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

LY/T 3232-2020

Frame type engineered wood flooring

框架式实木复合地板

(English Translation)

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Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for Standardization Work Part 1: Structure and Drafting Rules of Standardization Documents" Drafting.

Please note that some contents of this document may involve patents, the publication of this document the agency is not responsible for identifying these patents.

This document was proposed and managed by the National Wood-based Panel Standardization Technical Committee (SAC/TC198).

1 Scope

This document specifies the terms and definitions, classification and materials, requirements, inspection methods, inspection rules, markings, Packaging, transportation

and storage.

This document applies to frame-type solid wood composite flooring.

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 version corresponding to that date is applicable to this document; for undated references, the latest version (including all amendments) is applicable to this document file.

Note: For undated references, if the latest version does not contain the quoted content, then the last version containing the quoted content applies.

GB/T 2828.1-2012 Sampling inspection procedure by attributes Part 1: Batch inspection sampling plan retrieved by acceptance quality limit (AQL) GB/T 15036.2-2018 Solid Wood Flooring Part 2: Inspection Method 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 The limit of formaldehyde emission in wood-based panels and products for indoor decoration and refurbishment materials LY/T 1700-2018 wooden floor for floor heating

3 Terms and definitions

The following terms and definitions defined in GB/T 18103-2013 and GB/T 18259-2018 apply to this document.

Frame type engineered wood flooring the frame structure composed of solid wood short material and solid wood long side strips is used as the core board, and the vertical veneer is covered on the lower surface of the core board to form the floor base material, and the surface of the base material is covered with a decorative veneer, and the grooved and grooved floor is made by coating. The structure is shown in Figure 1. Use decorative veneer tree species to determine the name of the floor tree species.

Figure 1 Schematic diagram of frame type solid wood composite floor

4.1 Classification

- a) Frame type solid wood composite floor for non-floor heating
- b) Frame type solid wood composite floor for floor heating

4.2.1 Moisture content

The moisture content of the core board, the base material panel, the base material base plate and the decorative veneer is $\leq 12.0\%$.

4.2.2 Core board

4.2.2.1

Longitudinal solid wood strips have a density of 0.30g/cm^3 or more, a width of 15.00mm to 20.00mm, and a thickness of 7.00mm to 14.00mm. Such as when it is a finger-joined material, the staggered seams at the finger joints of the corresponding edge strips should be greater than 50mm.

4.2.2.2

Horizontal solid wood short material has a density of 0.30g/cm^3 or more, a width of 20.00mm~50.00mm, and a thickness of 7.00mm~14.00mm. same Batch solid wood short materials use the same tree species or tree species with similar wood properties.

4.2.2.3

The spliced core board should be flat.

4.2.3 Substrate panel, substrate backplane

4.2.3.1

Commonly used tree species. poplar, eucalyptus and other suitable tree species.

4.2.3.2

The thickness of the base material panel and base plate is 1.00mm~3.00mm.

4.2.4.1 Commonly used tree species

Fraxinus mandshurica Rupr, Ulmus sp., Quercus mongolica Fisch, Hickory (Carya spp.), Birch (Betula sp.), Maple (Acer mono Maxim), Cherry (Prunus spp.), Maple Wood (Liquidambar formosana Hance), Disc beans (Cylicodiscus sp.), Teak (Tectona grandis Lf), Black walnut (Juglans spp), balsamic pigeon peas (Myroxylon sp.), cliff peas (Milletia sp.), Panlongan (Pometia sp.) and other applicable tree species.

4.2.4.2 Common thickness

1.00mm~4.00mm.

5.1 Specifications and dimensions

The specifications and dimensions of the frame type solid wood composite floor shall meet the requirements of Table 1.

5.2 Dimensional deviation

The size deviation should meet the requirements of GB/T 18103-2013 Table 2.

5.3 Appearance quality

The appearance quality should meet the requirements of Table 1 of GB/T 18103-2013.

5.4 Physical and chemical properties

The physical and chemical properties should meet the requirements of Table 2.

6.1 Specifications and dimensions

Carry out in accordance with 6.2 of GB/T 18103-2013.

6.2 Appearance quality inspection

Carry out in accordance with 6.1 of GB/T 18103-2013.

6.3.1 Specimen production, test specimen size and quantity regulations

10 pieces of flooring are randomly selected from the sample, and the production position, size and quantity of the test pieces shall meet the requirements of Figure 2, Figure 3 and Table 3. ruler when the inch is insufficient, it can be spliced. When the sample preparation fails to meet the test requirements, the number of samples may be appropriately increased.

Figure 2 Schematic diagram of preparation of non-floor heating floor test pieces

Figure 3 Schematic diagram of preparation of test pieces of floor heating floor

6.3.2 Dipping and peeling

According to the provisions of 6.3.2 of GB/T 18103-2013.

6.3.3 Bending strength and elastic modulus

According to GB/T 17657-2013 in 4.7, the test piece needs to be balanced.