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

GB/T 23472-2024

Surface decorated strawboard with impregnated paper

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Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for standardization work Part

1. Structure and drafting rules for standardization documents" Drafting is required. This document replaces GB/T 23472-2009 "Impregnated film paper facing straw board".

Compared with GB/T 23472-2009, except for the structural adjustment In addition to the integration and editorial changes, the main technical changes are as follows: --The definitions of straw board and impregnated film paper facing straw board have been changed (see

3.2 of the.2009 edition); --Added classification (see Chapter 4); --Added appearance quality requirements for bulges (see 5.2); --Changed the requirements for verticality and flatness (see 5.3.2,

4.3.4 of the.2009 edition); -- Changed the performance requirements for surface wear resistance, surface pollution resistance, formaldehyde emission, etc. (see 5.4.1,

4.4 of the.2009 edition); --Added total volatile organic compounds (TVOC) performance requirements (see 5.4.1); --Deleted the requirements for dimensional stability and surface resistance to cigarette burns (see

4.4 of the.2009 edition); --Added the requirements for density deviation within the board (see 5.4.2.1); -- Changed the performance requirements for screw holding force (see 5.4.2.1,

4.4 of the.2009 edition); --Added the physical and mechanical properties requirements for straw boards with impregnated film paper facing and inorganic adhesive (see 5.4.2.2); -- Changed the test method (see Chapter 6, Chapter 5 of the.2009 edition); --The inspection rules have been changed (see Chapter 7, Chapter 6 of the.2009 edition). Please note that some of the contents of this document may involve patents. The issuing organization of this document does not assume the responsibility for identifying patents. This document was

proposed by the State Forestry and Grassland Administration. This document is under the jurisdiction of the National Forestry Biomass Materials Standardization Technical Committee (SAC/TC 416). This document was drafted by: Dehua Rabbit Baby Decoration New Materials Co., Ltd., Jiangsu Rocky Wood Industry Co., Ltd., Nanjing Forestry University, Youxin Materials Co., Ltd., Qiannianzhou New Materials Technology Group Co., Ltd., Langfang Minfeng Wood Industry Co., Ltd., China Forestry Research Institute Institute of Wood Industry of the Chinese Academy of Sciences and Huzhou Institute of Quality and Technical Supervision and Inspection. The main drafters of this document are. Xu Zifan, Zhan Xianxu, Zhang Ran, Li Xiaoke, Wang Ping, Liu Xueyu, Shen Jianping, Zhang Xiaowei, Lu Bin, Liu Zili, Su Dameng, Wei Renzhong, Huang Helang, Liu Yuanqiang, Ye Jiaoyou, Cheng Mingjuan, Shen Yiqiang, Zhao Jianfeng, Lu Mingliang, Sheng Shixiong, Ding Guanfen, Shen Juanxia, Du Rong, Yang Yong, Jia Huanliang, Wu Huachong, Xin Jiangmei, Duan Changqiang, Zhao Lijuan, and Yang Xu. The previous versions of this document and the documents it replaces are as follows: --First published in.2009 as GB/T 23472-2009; --This is the first revision. Straw board with impregnated film paper facing

1 Scope

GB/T 23472-2024 is the Chinese standard for melamine-faced strawboard. Strawboard is made from the wheat and rice straw that Chinese farmers would otherwise burn, and it is the material behind a substantial part of the country's low-formaldehyde furniture panel supply, because straw is bonded with isocyanate rather than urea-formaldehyde resin. Facing it with impregnated decorative paper turns it into a finished panel. The standard sets the classification and the specifications, then the requirements: the dimensions and their deviations, the appearance, the physical and mechanical properties of the board, density, moisture content, modulus of rupture, internal bond, screw holding and thickness swelling, the properties of the faced surface, its resistance to abrasion, staining, cracking, steam and cigarette burn and its bond to the substrate, and the formaldehyde and other emissions. It then gives the test methods, the inspection rules and the marking, packaging, transport and storage. It takes effect on 1 April 2025.

2 Normative references

The contents of the following documents constitute the essential clauses of this document through normative references in this document. For referenced documents without a date, only the version corresponding to that date applies to this document; for referenced documents without a date, the latest version (including all amendments) applies to This document.

GB/T 2828.1-2012 Sampling procedures for inspection by attributes Part

GB 8624-2012 Classification of combustion performance of building materials and products

GB/T 17657-2022 Test methods for physical and chemical properties of wood-based panels and veneered wood-based panels

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

GB/T 19367-2022 Determination of dimensions of wood-based panels

GB/T 29899 Test method for emission of volatile organic compounds from wood-based panels and their products - Small emission chamber method

GB/T 39600-2021 Formaldehyde emission classification of wood-based panels and their products
LY/T 3230-2020 Classification of volatile organic compound emissions from wood-based panels and their products

3 Terms and definitions

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

3.1 Strawboard With crop straw such as wheat straw or rice straw as the main raw material, organic (such as isocyanate adhesive) or inorganic (such as magnesium oxide and sulfuric acid) adhesive is applied. Magnesium) adhesive, a sheet made by molding.

3.2 A decorative board with straw board as base material and impregnated film paper facing material as finishing material.

4 Categories

According to the type of adhesive used on the substrate, it can be divided into.

- a) Straw board with impregnated film paper facing and organic adhesive;
- b) Straw board with impregnated film paper facing and inorganic adhesive.

5 Requirements

5.1 Grading According to the product appearance quality, it is divided into superior products, first-class products and qualified products.