

ICS 79.120.10

CCS J 65



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

GB/T 19985-2025

Replacing GB/T 19985-2005

Routing machines for woodworking - Vocabulary and accuracy

木工镂铣机 术语和精度

Issued on: October 31, 2025

Implemented on: May 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 General Requirements	3
1 Geometric Accuracy Inspection	4

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 19985-2005 "Terminology and Precision of Woodworking Machine Tools and Milling Machines". Compared with GB/T 19985-2005, Apart from structural adjustments and editorial changes, the main technical changes are as follows:

---The normative references have been changed (see 4.2,

4.7 and Table 1; 3.2,

3.7 and Table 2 in the.2005 edition);

---The term "Terminology" has been changed to "Terminology and Definitions," and the example diagram and related technical content of the woodworking milling machine have been revised (see Chapter 3). Chapter 4 of the.2005 edition);

---The phrase "Brief Description" has been changed to "General Requirements," and the relevant content descriptions have been revised (see Chapter 4, Chapter 3 of the.2005 edition);

---The inspection methods in the geometric accuracy inspection items have been changed (see Chapter 5, Chapter 5 of the.2005 edition). 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 Woodworking Machine Tools and Cutting Tools (SAC/TC84). This document was drafted by: Fujian Provincial Academy of Mechanical Sciences, Shunde Polytechnic, Nanxing Equipment Co., Ltd., and Guangdong Product Quality Supervision and Inspection Center. Quality Supervision and Inspection Institute, Foshan Shunde Ruijiang Machinery Manufacturing Co., Ltd. The main drafters of this

document are. Wu Shangjing, Wang Rongfa, Luo Chang, Yin Zhihong, Wang Heping, and Liu Jiasheng. This document was first published in 2005, and this is its first revision.

Woodworking milling machine terminology and precision

1 Scope

GB/T 19985-2025 is the Chinese national standard covering the wood router - its terminology, and the accuracy of the spindle runout, the table flatness and the guide, which together decide the finish left on a moulded edge. Issued on 31 October 2025, it has been in force since 1 May 2026, replacing GB/T 19985-2005.

This document defines the terminology for woodworking routers and their main components, specifies the geometric accuracy inspection and corresponding tolerances, and describes the relevant... The experimental method. This document applies to the precision inspection of general-purpose, ordinary-precision woodworking milling machines. This document is not applicable to operational testing of woodworking milling machines (such as inspections for vibration, abnormal noise, and component creep), nor is it applicable to machine... Test the characteristics of the bed (such as speed, feed rate, 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 17421.1-2023 General Rules for Machine Tool Inspection - Part

3 Terms and Definitions

The following terms and definitions apply to this document.

3.1 A worktable equipped with a workpiece support or contouring fixture; the workpiece can be manually or mechanically fed via a mechanism mounted above the worktable. A machine tool with a "C"-shaped body that performs milling operations on a workpiece using a tool spindle. Note