

TECHNICAL SPECIFICATIONS

MELAMINE FACED CHIPBOARDS (P2, E1) Harmonized standard: EN 13986/EN 14322

CONTROL CRITERIA	TEST STANDARD	UNIT OR FEATURE	THICKNESS RANGE (mm, nominal)				
			<15	≥15 to 20 mm	>20 mm		
TOLERANCES ON NOMINAL DIMENSIONS ^{*1} -THICKNESS † RELATIVE TO NOMINAL VALUES	EN 14323	mm	± 0,3 for class 1&2 +0,5/-0,3 for class 3A, 3B and 4			±0,5	
-THICKNESS † WITHIN THE BOARD			t _{max} - t _{min} ≤ 0,6				
LENGTH AND WIDTH	EN 14323	mm	± 5				
EDGE DAMAGE	EN 14323	mm	≤ 10				
SURFACE DEFECTS	EN 14323	mm ² /m ²	points ≤ 2				
SURFACE DEFECTS	EN 14323	mm/m ²	line ≤ 20				
RESISTANCE TO SCRATCHING	EN 14323	N	≥ 1,5				
RESISTANCE TO CRACKING	EN 14323	Rating	≥ 3				
RESISTANCE TO STAINING	EN 14323	Rating	≥ 3				
RESISTANCE TO ABRASION	EN 14323	Revolution	Pattern Class 1 < 50 Plain Class 3A ≥ 150				
FORMALDEHYDE RELEASE	EN 12460-3	mg /m ² h	E1 Class ≤ 3,5 ^{*2}				
	EN 717-1	ppm	≤ 0.05, ChemVerbotsV requirements ^{*3}				
DENSITY	EN 323	kg/m ³	Thickness range (mm)				
			8 - 12	14 - 15	16 - 18	22 - 25	28 - 38
			690-720	660-680	630-650	610-620	600-615

Melamine Faced Chipboards with P2 support are boards used for interior furniture and decoration applications. It can be used for manufacture all kinds of furniture: profile-enclosed front panels, high-quality shelf panels, wall panels (Wallboard), decorative panels, kitchen furniture and office furniture.

Please refer to the “**Particleboard Technical Specifications, Type P2, E1**” for the substrate raw board specifications.

***1 Thickness tolerances:** Here the thickness expresses the total thickness of the raw **Chip** board and the coatings of both surfaces of the board.

***2** This type of **Melamine Faced Chipboards** complies with **E1 formaldehyde emission class** for thickness range (8 – 38)mm.

***3** This type of **Melamine Faced Chipboards** complies with **ChemVerbotsV** requirements and **IOS-MAT-0181** for thickness range (10 – 25)mm.

Colour matching and surface texture: A slight deviation of colour and / or surface texture according to Rating4 EN14323 between the test sample and Kastamonu reference sample.

It is recommended the components that will be used side by side should be selected from the same production batch to maintain colour compatibility.



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