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

GB/T 25678-2025

Replacing GB/T 25678-2010

**Printing machinery - Web offset commercial rotary printing
machines**

印刷机械 卷筒纸平版商业轮转印刷机

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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 25678-2010 "Printing Machinery - Web Paper Offset Commercial Printing Presses" and is consistent with GB/T 25678-2010. Compared to previous versions, aside from structural adjustments and editorial changes, the main technical changes are as follows:

- a) Added "Device Type" (see 4.1);
- b) The "Structural Composition" has been changed (see 4.2, 4.1 in the 2010 edition);
- c) The "Basic Parameters" have been changed (see 4.3, 4.2 in the 2010 version);
- d) The product model numbering requirement has been removed (see section

4.3 of the.2010 version);

e) The requirements for "idle operation performance" have been changed (see 5.1,

5.10 in the.2010 version);

f) The term "paper splicing quality" was changed to "paper feeding performance," and corresponding technical details were added (see 5.2,

5.1 in the.2010 edition);

g) The technical content in "Printing Performance" has been changed (see 5.3,

1 Scope

GB/T 25678-2025 is the Chinese national standard covering the commercial web offset press - its speed and register accuracy at that speed, the web tension control and the splicer, the dryer and chill stack, the folder, and the safety of a machine that pulls paper through itself faster than anyone can react. Issued on 31 October 2025, it has been in force since 31 October 2025, replacing GB/T 25678-2010.

This document specifies the equipment types, structural components, basic parameters, technical requirements, and test methods for web-based offset commercial rotary printing presses. Inspection rules, marking, packaging, transportation and storage. This document applies to the design, manufacture, and use of multicolor (calculated by the number of colors printed on one side) roll-to-roll commercial rotary printing presses.

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/T 3785.1 Electroacoustic sound level meters - Part

3 Terms and Definitions

The following terms and definitions apply to this document.