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

GB/T 46968-2025

**Classification of working-hour consumption for numerical
control machine tools and the composition of standard working
hours**

数控加工工时消耗分类和标准工时构成

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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 Ministry of Human Resources and Social Security of the People's Republic of China. This document is under the jurisdiction of the National Technical Committee on Standardization of Labor Quotas and Staffing (SAC/TC131). This document was drafted by: China Academy of Machinery Industry Economic Management, China Academy of Labor and Social Security Sciences, and Beijing Information Science and Technology University. The main drafters of this document are. Li Peng, Sun Yimin, An Hongzhang, Lü Runze, Jin Weiping, Qu Li, Yu Jinpo, Nie Xirong, and Liu Fuwen. CNC machining time consumption classification and standard time composition

1 Scope

GB/T 46968-2025 is the Chinese national standard covering where the hours go on a CNC machine - the cutting time, the tool changes and rapid moves, the setup and the program proving, the inspection and the unavoidable waiting, and how those add up to the standard time a job is costed at. First edition, under the Ministry of Human Resources and Social Security, with the work measurement standard GB/T 23859-2025. It was issued on 31 December 2025 and has been in force since 1 April 2026, as a first edition. This page is published from the official record of the 2025 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.

This document specifies the classification, code, and composition of CNC machining time

consumption, and describes the calculation method for time consumption. This document applies to management activities involving the standardization, classification, statistics, and accounting of various time consumptions within a CNC machining work shift.

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 14002-2008 Terminology for Labor Quotas and Staffing

GB/T 14163-2009 Classification, Codes and Composition of Standard Working Hours LD/T 122-2019 Structure and Drafting Rules of Labor Quota Standards

3 Terms and Definitions

The terms and definitions defined in GB/T 14002-2008, GB/T 14163-2009, and LD/T 122-2019, as well as the following terms and definitions, apply to this standard. document.

3.1 The process of production operations using machine tools or machining units that employ digital control systems to automatically control the machining process.

3.2 standard working hours Operators with an average level of skill, under standard operating conditions and environment, at a normal operating speed and following standard procedures, complete... The total time required to complete the task.

3.3 manual operation time The time consumed by operators to complete tasks during the production process. [Source: GB/T 14163-2009, 2.1.2, with modifications]

3.4 The time consumed by CNC machining equipment to automatically complete all machining steps and processes under program control.

3.5 The time consumed by additional work that requires operator intervention outside of the automated processing of the equipment.

3.6 Auxiliary time for loading and unloading workpieces The time spent loading and unloading workpieces outside of the automatic processing of the equipment.