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

LY/T 1127-2025

Replacing LY/T 1127-2013, LY/T 1141-2018

**Wood-based panel machinery?Veneer clipper
(English Translation)**

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Foreword

This document complies with the provisions of GB/T 1.1-2020 "Standardization Work Guidelines Part 1: Structure and Drafting Rules of Standardization Documents".

Drafting.

This document supersedes LY/T 1127-2013 "Pneumatic Shearing Machine" and LY/T 1141-2018 "Stacking Veneer Shearing Machine", and is consistent with LY/T 1127-2013 and LY/T 1141-2018, apart from structural adjustments and editorial changes, the main technical changes are as follows.

- a) The scope of application has been changed (see Chapter 1, Chapter 1 of LY/T 1127-2013 and LY/T 1141-2018).
- b) Added terms and definitions (see Chapter 3);
- c) The simplified diagram has been modified, and a simplified structural diagram of the roller cutter veneer shearing machine has been added (see Figures 1 to 3).

d) The main parameters have been changed, and the parameter specifications for roller cutter veneer shearing machine and stacking veneer shearing machine have been added (see Table 1).

e) Safety requirements and corresponding inspection methods for shearing machines have been added (see 6.1 and 6.2);

f) The requirements for geometric accuracy and working accuracy have been revised to include roller cutter veneer shearing machines and stacked veneer shearing machines (see 6.3 and 6.4).

(5.2 and 5.3 of LY/T 1127-2013 and LY/T 1141-2018).

g) The inspection items for no-load operation test and load test have been changed (see 6.5, 6.6, LY/T 1127-2013 and LY/T 1141-2018).

(5.4, 5.5)

h) The inspection rules have been changed (see Chapter 7, Chapter 6 of LY/T 1127-2013 and LY/T 1141-2018).

i) The marking, packaging and storage requirements have been changed (see Chapter 8, Chapter 7 of LY/T 1127-2013 and LY/T 1141-2018).

Please note that some content in this document may involve patents. The issuing organization of this document assumes no responsibility for identifying patents.

This document was proposed and is under the jurisdiction of the National Technical Committee on Standardization of Wood-based Panel Machinery (SAC/TC 66).

1 Scope

This document specifies the main parameters, requirements and inspection methods, inspection rules, marking, packaging and storage of veneer shearing machines.

This document applies to single-layer pneumatic veneer shearing machines, roller cutter veneer shearing machines, and multi-layer equal-width shearing machines used in plywood production.

Stacking veneer shearing machine (hereinafter referred to as shearing machine).

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are listed below.

For references to documents, only the version corresponding to that date applies to this document; for undated references, the latest version (including all amendments) applies.

document.

GB/T 191 Pictorial Symbols for Packaging and Storage GB 2893 Safety Colors GB 2894 Safety signs and their usage guidelines GB/T 3181 Standard for Paint Film Color GB/T 3766 General rules and safety requirements for hydraulic transmission systems and their components GB/T 5226.1 Electrical Safety of Machinery - Electrical Equipment of Machinery - Part 1: General Technical Conditions GB/T 6576 Machine Tool Lubrication System GB/T 7932 General rules and safety requirements for pneumatic systems and their components GB/T 9239.1 Mechanical vibration constant-state (rigid) rotor balance quality requirements - Part 1: Inspection of specifications and balance tolerances GB/T 13306 Nameplates GB/T 13384 General Technical Requirements for Packaging of Mechanical and Electrical Products GB/T 17164 Terminology for Geometric Measuring Instruments - Product Terminology GB/T 18262 General Technical Requirements for Machinery Used in Wood-based Panels GB/T 18514 General Rules for Mechanical Safety of Wood-based Panels GB/T 23570 General technical requirements for welded parts of metal cutting machine tools GB/T 24343 Test Specification for Insulation Resistance of Electrical Equipment for Industrial Machinery GB/T 26220 General Technical Requirements for Numerical Control Systems for Industrial Automation Systems and Integrated Machine Tools JB/T 9953 Method for Measuring Sound Pressure Level of Woodworking Machine Tools LY/T 1382 Classification Terminology for Wood-based Panel Machinery

3 Terms and Definitions

The terms and definitions defined in GB/T 17164 and LY/T 1382 apply to this document.

4 Simplified Diagram

4.1

A simplified structural diagram of a pneumatic veneer shearing machine is shown in Figure 1.