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

GB/T 10924-2025

Replacing GB/T 10924-2009

**Straight-sided one- or two-point mechanical power presses -
Testing of the accuracy**

闭式单、双点压力机 精度

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Foreword

This document is in accordance with GB/T 1.1-2020 "Standardization Work Guidelines Part

1. Structure and Drafting Rules of Standardization Documents". Drafting is scheduled. This document replaces GB/T 10924-2009 "Accuracy of Closed-Type Single and Double Point Presses". Compared with GB/T 10924-2009, except for the structure... Aside from adjustments and editorial changes, the main technical changes are as follows:

---The installation level requirements have been changed (see 4.1.1,

3.1.1 from the 2009 version);

---The requirements for inspection tools have been changed (see 4.1.8,

3.2.6 of the 2009 version);

---The flatness requirements have been changed (see 4.2.1,

3.2.2 in the 2009 version). Please note that some content in this document may involve patents. The issuing organization of this document assumes no responsibility for identifying patents. This document was proposed by the China Machinery Industry Federation. This document is under the jurisdiction of the National Technical Committee on Standardization of Forging and Pressing Machinery (SAC/TC220). This document was drafted by: Jinan No.2 Machine Tool Group Co., Ltd., Yangli Group Co., Ltd., and Zhejiang Yiduan Precision Machinery Co., Ltd. Wode Precision Machinery (China) Co., Ltd., Suzhou Ster Intelligent Technology Co., Ltd., Zhejiang Jin'aolan Machine Tool Co., Ltd., Anhui Deyu Intelligent

Equipment Limited Liability Company, Zhejiang Yitian Precision Machinery Co., Ltd., Guangdong Forging & Pressing Machine Tool Factory Co., Ltd., Jiangsu Yawei Machine Tool Co., Ltd. King Fung (China) Machinery Industry Co., Ltd., and Zhejiang Zhengchang Forging Co., Ltd. The main drafters of this document are. Wang Chuanying, Feng Guoming, Guo Hongchang, Zhong Taisheng, Luo Qing, Zhu Peng, He Yanzhong, Zhang Tianwei, Ding Qianling, and Yan Haimin. Chen QiuHong, Wang Jinrong, Mao Jianjun, Chen Wei, Zheng Meihua, Jia Huishu, Zheng Shuling, Cai Wenzhong, Zhu Qi, Chen Jing, Shao Wenming, Zhang Wen, Lu Liquan, Li Jianping Wu Nengsong and Liu Gang. The release history of this document and the document it replaces is as follows:

---Published in 1989 as GB/T 10924-1989 "Accuracy of Closed Single-Point Presses";

---During the first revision in 2009, it was incorporated into GB/T 10933-1989 "Accuracy of Closed-Type Two-Point Presses", and the standard name was changed to "Precision of Closed-Type Single and Double-Point Presses";

---This is the second revision. Closed-type single and double point presses accuracy

1 Scope

GB/T 10924-2025 is the Chinese national standard on straight-sided one- or two-point mechanical power presses - testing of the accuracy, in the field of manufacturing engineering. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 31 October 2025 by the State Administration for Market Regulation; Standardization Administration of China, and has been in force since 1 May 2026. Classification: ICS 25.120.10, CCS J62. 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 issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This document specifies the accuracy requirements for closed-type single and double-point presses. This document applies to general-purpose, single-action, closed-type single- or double-point presses, such as those used for blanking, bending, forming, and deep drawing of metal materials. Crankshaft and eccentric presses used in processing and other procedures. This document does not apply to closed-loop forging presses, closed multi-link presses, or special-purpose presses with unique structures (such as powder forming presses). (such as a power press, screw press, etc.)

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are not included. For

references to documents, only the version corresponding to that date applies to this document; for undated references, the latest version (including all amendments) applies. This document.

GB/T 1219 Indicator Table

GB/T 6092 Right Angle Ruler

GB/T 8170 Rules for rounding off numerical values and the representation and determination of limiting values

GB/T 10923 General Rules for Precision Inspection of Forging Machinery

GB/T 36484 Terminology for Forging Machinery

JB/T 12291 Terminology for Closed-Circuit Presses

3 Terms and Definitions

The terms and definitions defined in GB/T 36484 and JB/T 12291 apply to this document.

4.1 General Requirements

4.1.1 Before precision testing, the installation level of the closed single- or double-point press (hereinafter referred to as the press) should be adjusted, with the worktable positioned in the center. Place a level along the longitudinal and transverse sides of the press to measure the installation level; the result should not exceed 0.10/1000.

4.1.2 The upper surface of the worktable is the reference surface for the accuracy inspection of the press.

4.1.3 When inspecting a rectangular plane, if the side length L is less than or equal to 1000 mm, no inspection is required within a range of $0.1L$ from the edge; if the side length L is less than or equal to 1000 mm, no inspection is required within this range. When L is greater than 1000mm, no detection is performed within 100mm of the edge.

4.1.4 The accuracy inspection sequence in this document does not represent the actual inspection order. For ease of installation and disassembly of inspection tools and for inspection purposes, any order may be used. Conduct an inspection.

4.1.5 The allowable tolerance for the accuracy of the inspection items shall be calculated based on the actual inspection length. The calculation result shall be rounded to the nearest micrometer according to GB/T 8170.

4.1.6 During the accuracy inspection process in

4.2.2 and 4.2.3, the slider balancing mechanism should be in working condition.

4.1.7 The geometric accuracy test of the press shall be carried out under no-load (i.e.,

no-load) conditions, and the accuracy test shall comply with the provisions of GB/T 10923. During inspection, no adjustments should be made to mechanisms or parts that affect accuracy. The guide rail clearance should ensure that the slider does not jam, and the temperature of the friction parts should meet the requirements.

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