



PARAMETER INSPEKSI
JIS Products Standard
Basis RS – 25 G-MDF & S-MDF

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

Tgl. Efektif :
01 Nov 2014

Disetujui oleh

Halaman
1 dari 2

Manager TQA/QC

Revisi : 0

PROPERTIES	GLUE TYPE	METHODS	UNIT	9	2.5 ≤ t ≤ 4	4 < t ≤ 7	7 < t ≤ 12	12 < t ≤ 18	18 < Up
				S-MDF	G-MDF	G-MDF	G-MDF	G-MDF	G-MDF
Density	G-MDF ★ ★ ★ ★ , G-MDF ★ ★ ★ , G-MDF ★ ★ S-MDF ★ ★ ★ ★ , S-MDF ★ ★ ★ , S-MDF ★ ★	JIS A 5905	Kg/M ³	700 - 850	≥ 350				
Thickness Tolerance			mm	± 0.5	± 0.1	± 0.15	± 0.2	± 0.2	± 0.2
Single Board Thickness Tolerance			mm	≤ 0.20	≤ 0.20	≤ 0.20	≤ 0.20	≤ 0.20	≤ 0.20
Moisture Content			%	5 - 13	5 - 13	5 - 13	5 - 13	5 - 13	5 - 13
Bending Strength (MOR)			N/mm ²	≥ 25	≥ 25	≥ 25	≥ 25	≥ 25	≥ 25
Bending Young's Modulus (MOE)			N/mm ²	≥ 2000	≥ 2000	≥ 2000	≥ 2000	≥ 2000	≥ 2000
Internal Bond			N/mm ²	≥ 0.4	≥ 0.4	≥ 0.4	≥ 0.4	≥ 0.4	≥ 0.4
Nail Literal Resistance			kN	1.0	-	-	-	-	-
Tei (nails) head peneration			kN	1.0	-	-	-	-	-
Wood Screw Holding Power (For Thickness 15mm Up)			N	-	-	-	-	≥ 500	≥ 500
Bending Strength Under Wet Conditioning (For M Type Only)			N/mm ²	≥ 12.5	≥ 12.5	≥ 12.5	≥ 12.5	≥ 12.5	≥ 12.5
Swelling in thickness After Immersion In Water (For M Type Only)			%	≤ 12	≤ 17	≤ 17	≤ 12	≤ 12	≤ 10
Formaldehyde Emission				Average			Maximum		
TYPE	UF & MF ★ ★	JIS A 1460	mg/L	1.5			2.1		
	UF & MF ★ ★ ★			0.5			0.7		
	UF & MF ★ ★ ★ ★			0.3			0.4		



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Halaman
2 dari 2
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A. Classification Board

Class	Thickness	Internal Bonding	Density Board	MOR	MOE	Definition
	Control Limit	Min	Control Limit	Min	Min	
I	Ok	Ok	Ok	Ok	Ok	Total Test.
II	Salah satu dari item diatas yang not ok kecuali hanya Thickness masuk class II.					Total Test.
III	Lebih dari satu item diatas yang not ok kecuali Thickness & Density Board not ok masuk class III.					Tidak perlu total test (Grade B).

B. Appearance Quality

Item		Definition of Defects	
Dimension	Length	$\pm 2.0 \text{ mm/m}$	Not more than 2 mm / meter
	Width	$\pm 2.0 \text{ mm/m}$	Not more than 2 mm / meter
	Diagonal	$\pm 2 \text{ mm}$	Both diagonal differential does not exceed 2 mm
	Squareness Type A	$< 2.0 \text{ mm}$	Clearance between the square and board at the point of 1000 mm
	Squareness Type B	$< 3.0 \text{ mm}$	Clearance between the square and board at the point of 1000 mm
Side Quality	Delamination	None	Board which splits across the surface.
	Distinct Layer - 3 layers	None	Visible three weak layers board, and soft at the core layer
	Edge Damage	None	Edge with dented, broken or knocked marks
	Brittle Edge	None	Edge surface is fragile and easily drop-off like sand particle
	Corner Split	None	Corners which are blunt or delaminate
	Wavy Board	Not Visible	Board physically wavy across the length or width
	Warping	Not Visible	Board sag at the middle or bend upward at the middle
	Rainbow Pattern	Max $\leq 0.09 \text{ mm}$	Pattern on the side cause by saw blade
Surface Quality	Chatter Mark	One side	Even lines across the width of the board
	Line (one side only)	Max 1 line ; Width max 2 cm	Spontaneous lines across the length of the board
	Press Mark (one side only)	Max 1 spot / m ²	Pre-cure dot or lines (Depend on the Press belt dented spot)
	Rough Surface	None	Rough surface on the whole board or as patches
	Pre-cure Surface	One side	Surface which looks yellowish and rough
	Groove	One side	Deep depression line on surface
	Scratch	None	Abrasion line distributed evenly on surface
	Oil Stain (one side only)	$\Sigma \text{max } 3 \text{ spots/m}^2$	Marking or stain cause by oil, which unable to stick
	Water-stain (one side only)	$\Sigma \text{max } 3 \text{ spots/m}^2$; dia max 3 cm	Marking or stain cause by water, which looks darker
	Fiber Spot (one side only)	$\Sigma \text{max } 3 \text{ spots/m}^2$; dia max 3 cm	Fiber lump which easily scratch off by finger
Latex spot (one side only)	None	White or black color spot which looks like a rock.	