

# JIS

**JAPANESE INDUSTRIAL STANDARD**

## Glue spreaders — Test and inspection methods

**JIS B 6549—1991**

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**by**

**Japanese Standards Association**

In the event of any doubt arising,  
the original Standard in Japanese is to be final authority.

## 1. Scope

This Japanese Industrial Standard specifies the testing methods for function, operational performance and rigidity as well as the inspection methods for static accuracy and fabricating accuracy of the glue spreaders the rolls of which are provided with lengths longer than 900 mm and shorter than 4500 mm.

- Remarks
1. The glue spreader is the machine used for coating a specific amount of adhesives on the adherent surface of veneer, board materials or the like by means of rotating roll (see JIS B 0114).
  2. The applicable standards to this Standard are as follows:  
  
JIS B 0114-Glossary of terms for wood working machinery.  
  
JIS B 6507-General code of safety for wood working machinery.  
  
JIS B 6521-Methods of measurement for noise emitted by wood working machinery.
  3. The units and numerical values given in { } in this Standard are based on the traditional units and are written for reference.

## 2. Function Test Methods

The test on the function of the glue spreader shall conform to the specification in Table 1.

Table 1. Function test

| No. | Test items                                             | Test method                                                                                                                                                                                                                                                  |
|-----|--------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1   | Electric apparatus                                     | Check for insulating condition once before and after the operation inspection respectively.                                                                                                                                                                  |
| 2   | Starting, stop and operation of driving mechanism      | Repeat starting and stop ten times to test the smoothness and dependability of actuation.                                                                                                                                                                    |
| 3   | Changing operation of rotational speed of coating roll | Check at every marked rotational speed of coating roll and with a variable speed system, change the rotational speed to three stages of lowest, middle and highest to test the smoothness of operational mechanism actuation and the accuracy of indication. |
| 4   | Changing operation of rotational speed of doctor roll  | Check at every marked rotational speed of doctor roll, and with a variable speed system, change the rotational speed to three stages of lowest, middle and highest to test the smoothness of operational mechanism actuation and the accuracy of indication. |
| 5   | Coated amount adjusting device                         | Test on the smoothness and dependability of function.                                                                                                                                                                                                        |
| 6   | Adhesive circulating device                            | Test on the smoothness and dependability of function.                                                                                                                                                                                                        |
| 7   | Safety device                                          | Test on the dependability of safety function for workers and machine protection function (see JIS B 6507).                                                                                                                                                   |
| 8   | Lubricating apparatus                                  | Test on the dependability of the function such as oil tightness and appropriate amount of oil distribution.                                                                                                                                                  |
| 9   | Hydraulic apparatus                                    | Test on the dependability of the function such as oil tightness and pressure adjusting.                                                                                                                                                                      |
| 10  | Pneumatic apparatus                                    | Test on the dependability of the function such as airtightness and pressure adjusting.                                                                                                                                                                       |
| 11  | Accessories                                            | Test on the dependability of function.                                                                                                                                                                                                                       |

Remarks: For the glue spreader which lacks any function mentioned above, the test item corresponding to it in Table 1 may be omitted.