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

GB/T 33639-2025

Replacing GB/T 33639-2017

CNC hydraulic punching and drilling composite machines

数控液压冲钻复合机

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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 replaces GB/T 33639-2017 "CNC Hydraulic Punching and Drilling Composite Machine". Compared with GB/T 33639-2017, the only changes are structural adjustments. Aside from editorial changes, the main technical changes are as follows:

---The general requirements for multifunction printers have been revised, and the relevant requirements in the accompanying technical documents and attachments have been incorporated into the general requirements. (See 4.1,

3.11 in the 2017 edition);

---Requirements for castings, forgings, and weldments have been revised (see 4.3, 3.3 in the 2017 version);

---Assembly requirements have been changed (see 4.8, version

---Noise limits have been changed (see 4.9, version

---Security requirements have been changed (see 4.10, 3.2 in version 2017);

---The geometric accuracy inspection requirements have been changed (see 5.2, 5.3 in the 2017 version);

---The requirements for work accuracy inspection have been changed (see 5.4, 5.5 in the 2017 version);

1 Scope

GB/T 33639-2025 is the Chinese national standard covering the machine that punches and drills structural steel in one setting - the punching force and the drilling capacity, the positioning accuracy along a beam several metres long, the tool changing, and the geometric and working accuracy tests. Issued on 31 October 2025, it has been in force since 1 May 2026, replacing GB/T 33639-2017.

This document specifies the technical requirements for CNC hydraulic punching and drilling composite machines, describes the corresponding test methods, and stipulates the inspection rules, marking, and packaging. Loading and storage. This document applies to the manufacture of CNC hydraulic punching and drilling composite machines for punching, drilling, and marking various flat parts, and is also applicable to standalone machines. Manufacturing of CNC hydraulic punching machines for punching and marking.

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 3766 General rules and safety requirements for hydraulic transmission systems and their components

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

3 Terms and Definitions

The terms and definitions defined in GB/T 36484 apply to this document.

4.1 General Requirements

4.1.1 The CNC hydraulic punching and drilling composite machine (hereinafter referred to as "composite machine") shall comply with the provisions of JB/T 1829 and this document, and shall be manufactured in accordance with the prescribed procedures.