



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

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

Tgl. Efektif :
 10 January 2019

Disetujui oleh,

[Signature]
 Manager TQA/QC

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Revisi :2

PROPERTIES	GLUE TYPE	METHODS	UNIT	9 S-MDF	2.0 ≤ t ≤ 4 G-MDF	4 < t ≤ 7 G-MDF	7 < t ≤ 12 G-MDF	12 < t ≤ 18 G-MDF	18 < Up G-MDF
DENSITY	G-MDF **** G-MDF *** G-MDF ** S-MDF **** S-MDF ***	JIS A 5905	Kg/M3	700 - 850	≥ 350				
Thickness Tolerance			mm	± 0.5	± 0.10	± 0.15	± 0.20	± 0.20	± 0.20
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/mm2	≥ 25	≥ 25	≥ 25	≥ 25	≥ 25	≥ 25
Bending Young's Modulus (MOE)			N/mm2	≥ 2000	≥ 2000	≥ 2000	≥ 2000	≥ 2000	≥ 2000
Internal Bonding			N/mm2	≥ 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	-	-	-	-	-	-
Bending Strength Under Wet Conditioning (For M Type Only)			N/mm2	≥ 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				Average			Maximum		
Type	UF & MF ***	JIS A 1460	mg/L	0.5			0.7		
	UF & MF ****			0.3			0.4		



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Appearance Quality

ITEM		DEFINITION OF DEFECTS	
Dimension	Length	+ 2.0 mm	+ 2.0 mm per order size
	Width	+ 2.0 mm	+ 2.0 mm per order size
	Diagonal	+ 2.0 mm	Both diagonal differential does not exceed 3.0 mm
	Squareness Type A	≤ 2.0 mm	Clearance between the square and board at the point of 1000 mm
	Squareness Type B	≤ 3.0 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	None	Board physically wavy across the length or width
	Warping	None	Board sag at the middle or bend upward at the middle
	Rough Cutting	None	Damage saw at the edge
Surface Quality	Chatter Mark	None	Even lines across the width of the board
	Line	None	Spontaneous lines across the length of the board
	Rough Surface	None	Rough surface on the whole board or as patches
	Pre- Cure Surface	None	Surface which looks yellowish and rough
	Groove	None	Deep depression line on surface
	Scratch	None	Abrasion line distributed evenly on surface
	Oil Stain	None	Marking or stain cause by water, which unable to stick
	Water - Stain	None	Marking or stain cause by water, which looks darker
	Fiber Spot	None	Fibre Lump which easily scratch off by finger
	Latek	MLH	None
Rubber (One Side)		∑max 3 spots/m ² ; ∑max.dia.< 5 mm.	