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

LY/T 3234-2020

**General technical requirements of digital inkjet printing
decorated wood products**

数码喷印装饰木制品通用技术要求

(English Translation)

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Foreword

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

Drafting.

This document was proposed and managed by the National Wood-based Panel Standardization Technical Committee (SAC/TC 198).

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Company, Zhejiang Shiyou Wood Industry Co., Ltd., Ruitong Polymer Technology (Zhejiang) Co., Ltd., Jiangsu Province Furniture and Furnishing Product Design Engineering Technology Research centers, etc.

1 Scope

This document specifies the terms and definitions, classification, requirements, test methods, inspection rules and signs, Packaging, transportation and storage, etc.

This document is applicable to the direct use of ultraviolet curing (UV) resin ink on the surface of wood, wood-based panels, wood-plastic composite materials and other substrates.

Products that are decorated with digital inkjet printing three-dimensional wood grains or patterns. Other substrates for digital printing decoration products can be implemented by reference.

2 Normative references

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

Note: For undated reference documents, if the latest version contains the quoted content, then the the last version applies.

GB/T 8485 Classification and testing method of airborne sound insulation performance of building doors and windows GB 8624 Classification of burning performance of building materials and products GB/T 15036.1-2018 Solid Wood Flooring Part 1: Technical Requirements GB/T 15036.2-2018 Solid Wood Flooring Part 2: Inspection Method GB/T 15102-2017 Impregnated film paper facing fiberboard and particleboard GB/T 17657-2013 Test method for physical and chemical properties of wood-based panels and facing wood-based panels GB/T 18102-2007 Impregnated paper laminated wood floor GB/T 18103-2013 Solid wood composite floor GB/T 18259-2018 Artificial board and its surface decoration terms GB/T 33042-2016 Determination of lead, cadmium, chromium and mercury heavy metal elements in wooden floor finishes GB/T 34722-2017 Impregnated film paper veneer plywood and blockboard GB/T 37005-2018 Paint facing wood-based panel LY/T 1657-2015 Cork flooring LY/T 1658-2006 Direct printing wood-based panel LY/T 1697-2017 veneer wooden wall panel LY/T 1858-2009 Coating impregnated paper laminated wood floor LY/T 1923-2010 interior wooden door LY/T 1986-2011 Direct printing wood floor

3 Terms and definitions

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

Digital inkjet printing Under the control of the computer, the high-resolution image

generated by the digital information is directly formed into fine droplets of ink through the nozzle.

The method of spraying onto the surface of the substrate and quickly curing to form decorative patterns or patterns, also known as digital inkjet printing, or digital printing, digital Inkjet printing.

Digital inkjet printing decorated wood products Use UV resin ink to directly digitally print three-dimensional wood grain or patterns on the surface of wood, man-made panels, wood-plastic composite materials and other substrates.

Decorative products, as well as products coated with paint on the surface of digital inkjet printing.

Digital inkjet printing covered wood products Also known as full-color digital printing wood products or over-color digital printing wood products, it is digital printing another kind of wood grain or Patterns are fully covered and decorated products. For example, digital printing teak wood grain on the surface of poplar solid wood floor is digital printing teak color wooden floor.

Digital inkjet printing stained wood products it is also called toning digital printing wood products or color repairing digital printing wood products. It is digital printing on the surface of the base material with natural wood grain.

A kind of wood grain coloring, dyeing or enhancing wood grain decoration products. For example, the teak wood grain is digitally printed on the surface of ordinary teak solid wood flooring, it is digitally printed teak solid wood flooring.

Inkjet printed layer Three-dimensional wood grain or pattern directly digitally printed with UV resin ink on the surface of wood, wood-based panels, wood-plastic composite materials and other substrates and other coatings, also called printing layers.

Coating layer (paint layer) coated layer Coating with paint (paint) on the surface of the spray printing layer.

Decorated surface; decorated layer A surface composed of a spray-printed layer alone or a spray-printed layer and a coating layer.

Dried flower frosting mark the opaque white variegation on the decorative surface is also called white flower.

[Source. GB/T 18259-2018,.4.68, with modification].

Scratches

In the process of processing and handling, scratches on the decorative surface caused by scratches.

[Source. GB/T 18259-2018, 3.4.75, with modification].

3.10

Imprint

Local dents on the decorative surface caused by external factors.

[Source. GB/T 18259-2018, 2.48, with modification].

3.11

Substrate revealment A phenomenon in which the color or defects of the substrate (or substrate) appear on the decorative surface due to insufficient hiding power of the spray printing layer.

[Source. GB/T 18259-2018, 3.4.77, with modification].

3.12

Collapse dents

Partial defects or jagged defects on the edge of the decorative surface.

[Source. GB/T 18259-2018, 3.4.78, with modification].

3.13

Bubbling blisters

Partial abnormal bulge caused by gas contained in the decorative surface.

[Source. Rewrite GB/T 18259-2018, 2.45, with modification].

3.14

Bulge

The decorative surface is locally abnormally convex due to the solid object inside.

[Source. GB/T 18259-2018, 3.4.79, with modification].

3.15

Delamination

The phenomenon of separation between the spray-printed layer and the substrate, or between the coating layer and the spray-printed layer.

[Source. GB/T 18259-2018, 2.44, with modification].

3.16

Spot; dirty and similar surface defects Ink marks appearing during surface printing and finishing, and spots formed on the decorative surface by sundries during processing.

[Source. GB/T 18259-2018, 3.4.72, with modification].