

Enterprise standard of Shanghai City

Q/ISKE 01-2007

Replaces Q/ISKE 01-2000

HORIZONTAL COLOR STEEL SANDWICH PANEL LAMINATING MACHINE

Issue Date: August 15, 2007

Implementation Date: August 15, 2007

Issued by Shanghai Ximing Construction Machinery Co., Ltd

Foreword

In order to guarantee the production quality, we hereby prepare this standard as the criterion to approve or reject a product on the basis of user' demands and our production situations. With the development of production and expanding of market, the demand for higher quality will press us to collect more user opinions and improve this standard.

This standard is composed in accordance with the rules of GB/T1.1-2000 and GB/T1.2-2002

This standard was drafted by Shanghai Ximing Construction machinery Co., Ltd.

The main draftsmen of this standard: Lu Ximing, Gong Mingfei.

This standard the first time issued on June 18, 2000, the first revision on August 15, 2007, replaces Q/ISKE 01-2000.

Horizontal Color Steel Sandwich Panel Laminating Machine

1. Scope:

This standard gives the definition for the mark, package, transportation, storage, classification of products, technical requirements, test method and inspection regulations, etc of Horizontal Color Steel Sandwich Panel Laminating Machine.

This Standard is applicable for Model XMF-1、XMF-2、XMF-3、XMF-4 horizontal color steel sandwich panel laminating machine.

2. Normative reference:

The clauses in the following documents have been quoted and become provisions of this standard. Every is the note date quotation document, it afterwards all revisions list (not including correction content) or the revised edition ill-uses in this standard, However, encourages to act according to this standard to reach the agreement all quarters to study whether can use these documents the newest edition, Every is does not pour the date the quotation document, Its newest standard use to this standard

GB 3768 : Determination of sound power levels of noise sources—Survey method

GB 5226.1: General Specifications for Mechanical security and Electric Units of machinery

GB/T 13306: Nameplate of Product

3. Product classification:

The machine is of four models: XMF-1, XMF-2, XMF-3, XMF-4.

4. Technological Requirements:

4.1 The machine shall be compliant with the requirements stated in this standard and manufactured in accordance with approved drawings and technological documents.

4.2 Technical Parameters of Units

4.2.1. Feeding unit

(1) Overall Size (mm): 7500x2100x1800

(2) Torque (Nm): 10

(3) Max. feeding speed (m/min): 4.0

4.3 Refer to Table 1 for the technical parameters of complete machine

Table 1 Technical Parameters

Item		Parameters		
Production Capability(m/min)		4		
Finished Product	Type	L(m)	B (mm)	H (mm)
	H-shaped	To be customized	1200	300
	Jack panel	To be customized	1150	250
	Corrugated panel	To be customized	950	100
	Glass-fiber heat-insulation wool matchboard	To be customized	1147	100
Overall Dimensions (m)		40x2.7x2.8		
Weight (t)		23		
Capacity (Kw)		33.32Kw		
Appearance		Clean, smooth, no marks missing, external pipes and lines neatly arranged.		

4.4 Refer to Table 2 for performance of machine

Table 2 Performance

Item		Performance	Remarks
Non-load test (m/min)		The machine runs consistently, and soundly in non-load state for 30 minutes. No oil leakage, gas leakage, jam or significant impact occurs	Test regular
Noise dB(A)	Non-load	75	
	Load	85	
Insulating resistance (MΩ)		1000	Control cabinet
High voltage performance		1500V, 2mA, 1Minute, no breakdown or flash occurs	Control cabinet
Loaded Test		Running under load for 30 minutes, all the operations including start-up, close, feeding, spraying glue, hemming and molding, cutting etc, are flexible and sound.	
Operating type		Manual, computer-program aided	

5. Test Method

5.1 Appearance inspection: Visual inspection.

5.2 Overall dimensions of machine and products: measured with a steel tape with a accuracy up to 1 mm.

5.3 Noise shall be determined in the way as stipulated in GB/3768.

5.4 Insulating resistance: High-voltage resistance test, as stipulated in GB5226.1.

5.5 Non-load test

After final assembly, a continual non-load running test for at least 30 minutes is required.

5.6 Loaded test

After non-load test, a continual loaded running test for at least 30 minutes is required. The load test may carry on in the user scene.

6. Inspection Rules

6.1 This machine shall not be delivered until being tested and found compliant with applicable standard by the Inspection Department, and attached with a Certificate of Compliance.

6.2 Pre-Delivery inspection

6.2.1. Each machine shall be subject to Pre-delivery inspection as specified in the non-load test stipulated 4.2, 4.3 and 4.4 of this Standard.

6.3 Type Inspection

6.3.1. In the following case, type inspections are required;

- (1) If evaluation for a new product or an old product which has been transferred to another factory for production is required.
- (2) During normal production, conducted every 3years.
- (3) If the construction, materials and processing technology related to the machine has been significantly modified.
- (4) In case production resumes after suspension for one yeas.

6.3.2.The item of type inspection cover all the contents of technological requirements.

6.3.3. Machine required for type Inspection: take one machine randomly from the latest products batch for type inspection.

6.3.4. In case rejected product found in the type inspection, improvement shall be recommended and re-inspection of that rejected product is required till the problem is solved.

7. Mark, package, transportation and storage

7.1 Product mark shall be attached to every machine. The size and technical requirements of marks shall comply with the stipulation of GB/T 13306,

The following items shall be contained in the marks.

- (1) Product description, model;
- (2) Weight of machine

- (3) Ex-factory date
- (4) Serial number
- (5) Manufacturer's name and address

7.2 If package is required by customers, the inner package of each part shall follow the stipulations as follows:

- (1) The machine shall be packaged in a wood box which is mounted on some sleepers.
- (2) The machine shall never be upside down.
- (3) The package shall be moist and rain proof.
- (4) The package shall be sound and rigid enough to meet the requirements of transportation authority.
- (5) The product's description, weight, size, the manufacturer's name/address, and the shipment date, destination and consignee, shall be indicated on the package box.

7.3 The following documents shall be attached to each machine:

- (1) Certificate of Compliance
- (2) Operating manual
- (3) Packing List

7.4 The machine can be transported either by land or by water. During transportation, the machine as well as all the accessories, parts and documents shall be ensured complete and safe.

7.5 The machine shall be kept in a dry, ventilated room. In case of storage outside, it shall stand on a pad and shall be rain-proof.