

ICS 79.060.20
B 70

GB

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

GB/T 4897-2015

Replacing GB/T 4897.1 ~ 4897.7-2003

Particleboard

刨花板

[ISO 16893-2:2010, Wood-based panels - Particleboard –
Part 2: Requirements, MOD]

Issued on: July 3, 2015

Implemented on: February 1, 2016

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China;
Standardization Administration of the People's Republic of
China.**

Table of Contents

Foreword.....	3
1 Scope	5
2 Normative references	5
3 Terms and definitions	6
4 Classification	8
5 Specification limits.....	8
6 Requirements.....	10
7 Measurement and test methods.....	19
8 Inspection rules.....	25
9 Symbols, packaging, transportation and storage	28
Annex A (Normative) Calculation of 5-percentile and 95-percentile values.....	29

Foreword

This Standard was drafted in accordance with the rules given in GB/T 1.1-2009 and GB/T 20000.2-2009.

This Standard is an amendment to GB/T 4897.1~4897.7-2003. Compared with GB/T 4897.1~4897.7-2003, the major technical changes in this Standard are as follows:

- COMBINE the standard divided into seven parts into one.
- The particleboards are divided into six types of panels based on the applications in previous edition, while they are divided into twelve types of panels in this Standard. Furthermore, ADD the property requirements of six types of panels.
- MODIFY the classification and symbols.
- MODIFY the determination method.
- ADD the testing method of moisture resistance.
- The testing method and limit requirements of formaldehyde release use the provisions of GB 18580.
- ADD the verticality measurement. DELETE the diagonal measurement.
- ADD the flatness measurement. DELETE the warpage measurement.
- ADD the following terms and definitions: “specification limit” and “high humid conditions”.
- As additional property indicators, dimensional stability and sand content’s requirements shall be determined after consultation between supplier and demander.

This Standard was redrafted by reference to ISO 16893-2:2010 *Wood-based panels - Particleboard - Part 2: Requirements (EN)* after modification. Compared with ISO 16893-2:2010, the major differences between this Standard and ISO 16893-2:2010 are as follows:

- MODIFY some expressions applicable to the international standards to those applicable to China’s national standards.
- ADD the method for determining the properties of individual panel.

- ADD Section 6.2 “Appearance quality”, Chapter 7 “Measurement and test methods”, Chapter 8 “Inspection rules”, Chapter 9 “Symbols, packaging, transportation and storage”.
- The testing method and limit requirements of formaldehyde release use the provisions of GB 18580.
- ADD the requirements for the water-absorbent thickness expansion ratio in 2h of the furniture grade particleboard for use in dry conditions
- ADD the definitions of particleboard, general purpose particleboard, furniture grade particleboard, load bearing particleboard and heavy-duty load bearing particleboard.
- ADD the flatness measurement.
- WIDEN the lower specification limits of the moisture content to 3%.
- ADD the calculation formula of mid-panel density deviation.

Some of the elements of this document may be the subject of patent rights. The issuing authorities of this document shall not be held responsible for identifying any or all such patent rights.

This Standard was proposed by State Forestry Administration of the People’s Republic of China.

This Standard shall be under the jurisdiction of the National Technical Committee for Standardization of Wood-based Panels (SAC/TC 198).

Drafting organizations of this Standard: Research Institute of Wood Industry, Chinese Academy of Forestry; Fujian Furen Wood Industry Co., Ltd; Kunming Xinfeilin Panel Board Co., Ltd; Jilin Forest Industry Co., Ltd; Dareglobal Wood (Fujian) Co., Ltd; Asia Dekor (Huizhou) Woods Co., Ltd; Power Unity Precedent Technology (Beijing) Co., Ltd; Handan Jinsaibo Panels Co., Ltd; Jiangxi Provincial Product Quality Supervision Testing College; Tangshan Jingsen Wood-based Panels Co., Ltd; and Southwest Forestry University.

Main drafters of this Standard: Long Ling, Chen Shiyong, Qu Yanchun, Zheng Fengshan, Zhang Jianjun, Chen Chongying, Jiang Fuchang, Wu Fangjing, Huang Mei, Yuan Yunzeng, Qiu Weixing, Yuan Junguo and Du Guanben.

The previous released editions substituted by this Standard are as follows:

- GB/T 4897-1985, GB/T 4897-1992 and GB/T 4897.1~4897.7-2003.

Particleboard

1 Scope

This Standard specifies the terms and definitions, classification, requirements, measurement and test methods, inspection rules, symbols, packaging, transportation and storage of the particleboards.

This Standard **is applicable to** the general purpose particleboards, furniture grade particleboards, load bearing particleboards and heavy-duty load bearing particleboards.

This Standard **is not applicable to** the oriented strand boards.

2 Normative references

The following documents are essential to the application of this document. For dated references, only the editions with the dates indicated are applicable to this document. For undated references, only the latest editions (including all the amendments) are applicable to this document.

GB/T 2828.1-2012 *Sampling procedures for inspection by attributes - Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection (ISO 2859-1:1999, IDT)*

GB/T 17657-2013 *Test methods of evaluating the properties of wood-based panels and surface decorated wood-based panels*

GB/T 18259-2009 *Terms of wood-based panel and its surface decoration*

GB 18580 *Indoor decorating and refurbishing materials - Limit of formaldehyde emission of wood-based panels and finishing products*

GB/T 19367-2009 *Wood-based panels - Determination of dimensions of panels*

LY/T 1717-2007 *Guide for sampling inspection of wood-based panels*