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LY

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

LY/T 1279-2020

Replacing LY/T 1279-2008

**Polyvinyl chloride film overlaid wood-based panels
(English Translation)**

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Foreword

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

This standard is a revision of LY/T 1279-2008 "PVC Film Facing Artificial Panels". This standard is compared with LY/T 1279-2008 the main technical content changes are as

follows.

- Modified the classification;
- Added raw material requirements;
- Modified the allowable deviation of length, width and thickness in the specifications;
- Increase the flatness requirement and cancel the warpage requirement;
- Modified the appearance quality requirements;
- Modified the physical and chemical performance requirements;
- Modified the limit requirements for hazardous substances;
- Modified the requirements for sampling and size of test pieces;
- Delete the amount of formaldehyde released in the factory inspection;
- Modified the inspection rules.

Please note that certain contents of this document may involve patents. The publishing organization of this article does not bear the responsibility for identifying these patents.

This standard was proposed and managed by the National Wood-based Panel Standardization Technical Committee (SAC/TC 198).

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1 Scope

This standard specifies the terms and definitions, classification, requirements, measurement and test methods, inspection rules, Identification, packaging, storage and transportation.

This standard applies to polyvinyl chloride film facing man-made panels.

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 document.

For undated references, the latest version (including all amendments) applies to this document.

GB/T 2828.1-2012 Sampling inspection procedure by attributes Part 1: Batch inspection sampling searched by acceptance quality limit (AQL) plan GB/T 3830-2008 Flexible polyvinyl chloride calendered film and sheet GB/T 4615-2013 Determination of residual vinyl chloride monomer in polyvinyl chloride gas chromatography GB/T 4897-2015 Particleboard GB/T 5849-2016 Blockboard GB/T 9846-2015 ordinary plywood GB/T 11718-2009 Medium Density Fiberboard GB/T 17657-2013 Test method for physical and chemical properties of wood-based panels and facing wood-based panels 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 18586-2001 Limits of harmful substances in PVC floor of interior decoration materials GB/T 19367-2009 Determination of the size of wood-based panels GB/T 22048-2015 Determination of specific phthalate plasticizers in toys and children's products GB/T 31765-2015 High Density Fiberboard LY/T 1787-2016 Non-structural laminated timber

3 Terms and definitions

The following terms and definitions defined in GB/T 18259-2018 apply to this document.

A veneer man-made board (referred to as PVC veneer) made of artificial board as the base material and covered with polyvinyl chloride film.

4.1 Classification by substrate type

- a) Polyvinyl chloride film facing particle board;
- b) PVC film facing medium density fiberboard;
- c) PVC film facing high-density fiberboard;
- d) PVC film facing plywood;
- e) PVC film veneer blockboard;
- f) PVC film facing non-structural laminated material.

4.2 Classification by finish

- a) Single-sided polyvinyl chloride film facing man-made board;
- b) Double-sided PVC film facing man-made board.

5.1.1 Polyvinyl chloride film

The PVC film used in the PVC film facing artificial board should meet the product quality requirements of the printed film in GB/T 3830-2008.

5.1.2.1 Particleboard for base material

The physical and chemical properties of the particleboard used as the base material of the polyvinyl chloride film facing artificial board should meet the dry state specified in 6.3 of GB/T 4897-2015 the physical and chemical performance requirements of the furniture-type particleboard (P2 type) used under.

5.1.2.2 Medium density fiberboard for base material

The physical and chemical properties of the medium-density fiberboard used for the base material of the polyvinyl chloride film facing wood-based panels should meet the dry conditions specified in GB/T 11718-2009.

The furniture-type medium density fiberboard (MDF-FN REG) used in the dry state requires physical and chemical properties.

5.1.2.3 High-density fiberboard for base material

The physical and chemical properties of the high-density fiberboard used for the base material of PVC film facing artificial board should meet the general requirements specified in GB/T 31765-2015 5.3 General high-density fiberboard (HDF-GP REG) physical and chemical performance requirements.

5.1.2.4 Plywood for base material

The physical and chemical properties of the plywood used as the base material of the polyvinyl chloride film veneer wood-based panel should meet the type II plywood specified in 5.3 of GB/T 9846-2015 Physical and chemical performance requirements.

5.1.2.5 Blockboard for base material

The physical and chemical properties of the blockboard used for the base material of the polyvinyl chloride film facing artificial board should meet the requirements of 6.4 in GB/T 5849-2016.

5.1.2.6 Non-structural laminated materials for base materials

The physical and chemical properties of the non-structural laminated material used for the base material of the polyvinyl chloride film facing wood-based panel shall meet the requirements of 5.4 of LY/T 1787-2016.