Press Brake Precision Acceptance Worksheet

Blank editable-print template · Checked 2026-11-04 · No acceptance result is preselected.

Select exactly one edition section

Worksheet	Standard	Status on check date	Use boundary
A	GB/T 33644-2025	current	Use only when named in the agreed acceptance basis
B	GB/T 14349-2011	current	Use only when named in the agreed acceptance basis
C	GB/T 14349-2026	upcoming	Not effective until 2027-02-01; do not use as current

Never combine editions or choose the strictest value across them. GB/T 14349-2011 remains the current general plate-bending-machine edition until GB/T 14349-2026 takes effect on 2027-02-01. GB/T 33644-2025 is a separate CNC press-brake accuracy reference.

Why the limit cells are blank

A numerical limit may be printed only after both gates pass: (1) official metadata and edition are verified; (2) the lawful full text has been checked item by item with clause/page references and an identified second reviewer. The lawful PDFs being available is not enough. This copy has not passed the second gate, so it supplies blank limit cells rather than invented values.

Common record — complete before the selected worksheet

Field	Entry
Order / contract and acceptance-basis revision	__
Machine make / model / serial number	__
FAT / SAT stage and inspection date	__
Site / environmental and machine conditions required by the agreed method	__
Punch / die / tool IDs and setup	__
Control / program revision	__
Specimen ID / grade / condition / batch / actual thickness	__
Instrument IDs / ranges / calibration evidence	__
Measurement datum / angle convention / loading state	__
Supplier and purchaser responsible persons	__

Status vocabulary: T=Type inspection; F=Factory / FAT inspection; P=Purchaser production / SAT test piece.

Every item begins as untested. Manual choices are pass, fail, untested, deferred, N/A. N/A needs a reason. Failed, untested and deferred items stay visible until the recorded disposition and independent retest close them.

Worksheet A — GB/T 33644-2025

CNC press brakes - Accuracy. Status on 2026-11-04: current. Published: 2025-10-31; effective: 2026-05-01.

Use this edition only when it is the agreed acceptance basis. Do not merge its limits with another edition.

Official metadata: https://openstd.samr.gov.cn/bzgk/std/newGbInfo?hcno=53DF848F8082CA074FB7181FA3AE677E

Evidence gate: official metadata verified = yes; lawful full text available = yes; clause/page review = no; second reviewer = not assigned. All numerical limit cells therefore remain blank.

Accuracy grade: use only a grade explicitly defined by the selected edition and agreement; otherwise write “not agreed”.

Stage per item: T = type inspection; F = factory/FAT inspection; P = purchaser production/SAT test piece. Keep these stages separate. Groups: G = machine geometry; A = axis positioning/repeatability; P = formed test-piece accuracy.

Inspection plan — agreed before testing

Item ID	Stage	Group	Characteristic / method	Clause / page	Agreed limit
CNC-2025-G1	☐ T ☐ F ☐ P	G	__	__	__
CNC-2025-G2	☐ T ☐ F ☐ P	G	__	__	__
CNC-2025-G3	☐ T ☐ F ☐ P	G	__	__	__
CNC-2025-A1	☐ T ☐ F ☐ P	A	__	__	__
CNC-2025-A2	☐ T ☐ F ☐ P	A	__	__	__
CNC-2025-A3	☐ T ☐ F ☐ P	A	__	__	__
CNC-2025-P1	☐ T ☐ F ☐ P	P	__	__	__
CNC-2025-P2	☐ T ☐ F ☐ P	P	__	__	__
CNC-2025-P3	☐ T ☐ F ☐ P	P	__	__	__

Machine / order / serial / drawing revision / program revision: _____

Tooling / specimen grade, batch and actual thickness / instrument IDs and calibration evidence: _____

Worksheet A raw readings — GB/T 33644-2025

Default item status is untested. A person must change it deliberately. Record every agreed position and every repeat specimen; never replace raw readings with a summary pass.

Item ID	Specimen / position	Raw readings + units	Signed deviations	Evidence link / instrument	Status
CNC-2025-G1	__	__ / __	__	__	untested
CNC-2025-G2	__	__ / __	__	__	untested
CNC-2025-G3	__	__ / __	__	__	untested
CNC-2025-A1	__	__ / __	__	__	untested
CNC-2025-A2	__	__ / __	__	__	untested
CNC-2025-A3	__	__ / __	__	__	untested
CNC-2025-P1	__	__ / __	__	__	untested
CNC-2025-P2	__	__ / __	__	__	untested
CNC-2025-P3	__	__ / __	__	__	untested

Allowed manual statuses: ☐ pass ☐ fail ☐ untested ☐ deferred ☐ N/A. N/A requires a written reason; deferred requires an owner and target date.

N/A reason, correction and independent retest

Item ID	N/A reason / deferred basis	Disposition / owner / target date	Retest raw readings + evidence	Retest status
__	__	__	__	__
__	__	__	__	__
__	__	__	__	__
__	__	__	__	__

Overall disposition is a human decision: ☐ accepted ☐ rejected ☐ open items remain. No overall pass is calculated by this worksheet.

Open items / remaining conditions: _____

Supplier reviewer / date / signature: ____ Purchaser reviewer / date / signature: _____

Worksheet B — GB/T 14349-2011

Plate bending machines - Accuracy. Status on 2026-11-04: current. Published: 2011-06-16; effective: 2012-01-01.

Use this edition only when it is the agreed acceptance basis. Do not merge its limits with another edition.

Official metadata: https://openstd.samr.gov.cn/bzgk/std/newGbInfo?hcno=6C15422636DACA0C7281B1827F0F06B7

Evidence gate: official metadata verified = yes; lawful full text available = yes; clause/page review = no; second reviewer = not assigned. All numerical limit cells therefore remain blank.

Accuracy grade: use only a grade explicitly defined by the selected edition and agreement; otherwise write “not agreed”.

Stage per item: T = type inspection; F = factory/FAT inspection; P = purchaser production/SAT test piece. Keep these stages separate. Groups: G = machine geometry; A = axis positioning/repeatability; P = formed test-piece accuracy.

Inspection plan — agreed before testing

Item ID	Stage	Group	Characteristic / method	Clause / page	Agreed limit
GEN-2011-G1	☐ T ☐ F ☐ P	G	__	__	__
GEN-2011-G2	☐ T ☐ F ☐ P	G	__	__	__
GEN-2011-G3	☐ T ☐ F ☐ P	G	__	__	__
GEN-2011-A1	☐ T ☐ F ☐ P	A	__	__	__
GEN-2011-A2	☐ T ☐ F ☐ P	A	__	__	__
GEN-2011-A3	☐ T ☐ F ☐ P	A	__	__	__
GEN-2011-P1	☐ T ☐ F ☐ P	P	__	__	__
GEN-2011-P2	☐ T ☐ F ☐ P	P	__	__	__
GEN-2011-P3	☐ T ☐ F ☐ P	P	__	__	__

Machine / order / serial / drawing revision / program revision: _____

Tooling / specimen grade, batch and actual thickness / instrument IDs and calibration evidence: _____

Worksheet B raw readings — GB/T 14349-2011

Default item status is untested. A person must change it deliberately. Record every agreed position and every repeat specimen; never replace raw readings with a summary pass.

Item ID	Specimen / position	Raw readings + units	Signed deviations	Evidence link / instrument	Status
GEN-2011-G1	__	__ / __	__	__	untested
GEN-2011-G2	__	__ / __	__	__	untested
GEN-2011-G3	__	__ / __	__	__	untested
GEN-2011-A1	__	__ / __	__	__	untested
GEN-2011-A2	__	__ / __	__	__	untested
GEN-2011-A3	__	__ / __	__	__	untested
GEN-2011-P1	__	__ / __	__	__	untested
GEN-2011-P2	__	__ / __	__	__	untested
GEN-2011-P3	__	__ / __	__	__	untested

Allowed manual statuses: ☐ pass ☐ fail ☐ untested ☐ deferred ☐ N/A. N/A requires a written reason; deferred requires an owner and target date.

N/A reason, correction and independent retest

Item ID	N/A reason / deferred basis	Disposition / owner / target date	Retest raw readings + evidence	Retest status
__	__	__	__	__
__	__	__	__	__
__	__	__	__	__
__	__	__	__	__

Overall disposition is a human decision: ☐ accepted ☐ rejected ☐ open items remain. No overall pass is calculated by this worksheet.

Open items / remaining conditions: _____

Supplier reviewer / date / signature: ____ Purchaser reviewer / date / signature: _____

Worksheet C — GB/T 14349-2026

Plate bending machines - Accuracy. Status on 2026-11-04: upcoming; not yet effective. Published: 2026-07-30; effective: 2027-02-01.

Do not use this upcoming edition as the current acceptance basis before its effective date. Do not preselect a future accuracy grade.

Official metadata: https://openstd.samr.gov.cn/bzgk/std/newGbInfo?hcno=7214C93B9F89ACF221F3F43661C1646E

Evidence gate: official metadata verified = yes; lawful full text available = yes; clause/page review = no; second reviewer = not assigned. All numerical limit cells therefore remain blank.

Accuracy grade (select only after agreement): ☐ I ☐ II ☐ III ☐ Not agreed

Stage per item: T = type inspection; F = factory/FAT inspection; P = purchaser production/SAT test piece. Keep these stages separate. Groups: G = machine geometry; A = axis positioning/repeatability; P = formed test-piece accuracy.

Inspection plan — agreed before testing

Item ID	Stage	Group	Characteristic / method	Clause / page	Agreed limit
GEN-2026-G1	☐ T ☐ F ☐ P	G	__	__	__
GEN-2026-G2	☐ T ☐ F ☐ P	G	__	__	__
GEN-2026-G3	☐ T ☐ F ☐ P	G	__	__	__
GEN-2026-A1	☐ T ☐ F ☐ P	A	__	__	__
GEN-2026-A2	☐ T ☐ F ☐ P	A	__	__	__
GEN-2026-A3	☐ T ☐ F ☐ P	A	__	__	__
GEN-2026-P1	☐ T ☐ F ☐ P	P	__	__	__
GEN-2026-P2	☐ T ☐ F ☐ P	P	__	__	__
GEN-2026-P3	☐ T ☐ F ☐ P	P	__	__	__

Machine / order / serial / drawing revision / program revision: _____

Tooling / specimen grade, batch and actual thickness / instrument IDs and calibration evidence: _____

Worksheet C raw readings — GB/T 14349-2026

Default item status is untested. A person must change it deliberately. Record every agreed position and every repeat specimen; never replace raw readings with a summary pass.

Item ID	Specimen / position	Raw readings + units	Signed deviations	Evidence link / instrument	Status
GEN-2026-G1	__	__ / __	__	__	untested
GEN-2026-G2	__	__ / __	__	__	untested
GEN-2026-G3	__	__ / __	__	__	untested
GEN-2026-A1	__	__ / __	__	__	untested
GEN-2026-A2	__	__ / __	__	__	untested
GEN-2026-A3	__	__ / __	__	__	untested
GEN-2026-P1	__	__ / __	__	__	untested
GEN-2026-P2	__	__ / __	__	__	untested
GEN-2026-P3	__	__ / __	__	__	untested

Allowed manual statuses: ☐ pass ☐ fail ☐ untested ☐ deferred ☐ N/A. N/A requires a written reason; deferred requires an owner and target date.

N/A reason, correction and independent retest

Item ID	N/A reason / deferred basis	Disposition / owner / target date	Retest raw readings + evidence	Retest status
__	__	__	__	__
__	__	__	__	__
__	__	__	__	__
__	__	__	__	__

Overall disposition is a human decision: ☐ accepted ☐ rejected ☐ open items remain. No overall pass is calculated by this worksheet.

Open items / remaining conditions: _____

Supplier reviewer / date / signature: ____ Purchaser reviewer / date / signature: _____