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

LY/T 3136-2019

Test method of rotary veneers drying quality

旋切单板干燥质量检测方法

(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 was proposed and managed by the National Timber Standards Committee (SAC/TC41).

The main drafting organizations of this standard. Beijing Forestry University, Yamatobo Maki Materials Co., Ltd., Jiangsu Brothers Smart Home Co., Ltd., Zhejiang Shiyou Wood Industry Co., Ltd., Shandong Feixian Jinli Rotary Cutting Machinery Factory.

1 Scope

This standard specifies the moisture content of veneer, distribution of moisture content of dry veneer, average moisture content of dry veneer, uniformity of moisture content of dry veneer, Detection method for drying veneer deformation and drying veneer cracking.

This standard is suitable for dry rotary cut veneer for various purposes.

2 Reference standards

The following documents are essential for the application of this document. For dated application 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 1931-2009 Wood moisture content determination method GB/T 15035-2009 Wood

drying term GB/T 17657 Test methods for physical and chemical properties of wood-based panels and facing wood-based panels

3 Terms and definitions

The terms and definitions defined in GB/T 15035-2009 and the following are applicable to this document.

Moisture content of veneer the mass of moisture contained in the veneer is the percentage of the mass of the dry veneer.

The moisture content of dried veneer the moisture content of veneer drying accounts for the percentage of veneer dry mass.

The moisture content distribution of dried veneer the moisture content distribution of each measurement point in the moisture content measurement area of the dry veneer.

The average moisture content of dried veneer the average value of the moisture content at each measurement point in the area where the moisture content of the dry veneer is measured.

The uniformity of moisture content of dried veneer the difference between the maximum moisture content and the minimum moisture content in the average moisture content of the measured dry veneer.

The warping of dried deformation Veneer warping is the torsional deformation of a veneer that fails to maintain its original flat shape due to the uneven shrinkage and stress of the veneer.

The cracking of dried veneer Refers to cracks caused by stress during the drying of veneer.

4.1 Veneer moisture content

Measured in accordance with 4.3 of GB/T 17657

4.2.1 Sampling and numbering

On the dry veneer tape, randomly select no less than 3 test veneers, and the size is the size in the fiber direction.

Degree dimension, the dimension in the vertical fiber direction is not less than 700mm;

The specification of the moisture content test sample is about 100mm x 100mm.

On each test veneer, label the veneer samples according to the numbering method shown in Figure 1;

Separate size is not less than 200mm, in vertical the size of the gap in the fiber direction is not small at 100mm.

In millimeters

4.2.2 Instrument

According to 4.3.2 of GB/T 17657.

4.2.3 Detection method

Test in accordance with GB/T 17657, 4.3.3.

4.2.4 Calculation method of moisture content distribution of dried veneer

The calculation of the moisture content distribution of the dried veneer is performed according to formula (1).

Where. (ij)-moisture content of the veneer at position (ij), %;

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G0 (ij)-the absolute dry mass of the veneer sample at position (ij), the unit is gram (g);

G1 (ij)-the initial mass of the wet veneer sample at position (ij), the unit is grams (g);

i- the number of the sample in the vertical fiber direction;

j- the number of samples in the direction of the fiber.

4.3.1 Sampling and numbering

In accordance with the provisions of 4.2.1.

4.3.2 Instrument

According to 4.3.2 of GB/T 17657.

4.3.3 Detection method

Test in accordance with the test method of 4.1.3.

4.3.4 Calculation method of average moisture content of dry veneer

The calculation of the average moisture content of the dry veneer is performed according to formulas (2), (3), and (4) (any one is sufficient).

Where.-the average final moisture content of the dry veneer, (%);

G0 (ij)-the absolute dry mass of the veneer sample at position (ij), the unit is gram (g);

G1 (ij)-the initial mass of the veneer sample at position (ij), the unit is. gram (g);

4.4.1 Sampling

On the dry veneer tape, randomly select no less than 9 test veneers, and the size is the width of the veneer tape in the fiber direction.

Degree dimension, the dimension in the direction of the vertical fiber is not less than 700mm.

4.4.2 Instrument

According to 4.3.2 of GB/T 17657.

4.4.3 Detection method

Test in accordance with GB/T 17657, 4.3.3.

4.2.4 Calculation method of moisture content uniformity of dry veneer

The calculation of the uniform moisture content of the dry veneer is performed according to formula (5).

In the formula.

- Uniformity of moisture content of dry veneer, (%);
- Maximum value of the average moisture content of the selected dry veneer (%);
- Minimum value of the average moisture content of the selected dry veneer, (%).

4.5.1 Test specimen

Samples of veneer are randomly selected in the dry veneer, and the specifications are that the size in the fiber direction is the width of the veneer strip, and the vertical fiber the direction is the natural width of the veneer.

4.5.2 Measurement method

Place the dry veneer flat on the horizontal operation platform, and the corner feet on both sides of the measured end face must be in contact with the horizontal operation platform;

Use a ruler with a length of $\geq 2000\text{mm}$ (accuracy $\geq 1\text{mm}$) to measure the horizontal dimension of the veneer in the direction of the horizontal stripes, L , as shown in Figure 2;

Using a ruler with a length $\geq 2000\text{mm}$ (accuracy $\geq 1\text{mm}$), measure the maximum arch height dimension at the end of the veneer, H , as shown in Figure 2.