



PT. SUMATERA PRIMA FIBREBOARD
JIS Product standard basis RS-30 U-Type & M-Type Rev.6

PROPERTIES		GLUE TYPE	METHODS	UNIT	1.8 ≤ t ≤ 4	>4 < t ≤ 7	>7< t ≤12	12 < t ≤18	18 < Up
Density		UF ★ ★ ★ ★ , UF ★ ★ ★ , UF ★ ★ MF ★ ★ ★ ★ , MF ★ ★ ★ ★ , MF ★ ★ ★ ★ MF ★ ★ ★ ★ , MF ★ ★ ★ ★ MF ★ ★ ★ ★ , MF ★ ★ ★ ★	JIS A 5905	Kg/M ³	≥ 350				
Thickness Tolerance				mm	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
Moisture Content				%	13-May	13-May	13-May	13-May	13-May
Bending Strength (MOR)				N/mm ²	≥ 30	≥ 30	≥ 30	≥ 30	≥ 30
Bending Young's Modulus (MOE)				N/mm ²	≥ 2500	≥ 2500	≥ 2500	≥ 2500	≥ 2500
Internal Bond	Min			N/mm ²	≥ 0.5	≥ 0.5	≥ 0.5	≥ 0.5	≥ 0.5
Wood Screw Holding Power				N	-	-	-	≥500	≥500
Bending Strength Under Wet Conditioning (For M Type Only)				N/mm ²	≥ 15	≥ 15	≥ 15	≥ 15	≥ 15
Swelling In thickness After Immersion In Water (For M Type Only)				%	≤ 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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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)



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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
	Square ness	$< 2.0 \text{ mm}$	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	$\text{Max} \leq 0.09 \text{ mm}$	Pattern on the side cause by saw blade
Surface Quality	Chatter Mark	One side	Even lines across the width of the board
	Line (<i>one side only</i>)	Max 1 line ;	Spontaneous lines across the length of the board
		Width max 2 cm	
	Press Mark (<i>one side only</i>)	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 (<i>one side only</i>)	$\Sigma \text{max } 3 \text{ spots/m}^2$	Marking or stain cause by oil, which unable to stick
	Water-stain (<i>one side only</i>)	$\Sigma \text{max } 3 \text{ spots/m}^2 ;$	Marking or stain cause by water, which looks darker
		dia max 3 cm	
	Fiber Spot (<i>one side only</i>)	$\Sigma \text{max } 3 \text{ spots/m}^2 ;$	Fiber lump which easily scratch off by finger
		dia max 3 cm	
	Latex spot (<i>one side only</i>)	None	White or black color spot which looks like a rock