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

GB/T 21686-2025

Replacing GB/T 21686-2008

**Slot mortising machines for woodworking - Vocabulary and
accuracy**

卧式榫槽机 术语和精度

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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 21686-2008 "Terminology and Precision of Horizontal Mortising Machines for Woodworking Machines" and is consistent with GB/T 21686-2008. Compared to previous versions, aside 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.2008 edition);

---The term "Terminology" has been changed to "Terms and Definitions," and the example diagram and related technical content of the horizontal tenoning machine have been revised (see Chapter 3,.2008). Chapter 4 of the 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.2008 edition);

---The inspection methods in the geometric accuracy inspection items have been changed (see Chapter 5, Chapter 5 of the.2008 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, Guangdong Institute of Product Quality Supervision and Inspection, Shunde Polytechnic, and Foshan. Shunde Xinma Woodworking Machinery Equipment Co., Ltd. The

main drafters of this document are. Wu Shangjing, Wu Fuchang, Feng Yu, Ma Jiehua, and Song Ting. This document was first published in.2008, and this is its first revision.

Terminology and Precision of Horizontal Mortising Machine

1 Scope

GB/T 21686-2025 is the Chinese national standard covering the horizontal slot mortiser - the terms for its parts and movements, and the accuracy of the table travel, the spindle and the fence that decide whether the mortise comes out square to the face and parallel to the edge. Issued on 31 October 2025, it has been in force since 1 May 2026, replacing GB/T 21686-2008.

This document defines the terminology for horizontal tenoning machines and their main components, specifies the geometric accuracy inspection and corresponding tolerances, and describes the relevant... The experimental method. This document applies to the accuracy inspection of general-purpose, ordinary-precision horizontal tenoning machines. This document is not applicable to operational tests of horizontal tenoning 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 woodworking machine tool that uses chisels, tenon chains, or milling cutters to machine non-cylindrical holes in workpieces, with all feed movements occurring on a single plane. It is carried out on the surface. Note