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

GB/T 46674-2025

Grain and oil machinery - Auger discharger

粮油机械 螺旋出仓机

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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. 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 National Food and Strategic Reserves Administration. This document is under the jurisdiction of the National Technical Committee on Standardization of Grain and Oil (SAC/TC270). This document was drafted by: Zhengzhou COFCO Research & Design Institute Co., Ltd. and Suzhou Jiesai Machinery Co., Ltd. The main drafters of this document are: Xin Shuojun, Sui Sai, Li Junwu, Tian Yingbin, Ma Ruyi, Zhao Jiangwei, Xia Chaoyong, Zhao Ruiying, Li Zhaofeng, and Wang Zhenmin. Xie Jiansong, Zong Yang, Guo Ning, Zhang Junling, Cheng Fei, Wang Yongwei. Grain and oil machinery screw conveyor

1 Scope

GB/T 46674-2025 is the Chinese national standard covering the sweep auger that empties the last of a flat store - its capacity and drive, the grain damage it causes, and above all the safety of a machine working inside a bin, which is where grain entrapment deaths happen. First edition, in force from 1 May 2026. Issued on 31 October 2025, it has been in force since 1 May 2026.

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 2894 Safety Colors and Safety Signs

GB/T 3768 Acoustic pressure method for determining the sound power level and sound energy level of a noise source using a simplified measurement method based on the envelope above the reflecting surface. Easy Method

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

GB/T 9286 Paints and varnishes - Cross-cut test GB/T 13306 Nameplates

GB 17440 Safety Specification for Dust Explosion Prevention in Grain Processing and Storage Systems

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

GB/T 24856 General Technical Requirements for Castings of Grain and Oil Machinery

GB/T 24857 General Technical Conditions for Plate Parts and Plate-Shaped Steel Components of Grain and Oil Machinery

GB/T 25218 General Technical Requirements for Coating of Grain and Oil Machinery Products

GB/T 36139 Method for Compiling Product Model Numbers for Grain and Oil Machinery

LS/T 3501.6 General Technical Requirements for Welded Components of Grain and Oil Processing Machinery

3 Terms and Definitions

The following terms and definitions apply to this document.

3.1 augerdischarger Equipment that uses a cantilever or track structure to force materials out of the warehouse via a screw conveyor.

3.2 discharge screw A welded component is a group or more sets of spiral blades of a certain size that are sequentially welded onto a drive shaft.