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

GB/T 33713-2026

Replacing GB/T 33713-2017

**Process control requirements and measurement methods for
heatset web offset printing**

热固型轮转胶印过程控制要求及检测方法

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1 Scope

GB/T 33713-2026 is the Chinese national standard covering controlling a heatset web press - the ink densities and tone value increase, the colour targets and their tolerances, the register, the drying and the paper conditioning, measured on a press running magazines at fifteen metres a second. It replaces GB/T 33713-2017 and has been in force since 1 March 2026. It was issued on 28 January 2026 and has been in force since 1 March 2026, replacing GB/T 33713-2017. This page is published from the official record of the 2026 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 material requirements, technical requirements, and printing environment requirements involved in the process control of thermoset rotary offset printing, and describes the corresponding... The detection methods were defined, and the relevant terms and definitions were specified. This document applies to the production process control of thermosetting rotary offset printing on commonly used paper materials.

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 451.2 Paper and paperboard - Part

3 Portable combustible gas detectors for industrial and commercial use

GB/T 17155 Offset Printing Plate Dimensions

GB/T 17934.1-2021 Printing Technology - Control of Processes for Color Separation Plates, Proofs and Production of Printed Matter - Part

7 Computer-to-Plate Making

GB 38507 Limits for the content of volatile organic compounds (VOCs) in inks

GB/T 38608 Determination of volatile organic compound (VOC) content in inks

12 Appendix A (Informative) Arrangement of Control Bars and Page Information

17 Appendix B (Informative) Reference values for solid density for different types of paper

18 Appendix C (Informative). Test Data from Two Different Printing Companies

19 Appendix D (Normative). Tone values increased by 24 on different printing substrates.

Appendix E (Normative) Automatic Registration System

26 Appendix F (Normative) Color Closed-Loop Management System

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This document is in accordance 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 33713-2017 "Requirements and Test Methods for Process Control of Thermosetting Rotary Offset Printing", and is consistent with GB/T 33713- Compared to.2017, aside from structural adjustments and editorial changes, the main technical changes are as follows:

- a) Added the term and definition of "spot color tonal value" (see 3.8);
- b) The technical content of "Paper Requirements and Ink Requirements" has been revised (see 4.1, 4.2, Chapter 4 of the.2017 edition), and "Printing Plate Requirements" has been added. The technical requirements for the equipment are detailed in sections
- c) Added "Defects affecting printing plate quality" (see 5.1.2.1) and "Error requirements

between printing plate dot gain and set target value" (see 5.1.2.2). "cm-1 corresponds to lpi (lines per inch), values, and conversion relationships" (see 5.1.3), "Mesh angles with a spindle and a black primary color plate" Example diagram (see 5.1.4), and technical requirements for "text size" (see 5.1.7.2.1 and 5.1.7.2.3);

d) The technical requirements for "Color", "Pitch Value Replication Range", "Overprint Position Error", and "Pitch Value Increase" have been changed (see 5.2.1, 5.2.2, etc.).
Sections

5.2.3 and 5.2.4 (and sections 5.2.1, 5.2.2, 5.2.3, and 5.2.4 in the 2017 version) have added "Printing Process Requirements" (see section 5.2.5).

e) The technical requirements for "line-fitting adhesive spraying," "line-fitting folding," and "line-fitting cutting" have been revised (see 5.3.1, 5.3.2, 5.3.3, and 5.3.1 in the 2017 version). 5.3.2, 5.3.3);

f) Added "Product Quality" (see 5.4);