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

GB/T 24507-2020

Replacing GB/T 24507-2009

Laminate engineered wood flooring

浸渍纸层压实木复合地板

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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 24507-2009 "Impregnated Paper Laminate Veneer Multilayer Parquet". And GB/T 24507-2009 In comparison, with the exception of editorial changes, the main technical changes are as follows:

- Modified the scope (see Chapter 1, Chapter 1 of the.2009 edition);
- Modified the normative reference documents (see Chapter 2, Chapter 2 of the.2009 edition);
- Modified some terms and definitions (see Chapter 3, Chapter 3 of the.2009 edition);
- Modify the classification, according to the surface shape classification, modify the original standard "relief surface" to "non-planar"; add "according to the surface wear resistance, etc. Fraction", delete the original standard "According to the amount of formaldehyde emission" (see Chapter 4, Chapter 4 of the.2009 edition);
- Revised the appearance quality, size and deviation (see 5.2, 5.3, 5.3, 5.4 of the.2009 edition)
- Modified the surface scratch resistance and surface wear resistance level requirements (see 5.4.1, 5.5 in the.2009 edition);
- Modified the method of specimen preparation, the static bending strength and elastic modulus specimens are modified from different specimens specified in the original standard to the same specimen (see 6.3.1.4, 6.3.1.3 of the.2009 edition);
- Added the surface damp and heat resistance requirements and inspection methods (see Table 3 and 6.3.12);
- Modified the formaldehyde emission requirements and inspection methods (see 5.4.2 and 6.3.14,

1 Scope

China's national product standard for engineered wood flooring surfaced with impregnated paper laminate. It specifies the classification, the requirements, the test methods, the inspection rules and the marking, packaging, transport and storage of flooring in which a melamine-impregnated decor paper is laminated onto a plywood or engineered wood core. The product sits between two others and takes something from each. Laminate flooring puts an impregnated paper surface on a fibreboard or particleboard core: cheap, hard-wearing, and dimensionally poor when it meets water, because the core swells irreversibly. Engineered wood flooring puts a real wood veneer on a plywood core: stable, repairable, warm, and expensive with a surface that scratches. This product puts the laminate surface on the plywood core, which gives the abrasion resistance of the first and the dimensional stability of the second - and it is used where a floor has to survive both traffic and humidity without the cost of a wood surface. What the standard has to control is the combination rather than either part. The bond between the laminate and the core is the interface neither parent standard covers, and delamination at it is the failure mode of the product. The core is a laminated wood construction, so its balance matters: an unbalanced build cups, and the laminate face is impermeable while the underside is not, which makes the moisture gradient across the board asymmetric by design. So the requirements cover the surface properties - abrasion, impact, stain and cigarette resistance - the substrate properties, the bonding strength, the dimensional stability under humidity change, the surface soundness, and the formaldehyde emission class. Issued on 14 December 2020 and in force since 1 July 2021, it replaces GB/T 24507-2009.

2 Normative references

The following documents are indispensable for the application of this document. For dated reference documents, only the dated version applies to this article. For undated reference documents, the latest version (including all amendments) is applicable to this document.

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

GB/T 15102-2017 Impregnated film paper facing fiberboard and particleboard

GB/T 17657-2013 Test method for physical and chemical properties of wood-based panels and facing wood-based panels

GB/T 18102 impregnated paper laminated wood floor

GB/T 18103-2013 Solid wood composite floor

GB/T 18259-2018 Artificial board and its surface decoration terms

GB 18580 The limit of formaldehyde emission in wood-based panels and products of

interior decoration materials

GB/T 39600-2020 Classification of formaldehyde emission of wood-based panels and their products

3 Terms and definitions

The following terms and definitions defined in GB/T 18259-2018 apply to this document. For ease of use, the following is repeated Certain terms and definitions in GB/T 18259-2018.

3.1 The thermosetting amino resin is impregnated with one or more layers of special paper, and after drying, it is spread on the front of the plywood substrate, and the surface of the special paper is wear-resistant Layer, balance layer can be added on the back of the substrate. Hot-pressed and molded floor.

3.2 Fissure The resin is over-cured during the hot pressing process or the expansion and contraction of the surface layer and the bottom layer are different, and irregular cracks are generated on the surface of the product.

3.3 Blow, blisters Due to the failure of the gluing, there are defects in the board and local protrusions on the surface. [GB/T 18259-2018, definition 2.45]

3.4 Bulge Local abnormal bumps caused by solid objects on the surface of the product.