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

**GB/T 28995-2012**

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**Special paper for wood-based panels decoration  
(English Translation)**

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### 1 Scope

This Standard specifies terms and definitions, classification, requirements, inspection methods, inspection rules as well as marks, packaging, transportation, storage of special paper for wood-based panels decoration.

This Standard is applicable to special paper for wood-based panels decoration, including base paper, printed paper, impregnated decorative paper, wear impregnated decorative paper, overlay paper, impregnated overlay paper, wear overlay paper, wear impregnated overlay paper, balance paper and impregnated balance paper.

This Standard is not applicable to kraft paper, pre-painted paper and tissue paper.

### 2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

GB/T 450-2008, Paper and board - Sampling for testing and identification of machine and cross direction wire side and felt side

GB/T 451.1-2002, Paper and board - Determination of size and deviation

GB/T 451.2-2002, Paper and board - Determination of grammage

GB/T 456-2002, Paper and board - Determination of smoothness

GB/T 458-2008, Paper and board - Determination of air permeance

GB/T 459-2002, Paper and board - Determination of dimensional instability

GB/T 461.1-2002, Paper and board - Determination of capillary rise (Klemm method)

GB/T 462-2008, Paper, board and pulp - Determination of moisture content of analytical sample printed base paper, with color, figure, pattern

3.4 impregnated decorative paper impregnated paper that solid color paper or print base paper is impregnated with amino resin and dried to a certain extent, with certain resin content and volatile content; after heating and pressing, it can be glued to each other or glued to the artificial board substrate

3.5 wear impregnated decorative paper impregnated decorative paper that contains certain wear-resistant materials, with certain wear resistance

3.6 overlay paper paper that is covered at the outermost layer of the substrate surface to protect the decorative layer, with a certain absorption and good transparency

3.7 wear overlay paper overlay paper that contains a certain amount of wear-resistant material

3.8 impregnated overlay paper impregnated paper that the overlay paper is impregnated with amino resin and dried to a certain extent, with a certain resin content and volatile content; after heating and pressing, it can be glued with impregnated decorative paper

3.9 wear impregnated overlay paper impregnated overlay paper that contains a certain amount of wear-resistant material

3.10 balance paper paper with a certain absorption and covering property that plays a role of strengthening and balancing in the slab

3.11 impregnated balance paper impregnated paper that the balance paper is impregnated with amino resin and dried to a certain extent, with a certain resin content and volatile content; after heating and pressing, it can be glued to each other or to the substrate

3.12 crease folding of decorative base paper due to various reasons; the crease cannot be eliminated on the surface of the final product after dipping and pressing, which falling off, resulting in small dots of the base paper color on the surface of the decorative paper

3.22 stain dirty spots and spots with non-design pattern texture on the surface of decorative paper

3.23 width variation after printing, the difference between the actual printing width of the entire pattern and the effective printing width of the design

3.24 misregister during the printing process, the maximum overprint deviation between each color, including longitudinal registration error and horizontal registration error

3.25 wrinkle unevenness on the surface of the decorative paper due to various reasons

3.26 missing print a phenomenon that during printing process, the ink in the mesh of the plate roller is not transferred to the decorative base paper, which causes the lack of decorative paper pattern texture

3.27 blade streaks the ink on the layout is not scraped clean, causing the excess ink to be transferred to the decorative paper and the vertical impressions formed are called blade streaks

3.28 doctor blade mark intermittent horizontal streaks during printing process due to the bounce or unstable oscillation of the squeegee; it is also called jump blade mark

3.29 torn off edges defects on the edges of decorative paper rolls

3.30 base weight the mass of paper per unit area, in grams per square meter (g/m<sup>2</sup>)

**NOTE:** Rewrite the definition of Clause 3 in GB/T 451.2-2002.

3.40 light fastness the ability of paper to retain its original color after exposure to sunlight or artificial light

3.41 penetration time when the paper is immersed in the specified test solution, the time required for it to be completely saturated, expressed in seconds (s)

## 4 Classification

### 4.1

According to the role of special paper in the slab, it is classified into.

- overlay paper;
- decorative paper;
- balance paper.

### 4.2

According to decorative paper processing process, it is classified into.

- base paper;
- printed paper;
- impregnated decorative paper.

### 4.3

According to whether there is printing on the surface of the decorative paper, it is classified into.

- solid color paper;
- print base paper.

#### **4.4**

According to different technique of decorative paper decoration, it is classified into.

- paper for high pressure method;
- paper for low pressure method.

#### **4.5**

According to the light fastness of decorative paper, it is classified into.

- standard level;
- high color retention level.

### **6.1.5 Appearance quality inspection of impregnated paper**

According to Table 3 and Table 4, inspect piece by piece.

### **6.2 Determination of specifications and allowable deviation**

In accordance with GB/T 451.1-2002.

#### **6.3.1 Specimen extraction**

In accordance with GB/T 450-2008.

#### **6.3.2 Specimen processing and test conditions**

In accordance with GB/T 10739-2002.

#### **6.3.3 Determination of quantification**

In accordance with GB/T 451.2-2002.

#### **6.3.4 Determination of moisture content**

In accordance with GB/T 462-2008.

#### **6.3.5 Determination of ash content**

In accordance with GB/T 742-2008.

#### **6.3.6 Determination of pH value**

In accordance with GB/T 1545-2008.