



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

GB/T 5856-2024

**Wood based panel machinery - General specifications of the
hot press**

人造板机械 热压机通用技术条件

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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. This document replaces GB/T 5856-1999 "General Technical Requirements for Hot Presses". Compared with GB/T 5856-1999, except for structural adjustments and In addition to editorial changes, the main technical changes are as follows:

- Changed the scope of application of hot press (see Chapter 1, Chapter 1 of the.1999 edition);
- Added terminology (see Chapter 3);
- Added a simplified diagram (see Chapter 4);
- Changed the main parameters (see Chapter 5, Chapter 3 of the.1999 edition);
- Deleted the hot press plunger series (see Chapter 4 of the.1999 edition);
- Changed the general requirements, technical requirements for main components and assembly technical requirements, and added corresponding inspection methods (see 6.1, 6.2, 6.3, Chapter 6 of the.1999 edition);
- Added safety protection requirements (see 6.4);
- Changed the geometric accuracy requirements, working accuracy requirements and corresponding inspection methods, and added a column for inspection tools (see 6.5, 6.6, Chapter 5 of the.1999 edition);
- Changed the requirements for idling test and load test, and deleted the requirements for accuracy test (see 6.7, 6.8, Chapter 7 of the.1999 edition);
- Changed the content of the inspection rules (see Chapter 7, Chapter 8 of the.1999 edition);
- Changed the contents of labeling, packaging and storage (see Chapter 8, Chapter 9 of the.1999 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 Technical Committee for Standardization of Wood-Based Panel Machinery (SAC/TC66). This document was drafted by: Suzhou Sufuma Machinery Co., Ltd., Shanghai Wood-Based Panel Machinery Factory Co., Ltd., China Forestry Research Institute Wood Industry Research Institute, Zhenjiang Zhongfuma Machinery Co., Ltd., Suzhou Huaxiang Wood Industry Machinery Co., Ltd., Shanxi Qiulin Machinery Co., Ltd. Linyi City Xintianli Machinery Co., Ltd. The main drafters of this document are. Shen Wenrong, Liu Guangxin, Li Shaokun, Yan Chenglin, Zhang Wenda, Wang Xueping, Yang Yongzhong, Xu Kai, Li Yongqing, Tang Qi, Ren Yusheng, Zhang Yaosheng, Wang Qi, and Liu Zixin. The previous versions of this document and the documents it replaces are as follows:

---First published in 1986 as GB/T 5856-1986 "Precision of hot presses";

1 Scope

GB/T 5856-2024 is the Chinese general specification for the hot press used in wood based panel production. The hot press is the machine that decides the panel: it holds the mat at temperature and pressure while the resin cures, and its platen flatness, its temperature uniformity and the accuracy and repeatability of its closing cycle set the thickness tolerance, the density profile and the bond quality of everything the plant makes. The document sets the principal parameters, the requirements on the platens, the frame, the hydraulic and pneumatic systems, the heating and the electrical equipment, on the accuracy and on safety, together with the inspection methods for each and the marking, packaging and storage. It applies to single-layer and multi-layer hot presses for plywood, fibreboard, particleboard, veneered panel, honeycomb panel and other wood-based panels. China builds and exports more panel plant than anyone else. The 2024 edition takes effect on 1 October 2024, and for a press builder or a panel mill buying one this is the acceptance text.

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 191 Pictorial markings for packaging, storage and transportation

GB/T 1184-1996 Shape and position tolerances without tolerance values

GB/T 1800.1-2020 Geometrical product specifications (GPS) - Linear dimension tolerances

- ISO code system - Part

GB/T 7932 General rules and safety requirements for pneumatic systems and their components

GB/T 11337 Flatness error detection GB/T 13306 Labels

GB/T 13384 General technical requirements for packaging of electromechanical products

GB/T 18262 General technical requirements for wood-based panel machinery GB T18263 Terminology of mechanical hot press for wood-based panels

GB/T 18514 General safety rules for wood-based panel machinery

GB/T 20801.1 Pressure piping specification Industrial piping Part

3 Terminology

The terms and definitions defined in GB/T 18263 apply to this document.