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

GB/T 46675-2025

**Grain and oil machinery - Integrated equipment of raw grain
cleaning center**

粮油机械 原粮清理中心成套设备

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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., Suzhou Jiesai Machinery Co., Ltd., and China Grain Reserves Corporation Chengdu Storage Research Institute. Research Institute Co., Ltd., COFCO Science & Industry (Henan) Engineering Equipment Co., Ltd. The main drafters of this document are: Zong Yang, Li Zhao Feng, Li Junwu, Zhu Jinlin, Tian Yingbin, Zhang Junling, Xia Chaoyong, Sui Sai, Zhao Ruiying, and Zhong Qiu. Liu Xiaopei, Zhang Zhen, Wang Zhenmin, Ma Ruyi, Sun Huinan, Ren Shouhua, Mao Genwu. Complete set of equipment for grain and oil machinery raw grain cleaning center

1 Scope

GB/T 46675-2025 is the Chinese national standard covering the cleaning plant a grain elevator receives into - the scalping, aspiration, destoning and magnetic separation in sequence, the throughput and the cleaning efficiency of the line as a whole, and the dust extraction and explosion protection. First edition, under the National Food and Strategic Reserves Administration. 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 5494 Grain and Oil Inspection. Inspection of Impurities and Defective Grains in Grains and Oilseeds

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

GB/T 10595 Belt Conveyors

GB/T 10596 Submerged scraper conveyor

GB/T 12620 Sieve plates with oblong, rectangular and round holes GB/T 13306 Nameplates

GB/T 21489 Bulk Grain Truck Unloading Device

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

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

GB/T 25233 Baghouse Dust Collector for Grain and Oil Machinery

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

GB/T 37519 Bucket Elevator for Grain and Oil Machinery GBZ /T 192.2 Determination of dust in workplace air - Part

3 Terms and Definitions

The following terms and definitions apply to this document.

3.1 The term refers to all equipment and its supporting and auxiliary devices that can complete the cleaning of raw grains in a centralized, efficient and environmentally friendly manner.

Note. The system typically consists of basic equipment such as a grain unloading pit, conveying equipment, lifting equipment, cleaning equipment, dust removal system, and buffer silos, as well as auxiliary equipment such as hydraulic tippers and dust-free dispensing devices.