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

GB/T 46744-2025

**Grain and oil machinery - Warehouse loading and unloading
system**

粮油机械 平房仓进出仓作业系统

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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., Shandong Jinzhong Technology Group Co., Ltd., and Anhui Huazhong Machinery. Supporting Engineering Co., Ltd., China Grain Reserves Group Co., Ltd., COFCO Science & Technology (Henan) Engineering Equipment Co., Ltd., Hengshui Jinshi Conveying Machinery Manufacturing Co., Ltd., Jiangxi Dingde Technology Development Co., Ltd., Shandong Changjiang Grain and Oil Storage Machinery Co., Ltd., Jiangsu Gutai Grain Machinery Technology Co., Ltd., COFCO Engineering Testing & Certification Co., Ltd., China Grain Reserves Chengdu Research Institute Co., Ltd., Henan University of Technology, COFCO Engineering Equipment Wuxi Co., Ltd. The main drafters of this document are. Sun Huinan, Wang Rong, Yan Hongmei, Ma Xuewei, Wang Song, Ren Shouhua, Jin Changlin, Yang Rui, Yang Yuze, and Gong Xueneng. Zhou Mengmeng, Jia Xin, Mao Genwu, Zhang Mingyou, Wang Mingxu, Wang Binxing, Luo Dong, Qin Feng, Gao Yangyang, Liang Guozhen, Zong Yang, Chen Fengchao. Grain and oil machinery flat warehouse loading and unloading operation system

1 Scope

GB/T 46744-2025 is the Chinese national standard covering the conveying system that fills and empties a flat grain store - the belts, augers and throwers, the capacity and the grain damage each causes, the dust generated and its extraction, and the safety of machinery working where people also walk. 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 2893 Safety Colors

GB 2894 Safety Colors and Safety Signs

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 6719 Technical Requirements for Bag Filters

GB/T 8874 General Technical and Equipment Terminology for Grain and Oil Products

GB/T 10595 Belt Conveyors

GB/T 10596 Submerged scraper conveyor

GB/T 15605 Dust Explosion Relief Specification

GB/T 17248.3 Noise emitted by acoustic machines and equipment shall be determined using approximate environmental correction at the working position and other specified locations. The emitted sound pressure level

GB/T 23821 Safety of Machinery - Safe Distances to Prevent Upper and Lower Limbs from Touching Dangerous Areas

GB/T 24855 General Technical Requirements for the Assembly 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 25235 Combined cleaning screen for grain and oil machinery

GB/T 26893 Primary Cleaning Screen for Grain and Oil Machinery (Cylinder)

GB/T 26894 Vibrating Cleaning Screen for Grain and Oil Machinery

3 Terms and Definitions

The terms and definitions defined in GB/T 8874 and the following terms and definitions apply to this document.