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

中华人民共和国轻工行业标准

QB/T 2976-2008

**Unplasticized polyvinyl chloride CPVC-U) color
profiles for the doors and windows**

**门、窗用未增塑聚氯乙烯 (PVC-U)
彩色型材**

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Foreword

The standard is prepared referring to GB/T 8814-2004 *Unplasticized Polyvinyl Chloride (PVC-U) Profiles for the Doors and the Windows* and formulated after modifying and supplementing the relevant requirements of color decorative profiles referring to the German standard DIN 16830-3:2000 *High Impact Polyvinyl Chloride (PV-U) Profiles for the Doors and the Windows-Part 3, the Surface Color Profile Requirements*.

The main differences between the Standard and GB/T 8814—2004 are as follows:

- Added requirements on bonding strength or adhesion for decorative layer and the profile body;
- Added heat stability requirements;
- Correspondingly added technical requirements for color profiles according to the decorative characteristic of various species;
- No stipulation for color profiles waste materials reuse;
- No stipulation for vicat softening temperature for surface decorative layer of three color profiles: laminating, coating, co-extruded color profiles;
- In “5.3.2 Main Profile Wall Thickness”, the requirements that Class B non-visual surface wall thickness shall be $\geq 2.2\text{mm}$ and Class C non-visual surface wall thickness shall be $\geq 2.0\text{mm}$ is added after December 31, 2009;
- The mentioned "neutral axis" in the result and representation in 6.10.4 of GB/T8814-2004 shall be changed to "centroidal axis";
- In 5.6 *Drop hammer Impact of Main Color Profiles*, the breakage rate requirements are not specified on the decorative surface of laminating, coating and co-extrusion color profiles.

Products specified in this Standard are suitable for durability application on exterior walls of building.

Annex A of this Standard shall be regarded as normative Annex.

This Standard was proposed by China National Light Industry Council.

The Standard is under the jurisdiction of the National Plastics Standardization Technical

Committee.

The Standard is mainly drafted by the following units: Special Committee of Profilewindow, China Plastics Processing Industry Association, Institute of Plastic Processing & Application of Light Industry (China National Center for Quality Supervision & Test of Plastic Products), National Test Center of Polymer & Chemical Building Materials, Zhejiang Zhongcai Profiles Co., Ltd., Dalian Shide Group Co., Ltd., Xi'an Gaoke Building Materials Technology Co., Ltd., Wuhu Conch Profiles and Science Co., Ltd., Baoding Bosoar New Type Building Material Co., Ltd., Beixin Plastic Materials Co. Ltd., Koemmerling (Tianjin) Kunststoff Co., Ltd., HWAP Construction Materials Co., Ltd..

Units involved in drafting this standard: Citiking Group Co., Ltd., Shanghai, GE (China) Co., Ltd., Rohm and Haas (China) Holding Co., Ltd., Shanghai Zhongyuan Chemical Application Technology Co., Ltd., Holland Colours (Shanghai) Co., Ltd., Shanghai Xinyuan Laminating Technology Co., Ltd., Chengdu Chuanhai Industrial Co., Ltd., Qingdao Laminate Machinery Co., Ltd..

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This Standard is first released.

Unplasticized polyvinyl chloride (PVC-U) color profiles for the doors and windows

1 Scope

This Standard specifies the terms and definitions, classification, requirements, test methods, inspection rules and marking, packaging, transportation and storage of unplasticized polyvinyl chloride (PVC-U) color profiles for the doors and the windows.

This Standard applies to the no color profiles for four-class doors and windows; laminating color profiles; co-extrusion color profiles; coating color profiles; quintana color profiles.

2 Normative References

The articles contained in the following documents have become this standard when they are quoted herein. For the dated documents so quoted, all the modifications (excluding corrections) or revisions made thereafter shall not be applicable to this Standard. For the undated documents so quoted, the latest editions shall be applicable to this Standard.

GB 250-1995 Gray scale for assessing change in colour

GB/T 1633-2000 Plastics--Thermoplastic materials--Determination of Vicat softening temperature (VST) (ISO 306: 1994, IDT)

GB/T 1766-1995 Paint and varnish—Rating schemes of degradation of coats

GB/T 2828.1-2003 Sampling procedures for inspection by attributea-Part1: Sampling schemes indexed by acceptance quality limit(AQL) for lot-by-lot inspection

GB/T 8814-2004 Unplasticized polyvinyl chloride (PVC-U)profiles for the doors and windows

GB/T 9286-1998 Paints and varnishes-Cross cut test for films

GB/T 9341-2000 Plastics--Determination of flexural properties

GB/T 13525-1992 Test method for tensile-impact property of plastics

GB/T 16422.2-1999 Plastics—Methods of exposure to laboratory light sources Part 2: Xenon-arc sources

ISO 179: 2000 Plastics - Determination of Charpy impact properties

ISO 2808: 1997 Paints and varnishes -- Determination of film thickness

3 Terms and definitions

For the purpose of this Standard, the following terms and definitions defined in GB/T 8814-2004 apply to.

3.1

Color profiles

The profiles for which the surface material or color is changed by certain technological process

3.2

Laminating color profiles

The profiles for which the surface is decorated with composite color film, expressed as FM.

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