

ICS 79.060.20

CCS B 70



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

GB/T 4897-2015

Replacing GB/T 4897.1 ~ 4897.7-2003

Particleboard

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Issued on: July 3, 2015

Implemented on: February 1, 2016

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China;
Standardization Administration of the People's Republic of China..**

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Foreword

This Standard was drafted in accordance with the rules given in GB/T 1.1-2009 and GB/T 20000.2-2009.

This Standard is an amendment to GB/T 4897.1~4897.7-2003. Compared with GB/T 4897.1~4897.7-2003, the major technical changes in this Standard are as follows:

- COMBINE the standard divided into seven parts into one.
- applications in previous edition, while they are divided into twelve types of panels in this Standard. Furthermore, ADD the property requirements of six types of panels.
- MODIFY the classification and symbols.
- ADD the testing method of moisture resistance.
- ADD the verticality measurement. DELETE the diagonal measurement.
- ADD the flatness measurement. DELETE the warpage measurement.
- ADD the following terms and definitions: “specification limit” and “high humid conditions”. requirements shall be determined after consultation between supplier and demander.

This Standard was redrafted by reference to ISO 16893-2:2010 Wood-based panels - Particleboard - Part 2: Requirements (EN) after modification. Compared with ISO 16893-2:2010, the major differences between this Standard and ISO 16893-2:2010 are as follows:

those applicable to China's national standards.

- ADD the method for determining the properties of individual panel.
- ADD Section 6.2 “Appearance quality”, Chapter 7 “Measurement and test methods”, Chapter 8 “Inspection rules”, Chapter 9 “Symbols, packaging, transportation and storage”.
- ADD the requirements for the water-absorbent thickness expansion ratio in 2h of the furniture grade particleboard for use in dry conditions
- ADD the definitions of particleboard, general purpose particleboard, furniture grade particleboard, load bearing particleboard and heavy-duty load bearing particleboard.
- WIDEN the lower specification limits of the moisture content to 3%.
- ADD the calculation formula of mid-panel density deviation.

Some of the elements of this document may be the subject of patent rights. The issuing authorities of this document shall not be held responsible for identifying any or all such patent rights.

This Standard was proposed by State Forestry Administration of the People's Republic of

China.

This Standard shall be under the jurisdiction of the National Technical Committee for Standardization of Wood-based Panels (SAC/TC 198).

Drafting organizations of this Standard: Research Institute of Wood Industry, Chinese Academy of Forestry; Fujian Furen Wood Industry Co., Ltd; Kunming Xinfeilin Panel Board Co., Ltd; Jilin Forest Industry Co., Ltd; Dareglobal Wood (Fujian) Co., Ltd; Asia Dekor (Huizhou) Woods Co., Ltd; Power Unity Precedent Technology (Beijing) Co., Ltd; Handan Jinsaibo Panels Co., Ltd; Jiangxi Provincial Product Quality Supervision Testing College; Tangshan Jingsen Wood-based Panels Co., Ltd; and Southwest Forestry University.

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The previous released editions substituted by this Standard are as follows:

1 Scope

This Standard specifies the terms and definitions, classification, requirements, measurement and test methods, inspection rules, symbols, packaging, transportation and storage of the particleboards.

This Standard is applicable to the general purpose particleboards, furniture grade particleboards, load bearing particleboards and heavy-duty load bearing particleboards.

This Standard is not applicable to the oriented strand boards.

2 Normative references

The following documents are essential to the application of this document. For dated references, only the editions with the dates indicated are applicable to this document. For undated references, only the latest editions (including all the amendments) are applicable to this document.

3 Terms and definitions

The terms and definitions defined in GB/T 18259-2009 and LY/T 1717-2007 and the following ones are applicable to this document. For ease of use, some of the terms and definitions in GB/T 18259-2009 and LY/T 1717-2007 are repeatedly listed below.

3.1 Particleboard

It refers to a kind of wood-based panels assembled and formed via hot pressing after processing wood or non-wood plant fiber raw materials into wood shavings (or scraps) and

applying adhesives (and other additives).

3.2 General purpose particleboard

General purpose particleboards refer to the particleboards that are generally not used on load-bearing occasions and for furniture, such as temporary panels for exhibitions, partition boards, etc.

3.3 Furniture grade particleboard

3.4 Load bearing particleboard

Load bearing particleboards refer to the particleboards used for small structural parts in ordinary load-bearing status, such as indoor flooring materials, shelves, roofing boards, shingles, plates for general construction, etc.

3.5 Heavy-duty load bearing particleboard

Heavy-duty load bearing particleboards refer to the particleboards used in greater load-bearing status, such as flooring materials, shelves and girders for industrial use.

3.6 Specification limit

Specification limits refer to the specified limit values used for determining whether some metrological quality characteristic of the unit product is qualified.

3.7 Upper specification limit μU

It refers to the maximum value of the specified qualified metrological quality characteristic.

3.8 Lower specification limit μL

It refers to the minimum value of the specified qualified metrological quality characteristic.

3.9 Dry conditions

Indoor environment or outdoor environment with protective measures. Dry conditions generally refer to the environmental conditions at 20°C, with the relative humidity of not greater than 65%, or with the relative humidity of greater than 65% for only a few weeks a year.

3.10 Humid conditions

Indoor environment or outdoor environment with protective measures. Humid conditions generally refer to the environmental conditions at 20°C, with the relative humidity of greater than 65% and not exceeding 85%, or with the relative humidity of greater than 85% for only a few weeks a year.