ICS 79.060.20
CCS B 70

NATIONAL STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

GB/T 15105-2024

Replacing GB/T 15105.1-2006

Molding products from wood particles

模压刨花制品

Issued on: March 15, 2024 **Implemented on: October 1, 2024**

Issued by: State Administration for Market Regulation;
Standardization Administration of China

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1 Scope

GB/T 15105-2024 is the Chinese national standard on molding products from wood

particles, in the field of wood technology. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 15 March 2024 by the State Administration for Market Regulation; Standardization Administration of China, and has been in force since 1 October 2024. Classification: ICS 79.060.20, CCS B 70. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This document specifies the classification, requirements, inspection rules and labeling, packaging, transportation, storage of molding products from wood particles; describes the corresponding inspection methods. This document is applicable to the production, circulation, trade, and inspection of flat- pressed molding products from wood particles. This document does not apply to molded pallets.

2 Normative references

The contents of the following documents constitute essential clauses of this document through normative references in the text. For reference documents with dates, only the versions corresponding to the dates apply to this document; for reference documents without dates, the latest versions (including all amendments) apply to this document.

GB/T 2828.1-2012 Sampling procedures for inspection by attributes - Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection

GB/T 15102-2017 Surface decorated fiber board and particleboard with paper impregnated thermosetting resins

GB/T 15104-2021 Decorative veneered wood-based panel

GB/T 17657-2022 Test methods of evaluating the properties of wood-based panels and surface decorated wood-based panels

GB/T 18259-2018 Terminology for wood-based panels and their surface decoration

GB 18580-2017 Indoor decorating and refurbishing materials - Limit of formaldehyde emission of wood-based panels and finishing products

GB/T 39600-2021 Formaldehyde emission grading for wood-based panel and finishing products LY/T 1279-2020 Polyvinyl chloride film overlaid wood-based panels

3 Terms and definitions

The terms and definitions as defined in GB/T 18259-2018, as well as the following terms and definitions, apply to this document.

3.1 Molding products from wood particles Products formed by using a mold to press the wood particles or scraps mixed with adhesives, with or without a decorative layer on the surface.

4 Classification

4.1 Classified by whether there is a decorative layer on the surface: - Molding products from wood particles with a decorative layer; - Molding products from wood particles without a decorative layer.

4.2 Classified by the decorative materials used: - Impregnated film paper decorative molding products from wood particles; - Decorative veneered molding products from wood particles; - PVC film decorative molding products from wood particles; - Printed paper decorative molding products from wood particles.

4.3 Classified by the place of use: - Indoor molding products from wood particles; - Outdoor molding products from wood particles.

5.1 Appearance quality

5.1.1 The appearance quality of the decorative layer of printed paper decorative molding products from wood particles shall comply with the provisions of Table 1. the provisions of

4.12 of GB/T 17657-2022; the test pieces do not need to be balanced. If it is not possible to obtain a flat test piece for testing, it is allowed to take a curved test piece and grind it flat before testing. However, the sampling location and sample preparation method shall be indicated in the test report.

6.3.5 Determination of water absorption thickness expansion rate The 2h water absorption thickness expansion rate is carried out in accordance with the provisions of

4.4 of GB/T 17657-2022; the test pieces do not need to be balanced. The immersion time is 2 h ± 5 min. The 24h water absorption thickness expansion rate is carried out in accordance with the provisions of

4.5 of GB/T 17657-2022. The test piece does not need to be balanced. The immersion time is 24 h ± 15 min.

6.3.6 Determination of the board surface screw holding force It is carried out in accordance with the provisions of

4.21 of GB/T 17657-2022. The test piece does not need to be balanced.

6.3.7 Determination of immersion peeling performance It is carried out in accordance with the provisions of Class III immersion peeling test in

4.19 of GB/T 17657-2022.

6.3.8 Determination of surface wear resistance Impregnated film paper decorative products are carried out in accordance with the provisions of

4.47 of GB/T 17657-2022. The pattern is ground for 100 r and the plain pattern is ground for 350r. PVC film decorative products are carried out in accordance with the provisions of

4.45 of GB/T 17657-2022.

6.3.9 Determination of surface crack resistance Perform according to the provisions of

4.39 of GB/T 17657-2022.

6.3.10 Determination of surface dry heat resistance Perform according to the provisions of

4.48 of GB/T 17657-2022.

6.3.11 Determination of surface water vapor resistance Perform according to the provisions of

4.38 of GB/T 17657-2022.

6.3.12 Determination of surface pollution resistance Impregnated film paper decorative products shall be tested according to the provisions of

4.43 of GB/T 17657-2022. Polyvinyl chloride film decorative products shall be tested according to the provisions of

4.44 of GB/T 17657-2022, with ethyl acetate and black coffee as conventional test pollutants.

6.3.13 Determination of formaldehyde release Perform according to the provisions of GB 18580-2017. The test piece shall be placed at (23 ± 2) °C and relative humidity (50 ± 5)% for (5 ± 2) d.

6.3.14 Determination of color fastness to light Perform according to

4.31 of GB/T 17657-2022.

6.3.15 Determination of surface bonding strength Perform according to

4.16 of GB/T 17657-2022; the test piece do not need to be balanced.

6.3.16 Determination of surface damp heat resistance Perform according to

4.50 of GB/T 17657-2022.

6.3.17 Determination of surface scratch resistance Perform according to