

# 喷砂工与喷砂房 安全操作规程

Safety operation specification of Sandblasting worker and Sand Blasting Room

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安全生产是任何工作都最为重视的问题，尤其喷砂这类工作，更是要注意，严格按照规定的操作流程进行，才能保障工作的安全性。喷砂工作一般都是在喷砂房内完成的，因此喷砂工不仅要注意自身及设备的安全操作，对于喷砂房的安全使用也要尤为注意。青工机械带您来详细了解一下喷砂工与喷砂房的安全操作规程。

Safety in production is the most important problem in any work, especially sandblasting. It is necessary to pay attention to strictly following the prescribed operation process in order to ensure the safety of the work. Sandblasting work is generally completed in sandblasting rooms, so sandblasting workers should not only pay attention to the safe operation of their own and equipment, but also pay special attention to the safe use of sandblasting rooms. QINGGONG Machinery brings you a detailed understanding of the safety operating rules of sandblasting and sandblasting rooms.

1. 喷砂工在工作前，应穿戴好劳动防护用品，工作场所应保持干净整洁。对机器设备进行全面检查，是否存在问题，如有问题应及时处理。

1. Sandblasting workers should wear labor protective equipment before work, and the workplace should be kept clean and tidy. Carry on the comprehensive inspection to the machine and equipment, whether there are any problems, if there are any problems should be dealt with in a timely manner.



2. 在工作中，严禁饮食、吸烟，以及做与工作无关的事情。装卸铁砂时，应使用适当的工具，但铁砂不能是湿润的。进行喷砂作业时，应关紧大门。

2. At work, no eating, smoking, and doing things that have nothing to do with work. When loading and unloading iron sand, appropriate tools should be used, but iron sand should not be wet. The door should be closed when sandblasting is carried out.

3. 此外，还要注意，喷砂房内不能有异物，如有应及时清理掉。两个风机不能同时开启，应先开启一个，然后等稳定后再开启另一个，以免使得启动电流过大。除尘器应每周放一次灰，以免被堵塞。邮箱中的油位和油质应定期进行检查，油量不足应及时添加。按照规定要求进行润滑、检查和保养工作。

3. In addition, it is also noted that there is no foreign material in the sand-blasting room, and if any, it should be cleaned off in time. The two fans can not be opened at the same time, one should be opened first, and then the other should be opened before stable, so that the starting current is too large. The dust collector should discharge the ash once a week so as not to be blocked. The oil level and oil quality in the mailbox should be checked regularly, and the amount of oil should be added in a timely manner. The lubrication, inspection and maintenance work shall be carried out in accordance with the requirements.

4. 在完成喷砂工作后，应关闭风管，且要打扫工作场所，以保持干净整洁。

4. After sandblasting, the duct should be closed and the workplace should be cleaned to keep it clean and tidy.

希望您严格遵守，以确保工作安全。

I hope you will abide by it strictly to ensure the safety of your work.



### 喷砂房安全操作规程

## 一、开机前检查

- 1、检查各安全防护罩是否齐全、固定可靠。
- 2、检查各控制电源是否连接可靠，接地是否可靠。
- 3、检查主气路连接是够牢固可靠，各紧固件是否有松动。
- 4、检查手把开关线路及喷砂管等管路是否破损，各接头及喷枪是否有磨损，各接头与喷枪是否有磨破的情况。
- 5、检查各软连接部分是否有破损。
- 6、检查风机连轴器内的油位是否符合要求。如有异常或者不符合要求须及时处理和更换以防意外。
- 7、储气罐、压力表、安全阀要定期检验，砂罐里的过滤滤芯每周检查整理一次，视滤芯损耗程度再进行更换。

## Safety operation procedures for sand blasting house

### 1. Check before starting

- ①. Check whether each safety shield is complete and reliable.
- ②. Check whether each control power supply is connected reliably and the grounding is reliable.
- ③. Check whether the main gas circuit connection is firm and reliable, and whether the fasteners are loose.
- ④. Check whether the pipeline of the handle switch and the sand blasting pipe are broken, and whether the joint and the spray gun are worn, and the joint and the spray gun are worn out.

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- ⑤. Check whether each soft connecting part is damaged.
- ⑥. Check whether the oil level in the fan shaft is in accordance with the requirements. In case of any abnormal or non-conformity, it shall be handled and replaced in a timely manner in case of an accident.
- ⑦. The air storage tank, the pressure gauge and the safety valve shall be checked, and the filter element in the sand tank shall be checked once a week and replaced according to the loss degree of the filter element.

## 二、加砂

1、检查选购的砂料粒度大小是否符合说明书要求。

2、喷砂粒度应与工作要求相符。

3、加砂时讲磨料中的异物清理筛选干净。

### 2. Add sand

- ①. to check whether the grain size of the selected sand meets the requirements of the specification.
- ②. The particle size of sandblasting should be consistent with the working requirements.
- ③. Clean up and screen the foreign bodies in the abrasive when adding sand.



### 三、试喷砂

- 1、工作前五分钟须启动空气压缩机及通风除尘设备，空转五分钟，观察运转是否正常。
- 2、压缩空气阀门要缓慢打开，气压严禁超过 0.8mpa，仔细观察风机的运行是否正常。
3. Test sand blasting.
  - ①. Start the air compressor and ventilation and dust removal equipment for five minutes before operation, idle for five minutes to observe whether the operation is normal.
  - ②. The compressed air valve shall be opened slowly, and the air pressure shall not exceed 0.8mpa, and carefully observe whether the operation of the fan is normal.

### 四、喷砂

- 1、讲工件移进喷砂房，并放平稳，小件须可靠固定。
- 2、打开反吹气源及反吹控制开关。
- 3、穿戴好喷砂工作服，作好喷砂前防护。
- 4、手持喷枪（枪口不准对准人），枪口对准工件喷砂部位，并启动手把开关开始作业。
- 5、喷砂作业时，禁止无关人员靠近，清扫和调整运转部位时，应订机并切断电源进行。

#### 4. Sandblasting

- ①. the work piece into the sandblasting room, and smooth placement, small pieces must be reliable fixed.
- ②. turn on the backblow air source and backblow control switch.
- ③. wear sand blasting work clothes, do a good job before sand blasting protection.
- ④. hand-held gun (the muzzle is not allowed to be aimed at the person), the muzzle is aimed at the sandblasting part of the workpiece, and start the handle switch to start the operation.
- ⑤. sandblasting operation, not close to unrelated personnel, cleaning and adjustment of the operating parts, should be booked and cut off the power to carry out.



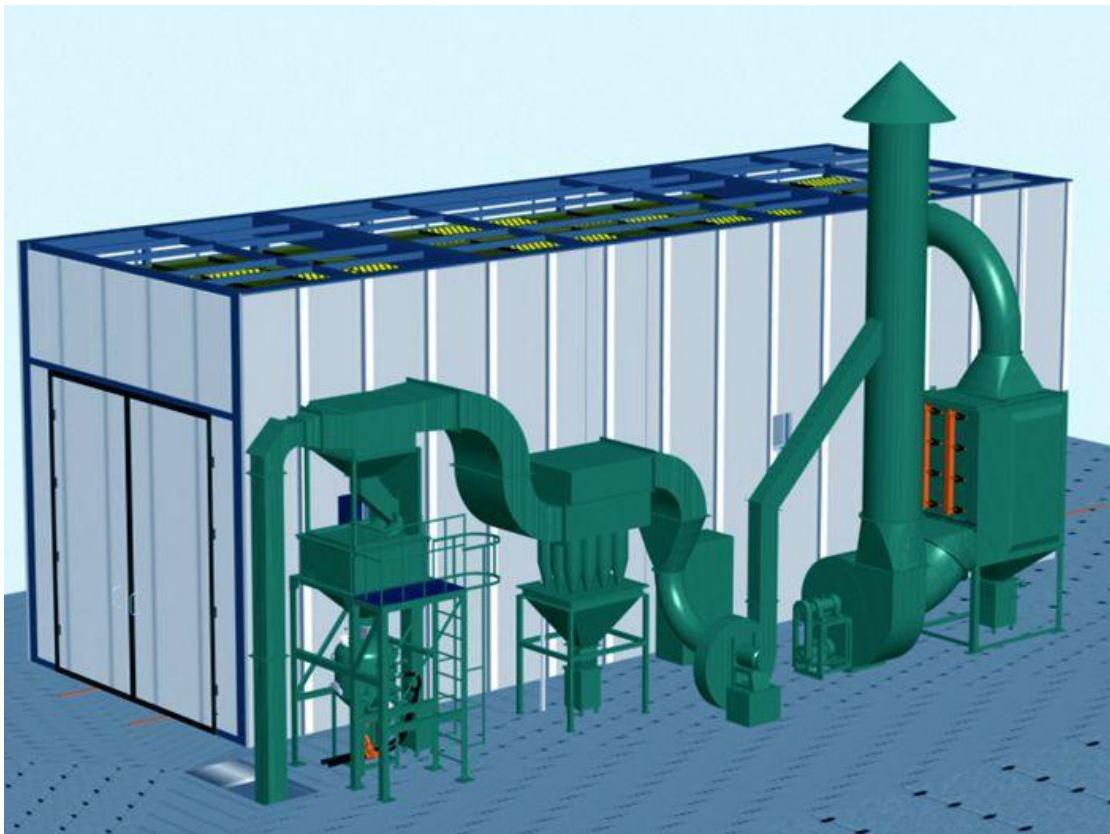


## 五、关机

- 1、关闭手把开关，停止喷砂作业。
- 2、关闭除尘风机。
- 3、除尘风机停机后，保持反吹气源及反吹电源继续反吹清灰约 5 分钟。
- 4、关闭气源及电源。
- 5、清洁设备，整理好喷砂工具，及防护装置。
- 6、清理粉尘、

5. Shutdown.

- ①. Turn off the handle switch to stop blasting operation.
- ②. Turn off the dedusting fan.
- ③. After the dedusting fan is stopped, keep the back-blowing air source and the back-blowing power supply for about 5 minutes.
- ④. Turn off the air source and power supply.
- ⑤. Clean the equipment, clean sand blasting tools and protective devices.
- ⑥. Clean the dust.



六、其它

- 1、定期清理（工作 100 小时，湿度较大地区，压缩空气未冷冻干燥需缩短清理周期）  
除尘器内滤筒上粘附的磨料及粉尘，保证设备正常运转。

2、开机前须打开气包下部的球阀，将气包的凝结水放干净，以免影响反吹效果。

6. Others

①. The abrasive and dust adhered to the filter cartridge of the dust collector shall be cleaned regularly (working for 100 hours, the humidity is large, and the compressed air is not freeze-dried), so as to ensure the normal operation of the equipment.

②. Before starting, the ball valve at the lower part of the air bag shall be opened, and the condensed water of the air bag shall be kept clean, so as not to affect the back blowing effect.