

ICS 79.060
CCS B 70

LY

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

LY/T 1794-2019

Replacing LY/T 1794-2008

Wood chips used for wood-based panel

人造板用木片

(English Translation)

Issued on: October 23, 2019

Implemented on: April 1, 2020

Issued by: State Forestry and Grassland Administration

Table of Contents

Foreword	
1 Scope	
2 Normative references	
3 Terms and definitions	
4 Classification	
5 Requirements	
5.1 Tree species	
5.2 Technical indicators	
6 Inspection method	
6.1 Inspection instruments and tools	
6.3 Determination of bark content	
6.4 Determination of the content of decaying wood chips	
6.5 Determination of nonwood content	
6.6 Determination of moisture content in wood chips	
6.7 How to distinguish between needle and hardwood chips	
7 Quantity calculation	
7.1 Volume calculation method	
7.2 Mass calculation method	
8 Sampling and determination	
8.1 Sampling	
8.2 Judgment	
9 Marking, packaging, storage and transportation	
9.1 Signs	
9.2 Packaging	
9.3 Storage	
9.4 Transport	

Foreword

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

Please note that some content of this document may involve patents, and the issuing authority of this document is not responsible for identifying these patents.

This standard replaces LY/T 1794-2008 Wood-based Panels.

Compared with LY/T 1794-2008, the main technical changes of this standard are as follows.

- Modified standard name and English translation (see cover).
- Added and modified some terms and definitions (see Chapter 3).
- Added classification (see Chapter 4).
- Modified requirements (see Chapter 5).
- Added inspection instruments and tools (see 6.1).
- The determination of the ratio of retained wood chips and qualified wood chips in each sieve layer has been modified (see 6.2).
- Modified the determination of bark content, the determination of decayed wood chips and the method of distinguishing needles and hardwood chips (see 6.3 and 6.4).
- Added a method for determining non-woody mixtures (see 6.5).
- Modified the determination of the moisture content of wood chips and the method of distinguishing between needle and broad-leaved wood chips (see 6.6 and 6.7).
- Added sampling and judgment (see Chapter 8).

This standard was proposed and managed by the National Timber Standardization Technical Committee (SAC/TC41).

This standard was drafted. Heilongjiang Institute of Wood Science, Heilongjiang Wood-based Panel and Log Saw Product Quality Supervision and Inspection Station, Lu Li Group Co., Ltd., Shandong Kaiyuan Wood Co., Ltd., Hebei State-owned Forest Management Branch of Heilongjiang Province.

1 Scope

This standard specifies the terms and definitions, classification, requirements, inspection methods, quantity calculation, sampling and judgment, marking, Packaging, transportation and storage.

This standard applies to wood chips for wood-based panel production and wood chip circulation.

2 Normative references

The following documents are essential for the application of this document. For dated references, only the dated version applies to this article Pieces. For undated references, the latest version (including all amendments) applies to this document.

GB/T 7909-2017 paper chip

3 Terms and definitions

Wood chips used for wood-based panel Wood chips with certain specifications and dimensions obtained by machining from wood as raw materials are used to make wood-based panels.

Wood chips used for particleboard Wood chips used in the manufacture of particleboard.

Wood chips used for fiberboard Wood chips used in the manufacture of fiberboard.

Wood chips used for special man-made board it is used to make wood chips for directional particle board, waffle chipboard, veneer lumber, etc.

Sieve plate

A metal plate with a specific shape and a prescribed circular hole.

Effective sieve area the actual area along the bottom of the screen.

Fines pan

A collection tray at the bottom of the shaker screen without any pores and used to catch the wood chips coming out of the screen.

Weight percent ratio of a certain screen tray the mass of wood chips remaining on a certain layer of sieve sieve in the screening of wood chips accounts for the percentage of the total mass of wood chips before screening.

Weight percent ratio of accept chips Samples are taken and sieved in accordance with the regulations. Except for the wood chips remaining on the first layer of sieve plate and wood chip collecting tray, the sum of the ratio of wood chips remaining in other sieve layers.

3.10

Oversize chips

Wood chips remained on the first sieve plate of the shaker sieve.

3.11

Sawdust fines

Fine woody impurities were measured on the last sieve plate of the sieve by shaking.

4 Classification

By purpose.

a) wood chips for particleboard;

- b) wood chips for fiberboard;
- c) Wood chips for other wood-based panels.

5.1 Tree species

All needles and broad leaves are suitable for tree species.

5.2 Technical indicators

Should meet the requirements of Table 1.

Table 1 Technical indicators

Project unit Wood chipboard Length mm 15 ~ 63 7 ~ 45 Thickness mm 2 ~ 8 3 ~ 5 Qualified wood chip ratio% ≥ 70 Wood chips content% ≤ 10 ≤ 2 Bark content% ≤ 15 ≤ 3 Content of decayed wood chips% ≤ 4 Non-wood mixture content% ≤ 0.5 Note. Other indicators and other technical indicators of wood chips for wood-based panels can be agreed between the supply and demand sides.

6.1 Inspection instruments and tools

- balance, accuracy 0.01g;
- Electronic scale, accuracy 0.01g;
- Stopwatch, accuracy 0.1s;
- Blast drying oven, temperature control range is 10 ~ 300 °C, temperature resolution is 1 °C.
- Vibration measurement sieve, sleeve screen composed of multiple sieve plates, usually 5-7 layers.

Determine the number of sieve plate layers and the pore size of the sieve plate according to the size of the largest piece of wood in the sample (target size).

The sheet is left in the middle layer or the middle two layers of the jacket sieve. Table 2 shows the combination of the number of sieve layers and the pore size of several shakers. Effective screening area of sieve plate $1200 \pm 100\text{cm}^2$, the height of the edge of the sieve plate is not less than 80mm, the distance between the sieve plate and the sieve plate is 100mm ~ 150mm, and the bottom of the sieve plate is in accordance with every three the circular holes and the center of the circle form an equilateral triangle. The circular holes with the same diameter are distributed regularly. All the circular holes must be complete and between the centers of any two circular holes.

The distance must be at least 1.2 times the diameter of the circular hole. The distance between the uppermost sieve plate edge and the uppermost edge of the screen sleeve is