

Technical data sheet (2020)

Product: Melamine faced particleboard MF PB P2EN16516 Particleboard with decorative melamine foils coating



1. Product identification

Supporting substrate is three-layer particleboard PB P2 manufactured from specially selected wood chips and high quality synthetic resin. Particleboard, sanded on both sides, is covered with a decorative paper impregnated with melamine resin, and available in various finishes, including gloss, matt, lightly textured and wood grain.

The boards are manufactured acc. the EN 14322 standard, which specifies requirements for boards for interior use (especially for interior fitments, including furniture).

The boards are intended to be used mainly for the furniture industry and for interior finishing for use in dry conditions. 'Dry conditions' is characterised by a moisture content in the material corresponding to a temperature of 20°C and a relative humidity of the surrounding air only exceeding 65% for a few weeks per year. The boards are not suitable for use in humid conditions.

Boards are available in thickness range 8 - 38 mm.

Manufacturer identification:

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2. Technical production specification of MF PB boards

Production tolerances of MF PB boards acc. EN 14322

Property		Test method	Attribute / unit	Requirement
Dimensional tolerances	Thickness	EN 14323, EN 324-1	Thickness ≤ 20 mm, class 1 a 2	± 0,3 mm
			Thickness ≤ 20 mm; class 3A, 3B, 4, gloss decors, multilayer facing	+ 0,5 mm - 0,3 mm
			Thickness > 20 mm	± 0,5 mm
Length and width	EN 14323, EN 324-1	Standard delivered sizes	± 5 mm	
		Pre-cuts panels	± 2,5 mm	
Deviation from flatness ^a (deflection in width or length)	EN 14323	Thickness < 15 mm	-	
		Thickness ≥ 15 mm	≤ 2,0 mm ^{b)}	
Edge damage	EN 14323	Standard delivered sizes	≤ 10	
		Pre-cuts panels	≤ 3	
Surface defects ^{c)}	EN 14323	Points (sum up size of defects)	≤ 2 mm ² /m ² ^{d)}	
		Length (sum up length)	≤ 20 mm/m ² ^{d)}	

a) Numerous factors, including changes in temperature and relative humidity in storage and fabrication areas at building sites, may cause panels to bow and twist irreversibly. This requirement is therefore only applicable at the time of delivery.

b) Valid for balanced surfaces only (e.g. equally weighted decorative papers both sides).

c) It is related to standard delivered sizes as whole. Surface defects are larger than 0.8 mm² and those that can be identified when the surface texture is viewed from a distance 0.7 m and at an angle about of 45°.

d) For standard panel size 2800mm x 2070mm the permissible total errors are calculated as follows: 2,8x2,07x 2mm²/m² = 11,6 mm² (points) and 116mm (length). These defects are permitted: 1x 11,6mm² or 2x 5,8mm² or 3x 3,8mm² etc. Similarly length errors are permitted: 1x 116mm or 2x 58mm or 3x 3,8mm² etc.

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Production specification related to core particleboard EN 312, type P2			
Bending strength	EN 310	N/mm ²	≥ 8,5
Modulus of elasticity in bending	EN 310	N/mm ²	≥ 1200
Internal bond	EN 319	N/mm ²	≥ 0,20
Surface soundness	EN 311	N/mm ²	≥ 0,8
Density tolerance	EN 323	kg/m ³	± 10 %
Moisture content	EN 322	%	2 - 12 %
Formaldehyde content	EN ISO 12460-5	mg/100 g	Class E1 (≤ 8 mg/100 g)
Production specification related to decorative melamine surface			
Resistance to scratching	EN 14323	Continuous scratch mark	≥ 1,5 N
Resistance to staining	EN 14323	Rating, grade	≥ 3
Resistance to cracking	EN 14323	Rating, grade	≥ 3
Resistance to abrasion ^{e)}	EN 14323, EN 438-2.10	IP, number of revolutions	Class 1: < 50 Class 2: ≥ 50 Class 3A: ≥ 150 Class 3B: ≥ 250 Class 4: ≥ 350

e) Depending on the number and type of surface layers used, different classes can be achieved. Unless otherwise stated, Class 1 applies.

3. Colour matching and surface texture

Due to the influence of unavoidable differences in the decorative paper and the used raw chipboard, it is necessary to take into account the possible occurrence of subtle colour deviations during processing. Therefore, it is recommended that for the final products or elements to be subsequently used side by side, it is preferable to use MF PB boards originating from one production batch.

The compatibility of MF PB boards with the reference sample should be agreed in colour and structure before processing.

4. Technical properties and hygienic requirements

Technical properties of MF PB P2EN16516		
Property	Test method, directives	Value
Reaction to fire	EN 13501-1	Class D,s2-d0
Formaldehyde emissions	EN ISO 12460-3	Class E1 (<3,5 mg/m ² .h)
	EN 16516	< 0,1 ppm (0,124 mg/m ³) ^{f)}
	EN 717-1	< 0,05 ppm (0,062 mg/m ³) ^{f)}

f) Product meets the limit determined by the German Chemical Act ChemVerbotsV.

5. Building-physical properties

Mechanical-physical and other properties needed for board use as non-loadbearing board in construction are determined in Declaration of performance (DoP) no. P2-CPR-2013-07-01 issued for raw particleboards P2.

6. Instruction for transport and storage

Transport

- By road trucks. Canvas covers are used to protect the goods against climatic influence and fixing device (courting) are used to disable the movement and consequent damage of the goods inside the truck.
- Railway carriages intended for this type of transport (closed and secured against climatic influence). In the carriages there are movable obstruction and fixing device (courting) which protects the goods against the damage.

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Storage

MF PB boards should be stored on flat surface, in dry and ventilated areas with optimal relative humidity 40-65% of ambient air. The individual board packing must be interleaved, the bottom package should be placed at least 10 cm above the floor.

7. Instruction for handling and processing

When loading and unloading the pallets/boards must not be moved one after the other for reason of possible damaging of MF PB surfaces or edges..

Removing individual boards from packing is only possible vertically by lifting the board. Any moving or pulling of single boards across each other (over the edges etc.) must be avoided.

Special attention must be paid to cleanness of board surfaces during board transfer. Any mechanical particles between boards can lead to irreversible damage of board surfaces.

8. General instruction for assembly and installation of furniture made of MF PB boards

It is assumed that the furniture elements made from MF PB boards will have during time of use the moisture content 7-10% by common interior temperature. Furniture and other interior fitments made of MF PB P2EN16516 boards must not be installed in damp new houses and other building where relative humidity is higher than 70%.

9. Protective equipment

Protective means fitting to the processing method and technical equipment of the processing company (protective goggles, respirators, gloves, safety shoes).

10. Disposal of waste generated during MF PB processing

With regards to general obligations imposed by the Act No.185/2001 Coll. (Czech law), on waste, the priority is to search for the material reuse of the respective waste in case that it was not possible to prevent its generation. In this respect those types of waste can be regarded as waste which complies with the requirements stipulated by Kronospan CR spol. s r. o. Jihlava concerning input raw material.

11. Related documents

- Cleaning and maintenance instructions