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INDUSTRY STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

LY/T 1454-2018

Replacing LY/T 1454-1999

Test code for accuracy of wood based panel machinery

人造板机械精度检验通则

(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 replaces LY/T 1454-1999 "General Rules for Mechanical Precision Inspection of Wood-based Panels". Compared with LY/T 1454-1999, except for editorial the main technical changes outside the revision are as follows.

--- Modified the scope;

--- Added normative references;

--- Increased the use of inspection methods and measurement tools;

--- Increased unit of measurement and measurement range;

--- Increased preparation work;

---Modified geometric accuracy test;

--- Modified the work accuracy test.

1 Scope

This standard specifies the mechanical accuracy test method for wood-based panels. The accuracy test includes geometric accuracy inspection and work accuracy inspection.

This standard applies to the precision inspection of wood-based panel machinery (including panel furniture machinery, secondary processing machinery, bamboo processing machinery), and other Wood and bamboo processing machinery can also be used as reference.

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2 Normative references

The following documents are indispensable for the application of this document. For dated references, only dated versions apply to this article.

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

GB/T 11337 flatness error detection GB/T 17421.1 General rules for machine tool inspection - Part 1. Geometrical accuracy of machine tools under no load or finishing conditions

3.1 Inspection method

The accuracy of testing the wood-based panel machinery should be measured by the method of actual measurement. The actual measurement is difficult or difficult. The test error can not be exceeded.

Law (such as the use of limit gauges, etc.).

3.2 Use of measurement tools

Measurement uncertainty due to measurement tools and methods used should be considered during the test. The total error of the inspection tool should be related to the item being tested.

Tolerances are compatible and generally only account for less than 20% of the tolerance of the item being inspected.

For Class A assessments of uncertainty for repeated test data, repeat at least 5 tests for each given test.

The average value of the values is the measurement result.

During the inspection, the interference of airflow, light and heat radiation (such as sunlight, too close to the electric light, etc.) should be prevented.

When there is a significant change, the gauge should be accompanied by an accuracy checklist.

4.1 Unit of measurement

The unit of measurement shall be implemented in accordance with the legal measurement unit of China. Tolerances and measurement ranges should be in the same unit system. Can not directly quote relevant when the standard determines zero, component tolerances, especially dimensional tolerances, it should be detailed. Angle tolerance can be in angle units (degrees, minutes, seconds; arc Degree) or tangent (expressed in millimeters per

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meter, eg 0.04/1000).

4.2 Measurement range

4.2.1

When the actual measurement range is larger than the specified measurement range, the specified measurement range can be arbitrarily selected within the actual measurement range.

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