

ICS 65.040.20

CCS B 93



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

GB/T 19819-2025

Replacing GB/T 19819-2005

Saw gin

锯齿轧花机

Issued on: October 31, 2025

Implemented on: February 1, 2026

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

Table of Contents

1.Scope	1
2 Normative References	1
3.Terms and Definitions	1
4.Product parameters and models	2
5.Technical Requirements	2
6.Test Methods	5
7 Inspection Rules	9
12 Appendix B (Normative) Determination of Cottonseed Hair Rate	14

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 19819-2005 "Sawtooth Cotton Grinding Machine". Compared with GB/T 19819-2005, the main differences are structural adjustments and editorial changes. Aside from the modifications, the main technical changes are as follows:

- a) The number of saw blades has been changed from 80 to 100 (see 4.1.1, 3.1.1 in the.2005 version);
- b) The film spacing in the first series was increased by 19 mm (see 4.1.2);
- c) The product model number has been updated with the letter Z (see 4.2);
- d) The product drawings and technical documents for the cotton gin manufacturing process have been removed (see section 4.1 of the.2005 edition);
- e) The per-flake output has been changed from "should be no less than 5 kg/h" to "should be no less than 8 kg/h" (see 5.3.15,.2005 version). 4.3.1);
- f) The description of the rolling quality indicators has been changed (see 5.3.11, 4.3.4 in the.2005 edition);
- g) The technical requirements for the corrugated saw blade have been changed (see 6.2.1, 4.4.1 of the.2005 edition);

h) Technical requirements for embossed ribs have been added (see 6.2.2);

1 Scope

GB/T 19819-2025 is the Chinese national standard covering the saw gin that separates cotton lint from seed - the ginning rate and the lint turnout, the fibre damage and the neps created, which decide the grade of the cotton, the seed breakage, and the fire risk in a machine full of dry lint. It replaces GB/T 19819-2005, under the All China Federation of Supply and Marketing Cooperatives. In force from 1 February 2026. Issued on 31 October 2025, it has been in force since 1 February 2026, replacing GB/T 19819-2005.

This document specifies the product parameters and models, technical requirements, sampling, inspection rules, as well as marking, packaging, storage, and transportation of sawtooth cotton gins. The text describes the corresponding experimental methods. This document applies to the design, manufacture, and quality inspection of sawtooth cotton ginning machines (hereinafter referred to as cotton ginning machines).

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 191 Pictorial Symbols for Packaging and Storage GB 1103.1 Cotton - Part

3 Terms and Definitions

The terms and definitions defined in GB/T 32139-2015, as well as the following terms and definitions, apply to this document.

3.1 saw cylinder The saw blades are strung together on a shaft to form a cylindrical roller. [Source: GB/T 32139-2015, 3.1.1.30]

3.2 Ribsinaline Rib components arranged in a certain number and according to certain requirements. [Source: GB/T 32139-2015, 3.1.1.14]

3.3 The percentage of the weight of the fuzz on a given weight of cottonseed to the weight of the cottonseed sample. [Source: GB/T 32139-2015, 2.4.5]

3.4 The percentage of cotton fiber mass in the impurities discharged during the cleaning process, which are mainly infertile seeds.