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

GB/T 46677-2025

Grain and oil machinery - Valves

粮油机械 阀门

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Table of Contents

- 1 Scope
- 2 Normative references
- 3 Terms and Definitions

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/TC 270). This document was drafted by: Zhengzhou COFCO Research & Design Institute Co., Ltd., Suzhou Jiesai Machinery Co., Ltd., and COFCO Engineering Technology Testing & Certification. Limited Liability Company, Jiangmen Zhenda Machinery Manufacturing Co., Ltd., Jiangsu Fast Machinery Co., Ltd., Chengdu Bister Technology Co., Ltd. Zhisheng Engineering Technology (Group) Co., Ltd., Jinsui Electromechanical Equipment Co., Ltd., and COFCO Science & Technology (Henan) Engineering Equipment Co., Ltd. The main drafters of this document are. Zhao Ruiying, Li Zhaofeng, Chen Yi, Li Junwu, Zhang Wei, Wang Zhiyong, Liu Cuicui, Wang Rong, Sun Huinan, and Chen Shuangming. Tang Jinxiang, Lin Ronghua, Xiao Xun, Xu Xiangyu, Han Qi, Zong Yang, Ren Shouhua, Sun Shengyong, Gao Yangyang, Sun Peiwen. Grain and oil machinery valves

1 Scope

GB/T 46677-2025 is the Chinese national standard covering the valves in a grain or oil plant - the slide gates and diverters that handle a flowing solid rather than a fluid, their sealing against dust, their actuation and their wear, and the food-contact and explosion requirements of the environment. 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 listed below. 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 5226.1 Electrical Safety of Machinery - Electrical Equipment of Machinery - Part

GB/T 9286-2021 Paints and varnishes - Cross-cut test GB/T 13306 Nameplates

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

3 Terms and Definitions

The following terms and definitions apply to this document.

3.1 valve Bodou A flap-type device installed in the grain and oilseed chute system to change the direction of material flow.

3.2 valve plate These are components that come into direct contact with materials, are installed in valves, and can rotate to change the direction of material flow.

3.3 Valve housing The entire frame of the valve.

Note. It has a certain strength and is used for mounting valve plates, drive devices, control components, etc.