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Replacing GB/T 19367.1-2003, GB/T 19367.2-2003

Wood-Based Panels -

Determination of Dimensions of Panels

(ISO 9426:2003, MOD)

人造板的尺寸测定

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Issued by: General Administration of Quality Supervision, Inspection and Quarantine;
Standardization Administration of PRC.

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Foreword

This Standard modified and used international standard ISO 9426:2003 *Wood-Based Panels - Determination of Dimensions of Panels* (English Version).

When this Standard modifies and uses internationals standard, the technical differences shall be marked with vertical single-line on the terms of their margins. Compared with ISO 9426:2003, this Standard has the technical differences as follows:

--- Add the following contents to 8.1: NOTE 1: in the event of a dispute between the supplier and the purchaser, the panel is allowed to be sawed from the middle, then measure as per above-mentioned method. NOTE 2: in the event of a dispute between the supplier and the purchaser, the micrometer with probe dimeter of 15.0mm~20.0mm is allowed to be used for measurement.

--- Modify the rope-line into metal line in “8.5 Determination of flatness”.

This Standard is the integrated revision against GB/T 19367.1 and GB/T 19367.2.

This Standard replaced GB/T 19367.1-2003 *Wood-Based Panels – Determination of Thickness, Width and Length of Boards*, and GB/T 19367.2-2003 *Wood-Based Panels – Determination of Squareness and Straightness of Boards*.

Compared with GB/T 19367.1-2003, GB/T 19367.2-2003, this Standards has the differences as follows:

--- Add the contents of balance treatment;

--- Add the measurement contents of paperback degree.

This Standard was proposed by the State Forestry Administration of the PRC.

This Standard shall be under the jurisdiction of National Technical Committee for Standardization of Wood-Based Panels.

Drafting organizations of this Standard: Research Institute of Wood Industry, Chinese Academy of Forestry.

Participating drafting organizations of this Standard: Shanghai Institute of Quality Inspection and Technical Research, Dehua Tubao New Decoration Material Co., Ltd., Foshan Nanhai Yaodonghua Furniture Boards Co., Ltd., Guangxi Fenglin Wood Industry Group Co., Ltd., Jiangmen Daping Wood Industry Co., Ltd., Foshan Zhengsen Wood Working Co., Ltd., Nanjing Leibo Texiangshi Wood Industry Co., Ltd., Asia Dekor Industries (Shenzhen) Co., Ltd., Shengda Forestry Industry Co., Ltd., Shandong Xingang Group Co., Ltd.

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Wood-Based Panels - Determination of Dimensions of Panels

1 Scope

This Standard specifies the measurement methods for the thickness, width, length, squareness, edge straightness and flatness of various wood-based panels.

This Standard is applicable to the wood-based panels with entire plane shape.

2 Normative References

The provisions in following documents become the provisions of this Standard through reference in this Standard. For dated references, the subsequent amendments (excluding corrigendum) or revisions do not apply to this Standard, however, parties who reach an agreement based on this Standard are encouraged to study if the latest versions of these documents are applicable. For undated references, the latest edition of the referenced document applies.

GB/T 17657 Test Methods of Evaluating the Properties of Wood-based Panels and Surface Decorated Wood-based Panels

3 Principle

Measure the entire panel's thickness, length and width through the linear measurement method.

Measure the entire panel's squareness and straightness through measuring the deviation between the mechanical-square or ruler and the panel.

Measure the flatness through measuring the surface deviation of the metal line measurement panel that penetrates the whole surface and is straightened by the panel's edge.

4 Sampling

For the bulk testing of the finished panels, it shall be sampling according to the relevant provisions of individual product standard for various wood-based panels.

stipulated in 7.5 to measure the distance δ_1 between the panel's edge and the other arm's side of the mechanical-square (see Figure 3).

Follow the same method for other corners.

NOTE: For process control of factory production, if the valid relevant data can be confirmed, the squareness can also be measured by the difference of two-diagonals' length of the panel; use steel tape to measure.

8.4 Determination of edge straightness

Place the ruler against one edge of the panel; or place the straightened metal wire in the two corners of the panel.

Use the measuring instrument stipulated in 7.5 to measure the maximum deviation between the ruler (or straightened metal wire) and the panel's edge, the result shall be accurate to 0.5mm.

Follow the same method for other edges.

8.5 Determination of flatness

Place the panel on a horizontal surface without any external force; measure the distance between the whole-surface of the tested panel and the straightened metal wire; find out the surface distance between the metal wire and maximum deformation point of the panel; use steel ruler to measure, accurate to 0.5mm.

9 Result Expression

9.1 Thickness

For each tested panel, use the arithmetic mean of each measurement value to express the thickness, accurate to 0.1mm.

9.2 Length and width

For each tested panel, use the arithmetic mean of each measurement value to express the length and width, accurate to 1mm.

9.3 Verticality

The result is the maximum measurement value of deviation between the mechanical-square's side and the panel's edge; use the number of millimeters on the edge-length per meter of panel to express the squareness, accurate to 0.5mm/m.

9.4 Edge straightness

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