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

GB/T 34669-2026

Replacing GB/T 34669-2017

Grain and oil machinery - Rolls

粮油机械 磨辊

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Standardization Administration of the PRC**

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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 34669-2017 "Grinding Rollers for Grain and Oil Machinery". Compared with GB/T 34669-2017, the main differences are in structural adjustments and editing. Aside from the logical changes, the main technical changes are as follows:

---The definitions of thick-walled rollers, thin-walled rollers, and tooth angles have been deleted (see sections 3.1, 3.2, and

3.6 of the 2017 edition);

---The definitions of smoothing roller, sandblasting roller, wire drawing roller, and medium crown have been revised (see 3.1~3.4, and 3.3, 3.4, 3.5, and

3.7 in the 2017 edition);

---A definition of hardness has been added (see 3.5);

---Added a classification for grinding rollers (see Chapter 4);

---The structure has been removed (see

4.1 in the 2017 version);

---The model designation method and basic parameters have been changed (see 5.1, 5.2, and

4.3 of the 2017 version);

---The roller body material and roller shaft material have been removed (see sections 5.2.3 in the 2017 version);

1 Scope

GB/T 34669-2026 is the Chinese national standard covering the roller mill roll - the fluted or

smooth chilled iron roll that breaks and reduces wheat into flour, whose flute profile, hardness and surface finish decide the milling yield. It replaces GB/T 34669-2017, with GB/T 25235-2026 on cleaning separators. It was issued on 28 January 2026 and has been in force since 1 August 2026, replacing GB/T 34669-2017. The document is under the responsibility of the National Food and Strategic Reserves Administration. 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.

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 Packaging and Storage Graphic Symbols

GB/T 9443 Penetrant testing of cast steel and cast iron parts GB/T 13306 Nameplates

GB/T 13313 Test methods for Shore and Leeb hardness of rolling mill rolls

GB/T 15822.1 Nondestructive testing - Magnetic particle testing - Part

GB/T 24854 General Technical Requirements for Packaging of Grain and Oil Machinery Products

GB/T 24855 General Technical Requirements for the Assembly of Grain and Oil Machinery

3 Terms and Definitions

The following terms and definitions apply to this document.

3.1 groundroller A grinding roller with a certain gloss on its surface.

3.2 sandblasting roller A grinding roller with a slightly rough and dull surface.

3.3 Groovedrol wire drawing roller The roller body is cut into a grinding roller with certain grinding parameters by a wire drawing machine.

3.4 Convexity rolcamber The difference between the maximum diameter of the central area of the roller and the minimum diameter of both ends of the roller.

3.5 hardness The ability of the roller surface to resist the indentation of a hard object.