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NATIONAL STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

GB/T 18103-2022

Engineered wood flooring

实木复合地板

Issued on: December 30, 2022 **Implemented on: July 1, 2023**

Issued by: State Administration for Market Regulation;
Standardization Administration of the PRC

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Foreword

This document was issued on 30 December 2022 by the State Administration for Market Regulation; Standardization Administration of the PRC and takes effect on 1 July 2023.

It is a GB/T standard: recommended rather than compulsory, but it is the text a Chinese reviewer applies when assessing a submission.

1 Scope

GB/T 18103-2022 covers engineered wood flooring, the board that carries a sawn wood face over a bonded core - how it is classified by panel material, by structure and by coating mode, and what it has to meet before it is sold: the raw materials the face and the core are made from, the appearance quality, the specifications, dimensions and permitted deviations, and the physical and chemical properties. Against each of those sits an inspection method, with separate procedures for planar flooring, for non-planar flooring and for flooring laid over underfloor heating. The inspection rules then set out the split between exit-factory and type inspection, the sampling method and determination principle, the overall determination that combines the individual results into a verdict on the lot, and the inspection report. Dimensions and physical-chemical performance are what a buyer cannot judge from a showroom sample: a board whose thickness or squareness drifts opens gaps once a whole floor is laid, and one whose bond and dimensional stability were never verified cups or delaminates when the heating comes on beneath it. Product and packaging labeling, packaging, transport and storage close the document, so that what was tested is still identifiable on the pallet. Written for flooring mills, importers, testing laboratories and the specifiers who write flooring into a contract.

This document defines the terms and definitions of engineered wood flooring, and specifies the

classification, requirements, inspection methods, inspection rules, labeling, packaging,

transportation and storage.

This document is applicable to engineered wood flooring.

2 Normative References

The contents of the following documents constitute indispensable clauses of this document

through the normative references in the text. In terms of references with a specified date, only

versions with a specified date are applicable to this document. In terms of references without a

specified date, the latest version (including all the modifications) is applicable 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 4823-2013 Defects in Sawn Timber

GB/T 15036.1-2018 Solid Wood Flooring - Part 1.Technical Requirements

GB/T 15036.2-2018 Solid Wood Flooring - Part 2.Examination Methods

GB/T 17657-2022 Test Methods of Evaluating the Properties of Wood-based Panels and Surface Decorated Wood-based Panels

GB 18580 Indoor Decorating and Refurbishing Materials - Limit of Formaldehyde Emission of Wood-based Panels and Finishing Products

GB/T 28999-2012 Multilaminar Decorative Veneer

GB/T 39600 Formaldehyde Emission Grading for Wood-based Panel and Finishing Products

GB/T 41547-2022 Wood-based Flooring for Underfloor Heating

HJ 571-2010 Technical Requirement for Environmental Labeling Products - Wood Based Panels and Finishing Products

3 Terms and Definitions

What is defined in GB/T 4823-2013, and the following terms and definitions are applicable to this document.

3.1 engineered wood flooring

Flooring made of solid wood panels or veneers (including restructured decorative veneers) as the panel, solid wood panels, veneers or plywood as the core layer or bottom layer, and laminated in different combinations.

3.2 two-layer engineered wood flooring

Two-layer-structured solid wood composite flooring with solid wood panels or veneers (including restructured decorative veneers) as the panel, and solid wood panels or veneers as the bottom layer.

3.3 three-layer engineered wood flooring

Three-layer-structured solid wood composite flooring with solid wood panels or veneers

(including restructured decorative veneers) as the panel, and solid wood panels as the core layer

and veneers as the bottom layer.

3.4 multi-layer engineered wood flooring

Multi-layer (with more than 3 layers) structured solid wood composite flooring with solid wood

panels or veneers (including restructured decorative veneers) as the panel, and plywood as the

base material, or solid wood panels or veneers (including restructured decorative veneers) as

the panel, and solid wood panels or veneers as the core layer or bottom layer.

3.5 nonplanar engineered wood flooring

Solid wood composite flooring with uneven surfaces, such as. saw marks and drawings, etc.

3.6 classic tongue-and-groove joint engineered wood flooring

Solid wood composite flooring with right-angled tenons and grooves on the sides and ends.

4 Classification

4.1 Classification in accordance with the panel material.

4.2 Classification in accordance with the structure.

4.3 Classification in accordance with the coating mode.

4.4 Classification in accordance with the surface shape.

4.5 Classification in accordance with whether it is suitable for ground radiant heating places.

4.6 Classification in accordance with whether it is locked and spliced.

5 Requirements

5.1 Requirements for Raw Materials

5.1.1 Panel

5.1.2 Solid wood panel

5.1.2.1 The wood species for the core layer of flooring in the same batch shall be of the same