before painting, the roughness requirements of the coated parts and plastic parts, rubber parts, leather goods are increased.

Processing requirements for the pre-painting of pieces and wood products (see 5.6.6, 5.6.7, 5.6.8, 5.6.9, 5.6.10);

- Increased ambient temperature, relative humidity, illuminance, dust permitting degree, ventilation and wind speed, and painting pressure in the painting process conditions
- Related requirements for air reduction (see 5.7.2, 5.7.3, 5.7.4, 5.7.5, 5.7.6, 5.7.7, 5.7.8, 5.7.9, 5.7.10, 5.7.11, 5.7.12) , 5.7.13, 5.7.14, 5.7.15, 5.7.16);

- Separate the "painting requirements" into chapters (see Chapter 6, 3.9 of the 2006 edition);

---In the "priming requirements", the painting requirements for the surface of chemically or electrochemically treated workpieces are increased (see 6.1.5);

---In the "scratch putty requirements", the requirements of the paint grade on the putty and the requirements of the putty sequence are added (see 6.2.5, 6.2.6);

---In the "painting requirements", increased sanding requirements (see 6.3);

---In the "coating intermediate requirements", the painting requirements have been increased (see 6.4.3, 6.4.4, 6.4.5);

---In the "painting requirements", the painting requirements have been increased (see 6.5.3, 6.5.4, 6.5.5, 6.5.6);

---In the "painting requirements", increased waxing and polishing requirements (see 6.6);

--- Increased the requirements for quality inspection of the painting process (see 8.1);

--- Addition to the requirements of the appearance level and the use of environmental conditions (see Appendix A, Appendix B);

--- The informative appendix in the appendix was changed to a normative appendix (see Appendix C, Appendix A of the 2006 edition).

This part is proposed by the National Tobacco Monopoly Bureau.

This part is under the jurisdiction of the National Tobacco Standardization Technical Committee Smoke Machine Subcommittee (SAC/TC144/SC3).

This section drafted by. China Tobacco Machinery Technology Center Co., Ltd., Kunming Marine Equipment Group Co., Ltd., Shanghai Tobacco Machinery Limited liability company, Changde Tobacco Machinery Co., Ltd., Xuchang Tobacco Machinery Co., Ltd., Qinhuangdao Tobacco Machinery Co., Ltd.

1 Scope

This part of YC/T 10 specifies the terms and definitions, general requirements, general requirements, painting requirements, test methods and inspections of tobacco machinery painting.

Inspection rules.

This section applies to the painting of tobacco machinery.

2 Normative references

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

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

GB/T 1720 paint film adhesion test method GB/T 1727 paint film general preparation method GB/T 1732 paint film impact resistance test GB/T 1740 paint film moisture resistance test GB/T 1865 Paint and varnish artificial weathering and artificial radiation exposure filtered Xenon arc radiation GB/T 2705 coating product classification and naming GB/T 3181 paint film color standard GB/T 4054-2008 paint coating mark GB 6514 Painting operation safety regulations Painting process safety and ventilation purification Technical conditions for phosphating treatment of GB/T 6807 steel workpiece before painting GB/T 8923.1.Determination of surface cleanliness of steels - Part 1 . Uncoated steel Corrosion grade and treatment grade of the surface of the steel after surface and overall removal of the original coating GB/T 9754 Determination of 20°, 60° and 85° specular gloss of paints and varnishes without metallic pigments Visual colorimetric test of GB/T 9761 paint and varnish GB/T 13452.2-2008 Determination of film thickness of paints and varnishes JB/T

10413 spray booth

3 Terms and definitions

The following terms and definitions apply to this document.

Appearance level visuallevels the appearance quality of the coating film is graded.

[GB/T 4054-2008, definition 3.2] 3.2 Use environmental conditions environmental condition the medium, climate and working conditions of the coating contact.