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LY

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

LY/T 1320-2019

**Cork sheet
(English Translation)**

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Table of Contents

Foreword
1 Scope
2 Normative references
3 Terms and definitions
4 Classification and marking
5 Technical requirements
6 Inspection methods
7 Inspection rules
8 Packaging, labeling, transport and storage

Foreword

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

This standard replaces LY/T 1320-2010 "cork paper" and LY/T 1321-2013 "cork paper test method".

Compared with LY/T 1320-2010 "Cork Paper" and LY/T 1321-2013 "Test Methods for Cork Paper", this standard, except for editorial changes, the main technical changes are as follows.

- Adjusted the scope of application.
- Revised terms and definitions.
- Modified product specifications and adopted international universal specifications.
- Revised appearance requirements.
- Revised the physical and chemical performance indicators.
- Modified sample size.
- Revised the physical and chemical performance indicators.
- Added requirements for formaldehyde release limit indicators.
- Revised the sampling plan for size inspection.
- Revised appearance quality sampling plan.
- Revised the sampling plan for physical and chemical properties.

-Adjusted the detection equipment for compressibility and compression rebound rate indicators.

Please note that some elements of this document may involve patents. The issuer of this document is not responsible for identifying these patents.

This standard was proposed and managed by the National Forestry Biomass Standardization Technical Committee (SAC/TC 416).

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learn.

1 Scope

This standard specifies the terms and definitions, classification and marking, requirements, inspection methods, inspection rules and packaging, marking, and transportation of cork paper.

And storage.

This standard applies to cork paper.

2 Normative references

The following documents are essential for the application of this document. For dated references, only the dated version applies to this document.

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

GB/T 622 chemical reagent hydrochloric acid GB/T 2828.1-2012 Counting sampling inspection procedures. Part 1. Sampling plan for batch inspection according to acceptance quality limit (AQL) GB/T 6682-2008 Analytical laboratory water specifications and test methods GB 18580 Formaldehyde release limit for interior decoration materials artificial boards and their products GB/T 20671.3-2006 Non-metallic gasket material classification system and test method. Part 3. Test method for liquid resistance of gasket material

3 Terms and definitions

The following terms and definitions apply to this document.

Cork granulated cork the rind of *Q.variabilis* Bl. Or *Q.suber* and other similar tree species is

crushed, ground, and sieved Pure and granular cork prepared by centrifugation.

Cork sheet

The pure cork granules are obtained by cementing, heat setting, and sectioning.

Note: Mainly used for making cork wall boards, bulletin boards, floor mats, static seals, shock absorbing gaskets, decorative materials, heat insulation materials, clutch friction plates, meals Drinking utensils, daily necessities, etc.

Disintegration

Cork paper loses the cohesive properties of the adhesive, resulting in delamination or decomposition of the cork paper into pieces of cork.

Cork sheet

Cork papers of different thicknesses are made by cutting cork blanks with a flat section machine.

Cork rolls

The cylindrical cement cork blank was cut with a rotary cutter and supplemented with heat-set cork paper of different thicknesses after the cut.

4.1 Classification

4.1.1

Divided into five categories according to the density characteristics of the products, see Table 1.

Table 1 Density classification and marking

Density range (kg/m ³)	170≤D < 220	220≤D < 270	270≤D < 320	320≤D < 380	D≥380
Marking code (D)	17	22	27	32	38

4.1.2

Divided into two categories according to production process methods, see Table 2.

Table 2 Classification and marking according to process

Category	Cut cork paper	Cork sheet	Marking code (M)	SR

4.2 Marking

Product marking is represented by DM, and its requirements should include.

- D represents the density characteristic of cork paper;
- M stands for production method of cork paper.

Example 1. D38-S represents a cemented cork sheet with a density of 380 kg/m³ or greater.

Example 2. D27-R means a cork coil with a density of 270 kg/m³ or more and less than 320 kg/m³.

5.1.1 Specifications

The product's specifications shall comply with the requirements in Table 3.

Table 3 Specifications

Item length/mm width/mm thickness/mm Sheet 915,1220 610,915,1220 ≤8 Coil.20000 50000 100000 915,1220,1450 ≤8

5.1.2 Other specifications

Determined by the supply contract or agreement signed between the supply and demand sides.

5.2 Dimensional deviation

The size and thickness deviation of the product shall meet the requirements in Table 4. The deviation of products with special specifications is determined by the agreement between the supplier and the buyer.

Table 4 Dimensional deviation

Plane size

Nominal length (L) L≤100 100 <L≤300 300<L≤500 500<L≤800 800<L≤1000 L>1000 Nominal width (W) W≤100 100 <W≤300 300<W≤500 500<W≤800 800<W≤1000 W>1000 Deviation ± 0.5 ± 1.0 ± 1.5 ± 3.0 ± 5.0 ± LX 5 per mille Product thickness / mm Nominal thickness (H) H≤1.0 1.0 <H≤3.0 3.0<H≤6.0 6.0<H≤10.0 10.0<H≤14.0 H>14.0 Deviation ± 0.1 ± 0.2 ± 0.3 ± 0.5 ± 0.8 ± 1.0

5.3 Appearance quality

5.3.1

The surface of the product should be smooth and flat, and there should be no obvious knife marks, scratches, unevenness, holes.

5.3.2

The surface of the product is free of debris, oil, smudges, no obvious color differences, and no glue spots.