



PARAMETER INSPEKSI
Medium Moisture Resistant (MMR)
Products Standard

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

Tgl. Efektif :
23 Juli 2019

Disetujui oleh,

Halaman

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QMR

Revisi : 3

PROPERTIES	METHODS	UNIT	3.0 < t ≤ 4.0	4.0 < t ≤ 6.0	6.0 < t ≤ 9.0	12.0 < t ≤ 19.0	19.0 < t ≤ 30.0	
Density	EN 323	Kg/M3	790 – 800	770 - 780	750 - 780	680 - 720	650 - 690	
Thickness Tolerance	EN 324-1	mm	±0.15	±0.15	±0.15	±0.20	±0.20	
Moisture Content	EN 322	%	8 ± 3					
Bending Strength (MOR)	EN 310	N/mm2	≥30	≥ 30	≥ 30	≥ 28	≥ 28	
Bending Young's Modulus (MOE)	EN 310	N/mm2	≥ 3000	≥ 3000	≥ 2800	≥ 2800	≥ 2500	
Internal Bonding	Min	EN 319	≥ 0.80	≥ 0.80	≥ 0.80	≥ 0.70	≥ 0.70	
Wood Screw Holding Power	For Thickness 15mm Up	Face	-	-	-	1050	1050	
		Edge	-	-	-	850	850	
Thickness Swelling (after 24 h. immersion)	EN 317	%	≤ 20	≤ 17		≤ 12		

Type Glue

UF ***	Formaldehyde Emission	JIS A 5905 : 2014	mg/l	≤ 0.7	
UF ****				≤ 0.4	
Phase 2		ASTM D 6007 : 2014	Ppm	Thickness ≤ 8.0mm	Thickness > 8.0 mm
				≤ 0.13	≤ 0.11
E1	Formaldehyde Content	BS EN ISO 12460-5 : 2015	mg/100g	≤ 8	
E2				8 < FC ≤ 30	
E0				≤ 5	
	Formaldehyde Content SPF Standard				



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A. Appearance Quality

Item		Definition of Defects	
Dimension	Length	±2.0mm/m	Not more than 2 mm / meter
	Width	±2.0mm/m	Not more than 2 mm / meter
	Diagonal	±5mm*	Both diagonal differential does not exceed 5 mm*
	Square nesse	< 2.0 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	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 ≤ 0.09mm	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 / m2	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)	Σmax3spots/m2	Marking or stain cause by oil, which unable to stick
	Water-stain (one side only)	Σmax3spots/m2; dia max 3 cm	Marking or stain cause by water, which looks darker
	Fiber Spot (one side only)	Σmax3spots/m2; dia max 3 cm	Fiber lump which easily scratch off by finger
Latex spot (one side only)	Σmax3spots/m2.	White or black color spot which looks like a rock.	
	Σmax.dia.<5mm.		
Colour	Green	For MMR	Indication
No Colour	Indication		