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LY

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

LY/T 1923-2020

Replacing LY/T 1923-2010

**Indoor wood-based door
(English Translation)**

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Foreword

This document starts from the rules given in GB/T 1.1-2020 "Guidelines for Standardization Work Part 1: Structure and Drafting Rules of Standardized Documents" grass.

Appendix A of this document is a normative appendix, and Appendix B is an informative appendix.

This document replaces LY/T 1923-2010 "Indoor Wooden Doors". This document is compared with LY/T 1923-2010, except for editorial changes, the main the main technical content changes are as follows.

- Modified the scope of application of indoor wooden doors;
- Modified some definitions and classifications;
- Added the requirements and inspection methods that the wooden raw materials used are consistent with the product declaration or labeling, and appended Appendix A;
- Modify the door leaf warpage requirements and measurement methods to flatness requirements and measurement methods;
- The requirements for moisture content have been revised, and Appendix B has been added;
- Modified the dipping and peeling index, and revised the surface resistance to washing liquid requirements and inspection methods to the surface pollution resistance

requirements and inspections method;

-Increase the light fastness performance, paint film yellowing resistance performance requirements and inspection methods;

- Increased the soluble heavy metal content requirements and inspection methods;

- Increased the limit requirements and inspection methods for benzene series, and increased the limit requirements and inspection methods for total volatile organic compounds;

--Modified the test items of the factory inspection;

1 Scope

This document specifies the terms and definitions, classification, requirements, inspection methods, inspection rules, marking, packaging, transportation and Storage etc.

This document applies to indoor wooden doors that use solid wood or other wooden materials as the main material. Not applicable to those stipulated by national compulsory standards Wooden doors with special functions, such as fire doors and anti-theft doors.

2 Normative references

The contents of the following documents constitute indispensable clauses of this document through normative references in the text. Among them, dated reference documents, Only the dated version is applicable to this document; for undated references, the latest version (including all amendments) is applicable to this document file.

GB/T 2828.1-2012 Sampling Inspection Procedures by Attributes Part 1: Batch Inspection Sampling Plan Retrieved by Acceptance Quality Limit (AQL) GB/T 8485-2008 Airborne sound insulation performance classification and testing methods for building doors and windows GB 8624-2012 Classification of burning performance of building materials and products GB/T 14155-2008 Whole door soft and heavy object impact test GB/T 17657-2013 Test method for physical and chemical properties of wood-based panels and facing wood-based panels GB 18580-2017 The limit of formaldehyde emission in wood-based panels and products of indoor decoration and refurbishment materials GB 18584-2001 Limits of harmful substances in wooden furniture for interior decoration and refurbishment materials GB/T 19367-2009 Determination of the size of wood-based panels GB/T 23987-2009 Artificial weathering of paint and varnish coatings, exposure to fluorescent ultraviolet rays and water GB/T 29739-2013 Durability test method for repeated opening and closing of doors and windows GB/T 29899-2013 Test method for the emission of volatile organic compounds in wood-based panels and its products. Small release chamber method Note. For undated references, if the latest version contains the quoted content, then the last version that contains all quoted content applies.

3 Terms and definitions

The following terms and definitions apply to this document.

Wood-based door

Door frames and door leaves made of solid wood or other wooden materials as the main materials and combined with hardware, the unit is . wood the main structure of the quality gate is shown in Figure 1 and Figure 2.

Figure 1 Schematic diagram of a typical door frame Figure 2 Schematic diagram of a typical door leaf skeleton

Indoor wood-based door the wooden door that separates the two indoor spaces of the building.

Door frame

Fixed at the door opening of the wall, supporting the movable door leaf and the frame-shaped wooden component for installing the fixed door leaf. It consists of a frame, an upper frame and a decorative board (line/Set line) composition, product name door cover.

Door sheet

The general name of the movable door, standby door, fixed door and other openable parts and non-openable parts.

Solid wood door

The door leaf and door frame are all wooden doors made of solid wood sawn timber or laminated timber of the same species or similar nature.

Solid wood composite door Use decorative veneer or restructured decorative veneer as the facing material, and use solid wood sawn timber, finger-joined timber, laminated timber, laminated veneer timber and other materials as the framework Material or door frame, a wooden door made of fiberboard, particle board or honeycomb paper as the core material.

Wood-based composite door Except for solid wood doors and solid wood composite doors, the surface uses opaque paint or PVC, PP, PE, CPL or HPL as the facing material, other Part of the wooden doors made of wood-based man-made panels as the main material.

4.1 According to material composition

- a) Solid wood doors;
- b) Solid wood composite door;
- c) Wooden composite doors;

4.2 According to surface decoration

- a) Paint finish door. transparent finish, opaque finish;
- b) Oil wax veneer doors. wood wax oil and other veneers;
- c) Other decorative doors. impregnated film paper, paint decorative paper, polyvinyl chloride (PVC), polypropylene (PP), polyethylene (PE), Thermosetting resin impregnated paper continuous laminate (CPL), thermosetting resin impregnated paper high pressure laminate (HPL), etc.

5.1.1 Raw and auxiliary materials

The quality of the materials used in the door leaf and door frame shall comply with the national standards or industry standards of the relevant products. The wood raw materials used to the source should meet the requirements of relevant national laws and regulations; the hinges, screws, door stops, door buckles, door closers, locks, hardware, connectors and the quality of auxiliary materials such as sealing strips should meet the requirements of the relevant product national standards or industry standards.

5.1.2 Consistency of wood raw materials and solid wood

The main raw materials used should be clearly indicated in the wooden raw material information sheet for indoor wooden doors (Appendix A).

The material information indicates that the materials shown should be consistent with the actual wood, wood-based panels, and facing materials used in the product. Use wood raw materials and products Product declaration or labeling should be consistent with requirements, see Appendix A.

5.2.1 Structural dimensions of door leaf and door frame

The structural dimensions of the door leaf and door frame can be determined according to the door opening size, door frame structure, and installation gap.

5.2.2 The thickness of the door leaf the conventional thickness of the door leaf is 35mm, 38mm, 40mm, 45mm, 50mm, 55mm, 60mm, and both parties can negotiate Produce doors of other thicknesses.

5.2.3 Thickness of the door frame

The thickness of the door frame is determined according to the design requirements. The thickness of the joint between the door frame and the ordinary hinge shall not be less than 25mm, and the joint with the T-shaped hinge the thickness should not be less than 18mm. 28 mm, 30 mm, 38 mm, 40 mm, 45mm, 50mm are preferred, both supply and demand parties can also Negotiate to produce door frames of other thicknesses.