



PARAMETER INSPEKSI GENERAL SPF MDF STANDARD

No. **P A R 0 1 T Q A 0 0 4**

Tgl. Efektif :
08 Maret 2018

Disetujui oleh,
[Signature]
QMR

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Revisi : 4

PROPERTIES	PRODUCT TYPE	TEST METHODS	UNIT	THICKNESS										
				Super Thin			Thin			Thick			Super Thick	
				1,0 – 1,5	1,6 – 2,0	2,1 – 3,0	3,1 – 4,0	4,1 – 6,0	6,1 – 9,0	10,0 – 13,0	13,1 – 16,0	16,1 – 21,0	21,1 – 32,0	
Density	E2,E1,E0,P2,FR,HMR,	EN 323	Kg/M ³	825	825	800	780	760	740	690	680	660	640	
	HDF	EN 323	Kg/M ³	≥ 870	≥ 870	≥ 870	≥ 860	≥ 830	≥ 830	≥ 780	≥ 730	≥ 700	≥ 680	
Density Tolerance	E2,E1,E0,P2,FR,HMR,	EN 323	Kg/M ³	± 30										
Thickness Tolerance	E2,E1,E0,P2,FR,HMR, HDF	EN 324-1	Mm	± 0,15	± 0,15	± 0,15	± 0,15	± 0,20	± 0,20	± 0,20	± 0,20	± 0,30	± 0,30	
Moisture Content	E2,E1,E0,P2,FR,HMR, HDF	EN 322	%	8 ± 3										
Bending Strength (MOR)	E2,E1,E0,P2,FR,HMR	EN 310	N/mm ²	≥ 25	≥ 25	≥ 30	≥ 30	≥ 30	≥ 30	≥ 30	≥ 30	≥ 30	≥ 30	
	HDF					≥ 35	≥ 35	≥ 35	≥ 35	≥ 35	≥ 35	≥ 35	≥ 35	≥ 35
Bending Young's Modulus (MOE)	E2,E1,E0,P2,FR,HMR	EN 310	N/mm ²	≥ 2500	≥ 2500	≥ 3000	≥ 3000	≥ 2800	≥ 2800	≥ 2500	≥ 2500	≥ 2300	≥ 2300	
	HDF					≥ 3300	≥ 3300	≥ 3300	≥ 3300	≥ 3300	≥ 3300	≥ 3300	≥ 3300	≥ 3300
Internal Bond	E2,E1,E0,P2,FR,HMR	EN 319	N/mm ²	≥ 0,85	≥ 0,85	≥ 0,80	≥ 0,75	≥ 0,70	≥ 0,70	≥ 0,65	≥ 0,65	≥ 0,60	≥ 0,55	
	HDF					≥ 1,20	≥ 1,00	≥ 1,00	≥ 1,00	≥ 1,00	≥ 1,00	≥ 1,00	≥ 1,00	≥ 1,00
Wood Screw Holding Power	For Thickness 15mm Up	Face	EN 320	N	-	-	-	-	-	-	-	≥ 1050	≥ 1050	≥ 1050
		Edge										≥ 850	≥ 850	≥ 850
Thickness Swelling (after 24 h. immersion)	E2,E1,E0,P2,FR,	EN 317	%	≤ 45	≤ 45	≤ 45	≤ 35	≤ 25	≤ 25	≤ 17	≤ 17	≤ 17	≤ 13	
	HDF					≤ 17	≤ 15	≤ 13	≤ 13	≤ 10	≤ 10	≤ 10	≤ 10	
	HMR					≤ 20	≤ 20	≤ 17	≤ 17	≤ 15	≤ 13	≤ 10	≤ 9	≤ 8
Surface Absorbtion	E0, E1, E2, P2, FR, HMR, HDF	Mm	EN 112.307/1	≥ 150										
Formaldehyde Content	E2	mg/100 g	EN 120	8 < FC < 30										
	E1			< 8										
	SPF'S E0			< 5										
Formaldehyde Emission	CARB P2 & EPA TSCA Title VI	Ppm	ASTM E 1333 (CARB Correlation)	Thickness ≤ 8,0 mm					Thickness > 8,0 mm					
				≤ 0,13					≤ 0,11					