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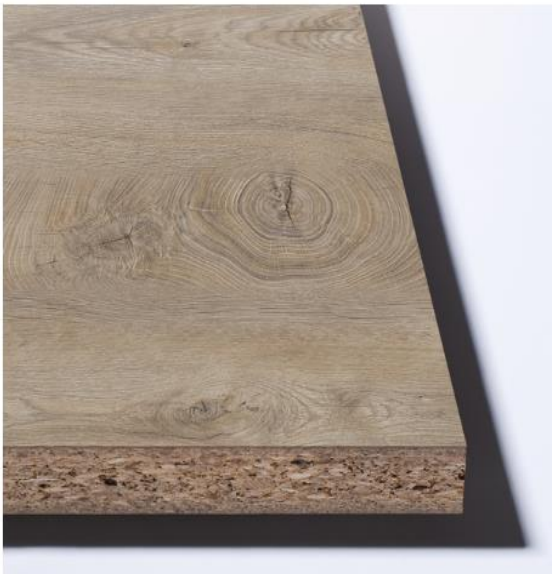
Technical data sheet

Product: Melamine faced particleboard MF PB P2 E-LE
Particleboard with decorative melamine foils coating



Product identification

Supporting substrate is three-layer particleboard PB P2 manufactured from specially selected wood chips and high-quality synthetic resin. Particleboard, sanded on both sides, is covered with a decorative paper impregnated with melamine resin. The boards are manufactured acc. to the EN 14322 standard, which specifies requirements for boards for interior use (especially for interior fitments, including furniture).

The boards are intended to be used mainly in the furniture industry and for interior finishing for use in dry conditions. 'Dry conditions' is characterised by a moisture content in the material corresponding to a temperature of 20°C and a relative humidity of the surrounding air only exceeding 65% for a few weeks per year. The boards are not suitable for use in humid conditions.

Boards are available in thickness range 8 - 38 mm.

By the request of customers, we can make boards according to EN16516.

Physical properties

Mechanical-physical and other properties needed for board use as non-loadbearing board in construction are determined in Declaration of performance (DoP) no. P2-CPR-2019-07-31 issued for raw particleboards P2.

Instruction for handling and processing

When loading and unloading the pallets/boards must not be moved one after the other for reason of possible damaging of MF PB surfaces or edges. Removing individual boards from packing is only possible vertically by lifting the board. Any moving or pulling of single boards across each other (over the edges etc.) must be avoided.

Special attention must be paid to cleanness of board surfaces during board transfer. Any mechanical particles between boards can lead to irreversible damage of board surfaces.

Transport

By road trucks. Canvas covers are used to protect the goods against climatic influence and fixing device (courting) are used to disable the movement and consequent damage of the goods inside the truck.
Railway carriages intended for this type of transport (closed and secured against climatic influence). In the carriages there are movable obstruction and fixing device (courting) which protects the goods against the

Manufacturer identification:

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Technical properties

Production tolerances of MF PB boards acc. EN 14322				
Properties		Test method	Attribute / unit	Requirement
Dimensional tolerances	Thickness	EN 14323	Thickness, 8 – 40 mm	± 0,3 mm
	Length and width	EN 14323	Standard delivered sizes	± 5 mm
Edge damage		EN 14323	Standard delivered sizes	≤ 10 mm
			Pre-cuts panels	≤ 3 mm
Surface defects		EN 14323	Points (sum up size of defects)	≤ 2 mm^2/m^2
			Length (sum up length)	≤ 20 mm/m^2

Production specification related to core particleboard EN 312, type P2							
Properties	Test method	Unit	Thickness range (mm, nominal)				
			8 to 13	> 13 to 20	> 20 to 25	> 25 to 32	> 32 to 40
Density	EN 323	kg / m^3	670 ± 50				
Bending strength	EN 310	N/mm^2	11	11	10,5	9,5	8,5
Modulus of elasticity in bend	EN 310	N/mm^2	1800	1600	1500	1350	1200
Internal bond	EN 319	N/mm^2	0,40	0,35	0,30	0,25	0,20
Surface soundness	EN 311	N/mm^2	0,8	0,8	0,8	0,8	0,8
Moisture resistance	EN 322	%	5 – 13				
Formaldehyde content	EN ISO 12460-5	≤ 4 mg / 100 g					

Production specification related to decorative melamine surface			
Resistance to scratching	EN 14323	Continuous scratch mark	≥ 1,5 N
Resistance to staining	EN 14323	Rating, grade	≥ 3 N
Resistance to cracking	EN 14323	Rating, grade	≥ 3 N

	Name	Position	Signature
Created by:	Petra Kolesarić	Head of laboratory	
Reviewed by:	Marko Vasić	Technologist	
Approved by:	Atanas Angelov	Plant Manager	