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

GB/T 18955-2025

Replacing GB/T 18955-2003

Safety of woodworking tools - Milling tools, circular saw blades

木工刀具安全 铣刀、圆锯片

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Foreword

This document complies with the provisions of GB/T 1.1-2020 "Standardization Work Guidelines Part

1.Structure and Drafting Rules of Standardization Documents". Drafting. This document replaces GB/T 18955-2003 "Safety Cutting Tools for Woodworking. Milling Cutters and Circular Saw Blades". Compared with GB/T 18955-2003, it includes the following changes. Aside from structural adjustments and editorial changes, the main technical changes are as follows:

---The normative references have been modified (see

5.1.4.1 and 5.1.6, and 6.1.5.1,

6.2.5 in the.2003 version);

---Terminology and definitions have been changed (see Chapter 3, Chapter 3 of the.2003 edition);

---The material notation for the cutting parts has been changed (see Chapter 4, Chapter 4 of the.2003 edition);

---The requirements for the "safety factor" have been changed (see 5.1.1,

6.1.1 in the.2003 version);

---Added the requirement for the "location of the chip breaker" (see 5.1.2.3);

---The requirement for "minimum clamping length" has been removed (

6.1.4 in the.2003 version);

---The requirement for "rebound speed ratio" has been removed (see

6.2.1.2 in the.2003 version);

1 Scope

GB/T 18955-2025 is the Chinese national standard on safety of woodworking tools - milling tools, circular saw blades, in the field of wood technology. 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 79.120.20, CCS J65. 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 circular saw blades, perforated end mills, shank end mills, and other cutting tools for woodworking machines used for cutting wood and materials with similar physical properties to wood. Safety requirements for end mills integrated with the spindle (hereinafter referred to as "cutting tools") are described, along with corresponding testing and safe operating methods, and specifications for marking and maintenance. This document covers aspects such as protection and handling. It does not address any hazards related to the shank strength of end mills. This document covers the knife-related hazards listed in Appendix A (Hazards List). This document applies to the design, manufacture, and use of cutting tools. This document does not apply to drills, eccentric single-cut milling cutters, milling cutters with a cutting circle diameter less than 16mm, lathes using rotary cutters, and copying lathes. The design, manufacture, and use of cutting tools on beds and cutting tools manufactured before the date of this document's publication.

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 1800.2-2020 Product Geometric Specification (GPS) - Linear Dimensional Tolerances
- ISO Notation System Part

2.Standards Tolerance zone designations and limit deviation tables for holes and shafts

GB/T 7997-2014 Vickers Hardness Test Method for Cemented Carbide

GB/T 9239.1-2006 Mechanical Vibration Constant-State (Rigid) Rotor Balancing Quality
Requirements Part

3 Terms and Definitions

The following terms and definitions apply to this document.

3.1 A thin, circular blade that is installed on a woodworking circular saw or other
woodworking machine tool to machine or weld saw teeth onto the outer circumference of
the saw body.

3.2 Solid tool; one-piece tool A cutting tool in which the cutting part and the tool body are
integrated as a single unit.

3.3 Welding tool composite tool; tipped tool A cutting tool in which the material to be cut is
welded to the tool body.

3.4 Assembly tool builtup tool; complex tool A cutting tool in which the cutting part is mounted
on the tool body.