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

LY/T 3132-2019

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

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Foreword

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

Please note that some elements of this document may involve patents. The issuer of this document is not responsible for identifying these patents.

This standard was proposed and managed by the National Timber Standardization Technical Committee (SAC/TC 41).

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1 Scope

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

This standard applies to wooden sliding doors as defined in 3.1.

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 2828.1-2012 Counting sampling inspection procedure Part 1. Sampling plan for batch inspection for retrieval by acceptance quality limit (AQL) GB/T 4897-2015 particleboard GB/T 9846-2015 ordinary plywood GB/T 10125-2012 artificial atmosphere corrosion test salt spray test GB/T 11718-2009 medium density fiberboard GB/T 15102-2017 Particleboard and fiberboard GB/T 15104-2006 Requirements for decorative veneer facing wood-based panels GB/T 17657-2013 Test methods for physical and chemical properties of wood-based panels and facing wood-based panels GB 18580-2017 Formaldehyde release limit for interior decoration materials artificial boards and their products GB 18584-2001 Limits of harmful substances in wood furniture for interior decoration materials GB/T 19367-2009 Dimensional determination of wood-based panels GB/T 34722-2017 impregnated film paper facing plywood and blockboard GB/T 34742-2017 Specification for wood and wood-based panels for wooden doors and windows HJ 571-2010 Technical requirements for environmental labeling products Wood-based panels and their products LY/T 1279-2008 PVC film facing artificial board LY/T 1787-2016 Laminates for non-structures QB/T 4463-2013 Technical requirements for edge banding for furniture

3 Terms and definitions

The following terms and definitions apply to this standard.

Sliding wood-based door A door made of wood material that can be reciprocated on a slide

or track.

4 Classification

1.1 4.1 Classification by main material

- a) Solid wood sliding door
 - b) Composite sliding door
 - c) Other sliding doors
- ### 1.2 4.2 Classification by Finishing Materials

- a) Paint finish sliding door
- b) Sliding door with impregnated film
- c) Polyvinyl chloride film (PVC) facing sliding door
- d) Other facing sliding doors

5.1 Materials

The materials used for wooden sliding doors should generally meet the requirements of Table 1. According to customer needs, the supply and demand sides can be determined through negotiation.

Table 1 Quality requirements of main and auxiliary materials for wooden sliding doors

Material name quality requirements Wood should meet the requirements of GB/T 34742-2017 Laminated timber shall meet the requirements of LY/T 1787.

Dipping film paper facing people Build plate Formaldehyde release GB 18580-2017 Requirements Other properties should meet GB/T 15102-2017 and GB/T 34722-2017 requirements.

PVC film facing

Artificial board

Other properties shall meet the requirements of LY/T 1279-2008.

Decorative veneer man-made Other properties shall meet the requirements of GB/T 15104-2006.

glass

Its performance should meet the requirements of GB/T 26695-2011. Framed sliding doors are not subject to this limit.

system. Wooden sliding doors used in public places, "nominal thickness is not less than 5mm", steel is recommended of glass.

Edge banding meets the requirements of QB/T 4463-2013.

Hardware Parts

The physical and chemical properties of hardware accessories should meet the requirements of relevant standards. After the salt spray corrosion resistance test, the surface should be free from defects such as swelling, blisters, peeling, rust, discoloration and loss of light.

5.2.1 Dimensional deviation requirements

The dimensional deviation of wooden sliding doors shall meet the requirements of Table 2.

Table 2 Dimension deviation unit is mm

5.2.2 Form and Position Tolerance

The shape and position tolerances of wooden sliding doors shall meet the requirements of Table 3.

Table 3 Form and Position Tolerance

5.3.1 Appearance quality of solid wood sliding door and veneer sliding door

The appearance quality of solid wood sliding door and veneer sliding door shall meet the requirements of Table 4.

Table 4 Appearance quality of solid wood sliding door and veneer sliding door

Requirements for inspection items
 Decorative Visual color and beautiful pattern Pattern consistency Material color unevenness, discoloration and discoloration are not obvious
 Dead knot, hole Holes, jackets, Resin lane Half alive, dead, holes, Jacket and resin lane, gum lane Defects per square meter the total number of the largest single diameter of half joints/mm 10, less than 5 is not considered Dead joint, wormhole, hole single maximum diameter/mm is not allowed Jacket single maximum diameter/mm 10, less than 5 Resin canal, gum canal, pith plaque maximum single diameter/mm 10, less than 5 Item deviation Height ± 2 Width ± 1.5 Thickness ± 0.5 Project tolerance Verticality and edge straightness $\leq 1.0\text{mm}/1\text{m}$ Surface flatness $\leq 1.0\text{mm}/500\text{mm}$ Warpage $\leq 0.15\%$ Decay is not allowed crack Single width/mm 0.3 Single length/mm 100 Stitching Single width/mm 0.3 Single length/mm.200 Maximum single width of lamination/mm Bubbling and delamination are not allowed Sagging, indentation, and bulging are not allowed Patches, Material color, pattern and surface Consistency Difficult to distinguish Burr groove marks, knife marks, scratches are not obvious Sand permeation width/mm 3, only allowed at the edge of the board Other defects do not affect the decorative effect Processing of corrugations is not allowed Film scratches * Not obvious Paint sag * Not allowed Film bubbling * Not allowed Leakage paint * not noticeable Contamination (including grooved frame color parts) Pinhole