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

GB/T 20956-2025

Replacing GB/T 20956-2007

**Printing machinery - Safety technical specification for cutting
equipment**

印刷机械 裁切设备安全技术规范

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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 supersedes GB/T 20956-2007 "Design and Structural Safety Rules for Paper Cutters of Printing Machinery" and is consistent with GB/T 20956-2007. In comparison, aside from structural adjustments and editorial changes, the main technical changes are as follows:

- a) Added technical parameters for "paper clamp," "cutting cycle," "cutting area," "high-pressure clamping," "low-pressure clamping," "manual clamping," and "safety distance." Terms and definitions (see 3.12-3.18);
- b) The content for "Book Margin Index Digging Machine" has been deleted (see Table 1 in the.2007 edition);
- c) The sections on "small paper cutters" and "fire and explosion hazards" have been added

(see Table 1);

d) A section on "General Requirements" has been added (see 5.1);

e) The requirements for "paper cutter" have been changed (see 5.2,.2007 edition of 5.2);

f) The requirement for "paper cutters equipped with paper feeding and unloading devices" has been changed (see 5.3,.2007 edition of 5.3);

g) The requirement for a "small paper cutter" has been added (see 5.4);

h) The requirement for a "book margin indexing tool" has been removed (see 5.4 in the.2007 edition);

i) The requirement for a "manual book feeder with three-sided book trimmer" has been added (see 5.6);

j) The testing methods for "Safety Requirements or Measures" have been changed (see Chapter 6, Chapter 6 of the.2007 edition);

k) The "Safety distance for photoelectric protection device (ESPD) of paper cutter" has been changed (see Appendix A, Appendix A of the.2007 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 Printing Machinery (SAC/TC192). This document was drafted by: Zhejiang Guowei Intelligent Equipment Co., Ltd., Guowang Technology (Zhejiang) Co., Ltd., and Hangzhou Zhongguan Hanming Technology Co., Ltd. The company, Zhejiang Huayue Packaging Machinery Co., Ltd., Pinghu Yinghou Machinery Co., Ltd., Zhejiang Daishi Printing Machinery Co., Ltd., and Zhejiang Daxiang Office Equipment Co., Ltd., Changxing Yinmai Machinery Co., Ltd., Shanghai Chenzhu Instrument Co., Ltd., and the Second Printing Office of Yunnan Provincial Government Affairs Administration Bureau Center, Zhejiang Sci-Tech University, Jiangxi Himalaya Intelligent Equipment Co., Ltd., Anhui Xinhua Printing Co., Ltd., China Printing Science Technology Research Institute Co., Ltd. The main drafters of this document are. Wang Yuyun, Lin Xiaoguo, Xue Xiaobu, Ye Wei, Zhang Yu, Jiang Hong, Cai Jianshi, Xia Huirong, Xia Peihui, and Zhang Hua. Lu Zhewei, Zhang Jian, Yu Mianlai, Ye Changbin, Ma Guoming, Peng Bo, Wu Jianping, Zhou Ting, Zhao Xinghua, Yue Peinan, Mao Zongfeng, Zhao Yueliu, Du Wanquan Ning Wenxiong. This document was first published in.2007, and this is its first revision. Safety Technical Specifications for Printing Machinery Cutting Equipment

1 Scope

GB/T 20956-2025 is the Chinese national standard covering the guillotine of a print works - two-hand control, the light curtain, the blade brake and its stopping distance, the clamp that

comes down before the knife, and the interlocks for changing a blade. The paper guillotine is one of the most dangerous machines in any workshop. It replaces GB/T 20956-2007. It was issued on 2 December 2025 and has been in force since 2 December 2025, replacing GB/T 20956-2007. The document is under the responsibility of the China Machinery Industry Federation. This page is published from the official record of the 2025 edition; the clause text of a standard this recent is not yet in circulation, and the figures, limits and tables it contains are those of the document itself, delivered in full with the English translation.

This document specifies the major hazards of cutting equipment, safety requirements or measures, inspection of safety requirements or measures, and instructions for use. This document applies to paper cutters, paper cutters equipped with paper feeding and unloading devices, small paper cutters, three-sided book cutters, rotary cutters, and circular cutters. Cutting equipment such as corner cutting machines and label punching machines. This document does not apply to longitudinal slitting machines and roll-to-sheet paper cutting 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 3836.28-2021 Explosive Atmospheres - Part

28.Basic Methods and Requirements for Non-Electrical Apparatus for Explosive Atmospheres

GB/T 5226.1-2019 Electrical Safety of Machinery - Electrical Equipment of Machinery - Part