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

GB/T 18264-2018

Replacing GB/T 18264-2000

General acceptance rules for particleboard production lines

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009. This standard replaces GB/T 18264-2000 "General Rules for the Acceptance of Particleboard Production Lines". This standard is compared with GB/T 18264-2000, except The main technical changes outside the editorial changes are as follows:

--- Revised the scope, the scope of application increased gypsum particleboard production line, oriented strand board production line, cement particle board production line;

---Modified normative references;

---Modified requirements. Incorporate Chapters 4 through 10 of the original standard into Chapter 3, adding equipment installation for the expanded scope of application; Testing methods; increased safety, hygiene and energy saving, environmental protection requirements, and associated piping and safety devices related to the above requirements Provisions on the setting and installation of the production line; revised part of the technical indicators of the production line in the production line load test;

--- Modified the acceptance rules. Please note that some of the contents of this document may involve patents. The issuing organization of this document is not responsible for identifying these patents. This standard was proposed by the National Forestry and Grassland Bureau. This standard is under the jurisdiction of the National Wood-based Panel Machinery Standardization Technical Committee (SAC/TC66). This standard was drafted. Suzhou Sufu Ma Machinery Co., Ltd., Shanghai Wood-based Panel Machinery Co., Ltd., Beijing Forestry Machinery, State Forestry Administration Institute of Machinery. The main drafters of this standard. Liu Guangxin, Li Shaokun, Shen Wenrong, Li Xiaoxu, Zhang Wenda, Xue Jianli. The previous versions of the standards replaced by this standard are.

---GB/T 18264-2000. General rules for the acceptance of particleboard production line

1 Scope

China's national rules for accepting a particleboard production line. It specifies the acceptance requirements, the acceptance rules and the marking for particleboard production lines, and it applies to lines producing particleboard and oriented strand board from wood and non-wood plant material, to semi-dry process gypsum particleboard lines using gypsum as the binder and wood or non-wood shavings as reinforcement, and to semi-dry process cement particleboard lines using cement as the binder. A particleboard line is a chain of dependent stages - chipping and flaking, drying, screening, resin blending, forming, prepressing, hot pressing, cooling, trimming and sanding - bought as one project and commissioned as one machine, and the buyer's risk is that the individual machines pass while the line does not deliver the rated output, the board properties or the consumption figures that were sold. Acceptance therefore has to test the line, not the equipment list. The requirements cover the installation and the foundations, the electrical and control equipment, the safety and environmental provisions, and then the staged testing: individual machines run empty, the whole line run empty in sequence to prove the interlocks and the transfers, and finally the loaded run in which output, board properties and specific consumption are measured against the contract. The extension of the scope to oriented strand board and to the gypsum- and cement-bonded lines is what distinguishes this edition, since those lines share the forming and pressing architecture of a particleboard plant while differing entirely in binder chemistry and cure. Issued on 28 December 2018 and in force since 1 July 2019, it replaces GB/T 18264-2000.

This standard specifies the acceptance requirements, acceptance rules and signs of the particleboard production line. This standard applies to particleboard and oriented strand board production lines (complete sets of equipment) using wood materials and non-woody plant materials as raw materials. Gypsum is a semi-dry gypsum particleboard production line (set of equipment) with cementitious material, shavings (wooden or non-wood) as reinforcing material, cement as glue Acceptance of semi-dry cement particleboard production line (set of equipment) with condensed materials and shavings (wood or non-wood).

2 Normative references

The following documents are indispensable for the application of this document. For dated references, only dated versions apply to this article. Pieces. For undated references, the latest edition (including all amendments) applies to this document. General rules and safety requirements for

GB/T 3766 hydraulic drive systems and their components General rules for

GB/T 4272 equipment and pipeline insulation technology GB/T 4897 Particleboard

GB 5226.1 Mechanical electrical safety machinery and electrical equipment - Part 1.
General technical conditions

GB/T 7932 Pneumatic pairing system and its components general rules and safety
requirements

GB 8978 Integrated Wastewater Discharge Standard

GB 12348 industrial enterprise boundary environmental noise emission standards GB/T
13306 signage

GB 16297 Integrated emission standards for atmospheric pollutants

GB/T 18262 General technical conditions for wood-based panel machinery

GB/T 18514 Wood-based panel machinery safety rules

GB/T 24312 cement particle board

GB 50093 automation instrument engineering construction and quality acceptance
specification

GB 50235 industrial metal pipeline engineering construction specification

GB 50254 Electrical installation engineering Low-voltage electrical installation and
acceptance specifications