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INDUSTRY STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

LY/T 1614-2024

Glued timber flooring

实木集成地板

(English Translation)

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Reference

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 LY/T 1614-2011 "Solid Wood Integrated Flooring". Compared with LY/T 1614-2011, except for structural adjustments and editorial in addition to the modifications, the main technical changes are as follows.

a) Deleted the first-class products and their appearance quality requirements (see 5.1 and 5.3 of the 2011 edition);

b) Added requirements and test methods for non-planar solid wood integrated floors (see 5.2.2, 5.3.3, 5.4.2, 6.4);

c) The requirements for warpage and assembly height difference have been changed (see 5.3.2, 5.4.4 of the 2011 edition);

d) The requirements and test methods for moisture content, paint film adhesion, surface wear resistance, surface pollution resistance, and formaldehyde emission limits have been changed (see 5.4.1, 6.3.1, 6.3.3, 6.3.5, 6.3.7~6.3.9, 5.5, 6.3.1, 6.3.3, 6.3.5~6.3.8 of the 2011 edition);

e) Added requirements, test methods and test rules for paint film hardness (see 5.4.1, 6.3.1, 6.3.6, 7.2.4);

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f) The test method for static bending strength has been changed (see 6.3.1, 6.3.4, 6.3.1, 6.3.4 of the 2011 edition);

g) Deleted the inspection report (see 7.5 of the 2011 edition);

h) Added the Appendix on Equilibrium Moisture Content of Wood in my country's Provinces (Regions) and Municipalities (see Appendix A).

1 Scope

This document specifies the classification, requirements, inspection rules, and requirements for labeling, packaging, transportation and storage of solid wood integrated flooring.

Inspection method.

This document applies to the production, sales and inspection of solid wood integrated flooring.

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 2828.1-2012 Sampling procedures for inspection by attributes Part 1: Sampling for batch inspection based on acceptance quality limit (AQL) plan GB/T 15036.1-2018 Solid wood flooring Part 1: Technical requirements GB/T 15036.2-2018 Solid wood flooring Part 2: Test methods GB/T 17657-2022 Test methods for physical and chemical properties of wood-based panels and veneered wood-based panels GB 18580 Limits of formaldehyde emission from artificial boards and their products for interior decoration and renovation GB/T 39600-2021 Formaldehyde emission classification of wood-based panels and their products LY/T 1859-2020 Antique wooden floor

3 Terms and definitions

The terms and definitions defined in GB/T 15036.1-2018 and the following apply to this document.

A floor made by joining two or more pieces of wood of specified length and width.

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4 Categories

4.1

According to surface shape.

a) Flat solid wood integrated floor;

b) Non-planar solid wood integrated flooring.

4.2

According to the coating method.

a) Painted solid wood integrated flooring;

b) Oil-finished solid wood integrated flooring;

c) Unfinished solid wood laminate flooring.

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