

ICS 25.080.01

CCS J 50



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

GB 15760-2025

Replacing GB 15760-2004

**Metal cutting machines - General specifications for
safeguarding**

金属切削机床 安全防护通用技术规范

Issued on: August 1, 2025

Implemented on: August 1, 2026

**Issued by: State Administration for Market Regulation;
Standardization Administration of the PRC**

Table of Contents

Foreword	4
Introduction	8
1 Scope	10
2 Normative References	10
3 Terms and Definitions	13
4 Machine Tool Classification, Mode of Operation, and Configuration	15
4.1 Machine Tool Classification	15
4.2 Mode of Operation of Machine Tools	16
4.3 Configuration of Machine Tool Category and Mode of Operation	17
5 Machine Tools Danger	17
5.1 Machine Tool Risk Assessment	17
5.2 Identification of Machine Tools Dangers	18
5.3 Primary Dangers of Machine Tools	18
6 Safety Requirements and / or Safety Measures	23
6.1 General Requirements	23
6.2 Machine Tool Structure	26
6.3 Electrical Systems	32
6.4 Control Systems	34
6.5 Safeguards	40
6.6 Safety Signs and Safety Colors	42
6.7 Temperature	42
6.8 Noise	42
6.9 Vibration	44
6.10 Radiation	45
6.11 Substances and Materials	45
6.12 Ergonomics	47
6.13 Lighting	50
6.14 Assembly	51
6.15 Hydraulic System	51
6.16 Pneumatic System	52
6.17 Lubrication System	52
6.18 Cutting Cooling System	52

6.19 Mode of Operation of Machine Tools	53
---	----

Foreword

This document was issued on 1 August 2025 by the State Administration for Market Regulation and the Standardization Administration of the PRC, and took effect on 1 August 2026.

It replaces GB 15760-2004, which is superseded.

Classification: ICS 25.080.01, CCS J 50.

It is a GB standard without the /T suffix: compliance is mandatory in China.

1 Scope

GB 15760 is the general safeguarding standard for metal cutting machine tools, and the 2025 edition is a consolidation: it replaces eight separate standards - GB 15760-2004 together with GB 16454, GB 18568, GB 22997, GB 22998 and the three parts of GB 24384 to GB 24386 - with a single text covering lathes, milling, drilling, grinding and machining centres. It sets the requirements for guarding and interlocking, the control system and its safety functions, the emergency stop, the protection against ejected workpieces and coolant, the electrical, noise and ergonomic requirements, and the information for use. At 24,500 words it is a substantial reference for anyone building or importing machine tools into China. Issued on 1 August 2025, in force since 1 August 2026. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the edition it replaces are taken from there. The clause text, the tables and the numeric limits are not reproduced on this page - they are in the document itself, which is delivered in full in English translation.

About this edition

GB 15760-2025 is the current edition. It was issued on 1 August 2025 and has been in force since 1 August 2026, replacing GB 15760-2004.

GB 15760-2004 has been superseded: a specification that still cites it is citing a withdrawn edition.

The interval between issue and effect is the transition period. It exists so that producers, laboratories and buyers can requalify products, revise procedures and use up documentation before the new text becomes the one that applies. The date on this page is the official one from the record of the Standardization Administration.

Classification and status

GB 15760-2025 is classified under ICS 25.080.01. ICS is the International Classification for Standards, the same scheme used by ISO and by the national bodies of most countries, which is what allows a Chinese standard to be placed beside its foreign counterparts on subject rather than on number.

Its Chinese Standard Classification code is CCS J 50. CCS is the domestic scheme, a letter for the sector and two digits for the subject within it, and it is the code by which the standard is filed and searched in China.

The GB prefix marks a mandatory national standard. Compliance is required by law within China: it applies to what is made, sold or imported there, and an inspection body will judge a product against it whether or not a contract names it.

How a Chinese national standard is set out

Chinese national standards are drafted to the rules of GB/T 1.1, which fixes the order in which a standard is set out. The document opens with a foreword recording the issuing bodies, the relationship to any previous edition and the technical committee responsible for it. Clause 1 is the scope. Clause 2 lists the normative references - the other standards that have to be applied together with this one, and without which its requirements cannot be met. Clause 3 gives the terms and definitions. The technical clauses follow: the requirements themselves, the test or measurement methods by which conformity is established, the inspection rules that say how a lot is sampled and judged, and, for a product standard, the provisions on marking, packaging, transport and storage. Annexes, normative or informative, come last.

GB 15760-2025 runs to 57 pages in the English translation. What is delivered is the complete document in that order: every clause, every table, every figure and every annex of the Chinese original, with the same numbering, so that a reference to a clause number in a contract or a test report points to the same place in both languages.

About this English translation

The English edition of GB 15760-2025 is a full translation of the official Chinese text, not a summary, an abstract or a machine rendering left unchecked. Clause and subclause numbers, table and figure numbers and annex letters are those of the original, because they are what a specification, a purchase order or a test report cites.

Technical terms are translated against the vocabulary standards of the same field, so that a term used in GB 15760-2025 reads the same way as in the other Chinese standards it is used beside. Where a term has an established English form in an ISO or IEC document on the same subject, that form is used; where China's term has no foreign counterpart, it is

translated literally and the Chinese is kept alongside it rather than replaced by an approximation.

Quantities, units and symbols are carried over unchanged. Chinese standards use SI, so a value in the translation is the value in the original document, not a conversion, and a limit read from the English text is the limit that will be applied by a Chinese inspection body reading the Chinese one.

This page is compiled from the official publication record: the standard number and both titles, the issuing bodies, the dates of issue and effect, the edition it replaces, the ICS and CCS classification. The requirements, limits, tables and test conditions are in the document itself.