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INDUSTRY STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

LY/T 1738-2020

Replacing LY/T 1738-2008

Plywood for parquet

实木复合地板用胶合板

(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 1738-2008 "Plywood for Solid Wood Composite Flooring". This standard is in line with LY/T 1738-2008 the main technical content changes are as follows.

--Added the definition of plywood for solid wood composite floor without formaldehyde;

--Modified the classification;

-Modified the specification and size deviation requirements;

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-Deleted the requirements for needle knots, live knots, abnormal wood structure and other defects in the appearance quality;

-Deleted the bonding strength requirements in the physical and chemical properties;

--Modified the inspection method and requirements of formaldehyde emission;

-Modified the size and quantity of test pieces for dimensional stability testing;

--- Added a schematic diagram of sample sawing;

-Added sampling plan for appearance quality inspection and specification size deviation inspection;

-Modified the marking, packaging and transportation requirements.

Please note that certain contents of this document may involve patents. The issuing agency of this document is not responsible for identifying these patents.

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

Standard drafting unit. Research Institute of Wood Industry, Chinese Academy of Forestry, Wanhua Chemical Group Co., Ltd., Huzhou Hantai Wood Co., Ltd., Anhui Yangzi Flooring Co., Ltd., Baroque Wood (Zhongshan) Co., Ltd., North American Maple Home Furnishing (Jiang Su) Co., Ltd., Dehua Group Holding Co., Ltd., Fujian Qingxin Wood Industry Co., Ltd., Guangxi Daping Wood Industry Development Co., Ltd., Jilin Forest Industry Golden Bridge Flooring Group Co., Ltd., Jiangsu Kendia Wood Co., Ltd., Jiangsu Senmao Bamboo and Wood Co., Ltd., Linyi Youyou Wood Industry Co., Ltd., Pu'er City Quality and Technical Supervision and Comprehensive Inspection Center, Shouguang City Luli Wood Industry Co., Ltd., Shuxiangmendi (Shanghai) Meisei Home Furnishing Co., Ltd., Suzhou David Wood Co., Ltd., Hongmu Fang Home Furnishing Technology (Huzhou) Co., Ltd., Zhejiang Jiangliangyou Wood Co., Ltd., Zhejiang Shenghua Yunfeng New Material Co., Ltd., Zhejiang Shiyou Wood Co., Ltd., Gaotang Lianfeng Wood Co., Ltd., Wujiang District Inspection and Testing Center of Suzhou City, Yiyang City Product Quality Supervision and Inspection Institute, Xuzhou Huayu Wood Industry Co., Ltd.

1 Scope

This standard specifies the terms and definitions, classification, requirements, inspection methods, inspection rules, and identification, Packaging, transportation and storage, etc.

This standard applies to plywood for solid wood composite flooring.

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

GB/T 2828.1-2012 Sampling Inspection Procedures by Attributes Part 1: Batch-by-batch Inspection Sampling Retrieved by Acceptance Quality Limit (AQL) GB/T 9846-2015 ordinary plywood GB/T 17657-2013 Test method for physical and chemical properties of wood-based panels and facing wood-based panels GB/T 18103-2013 Solid wood composite floor GB/T 18259-2018 Artificial board and its surface decoration terms GB 18580 Formaldehyde release in artificial panels and products of indoor decoration materials GB/T 19367-2009 Determination of the size of wood-based panels

3 Terms and definitions

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

Plywood for solid wood composite floor made by veneer group blank and gluing.

The plywood for solid wood composite floor without adding any adhesive or auxiliary agent containing formaldehyde in the preparation process.

4 Categories

4.1
According to the type of adhesive.

a) Formaldehyde-free added plywood for solid wood composite floor;

b) Plywood for solid wood composite floor with formaldehyde added.

4.2
Divided by use environment.

a) Type I plywood. used under outdoor conditions;

b) Type II plywood. used in humid conditions.

5.1 Specification size deviation

The specification and size deviation of the plywood for solid wood composite floor shall meet the requirements of Table 1.

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5.2 Appearance quality

The appearance quality of the plywood for solid wood composite floor should meet the requirements of Table 2.

5.3 Physical and chemical properties

The physical and chemical properties of the plywood for solid wood composite flooring should meet the requirements of Table 3.

6.1.1 Length, width and thickness deviation

According to the provisions of GB/T 19367-2009 in 8.2 and 8.1.

6.1.2 Verticality and edge straightness

According to GB/T 19367-2009 in 8.3 and 8.4.

6.1.3 Warpage

According to the provisions of GB/T 19367-2009 in 8.5.

6.2 Determination of appearance quality

Carry out according to the provisions of 6.3.1 in GB/T 9846-2015.

6.3.1 Method of sawing specimens and test pieces

6.3.1.1
Take three sets of 500mmx500mm samples from each plywood for solid wood composite flooring for testing, if the test panel is not enough Take 3 sets of samples at a time, which can be selected from two plates.

6.3.1.2
The preparation position, size and quantity of the test piece shall be carried out in accordance with Table 4 and Figure 1.The length and width of the test piece should be perpendicular to each other, the size error Must not exceed ±0.5mm.

6.3.1.3
When samples and test pieces are intercepted, material defects and processing defects that affect the accuracy of the test shall be avoided.

6.3.1.4
The formaldehyde emission sample can be taken separately, with a total surface area of 1m2.

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