



PARAMETER INSPEKSI GENERAL SPF MDF STANDARD

No.	P	A	R	-	0	1	T	Q	A	-	0	0	4	
Tgl. Efektif : 03 January 2022		Disetujui oleh, <i>[Signature]</i> QMR								Halaman 1 dari 1 Revisi : 10				

PROPERTIES	PRODUCT TYPE	TEST METHODS	UNIT	THICKNESS										
				Super Thin		Thin				Thick		Super Thick		
				Unsanded		Sanded / Unsanded								
				1,0 ≤ t ≤ 1,5	1,5 < t < 2,0	2,0 ≤ t ≤ 3,0	3,0 < t ≤ 4,0	4,0 < t ≤ 6,0	6,0 < t ≤ 9,0	9,0 < t ≤ 12,0	12,0 < t ≤ 16,0	16,0 < t ≤ 19,0	19,0 < t ≤ 32,0	
Density	MDF	EN 323	Kg/M3	≥ 850	≥ 830	800	780	760	740	690	680	660	640	
	HMR					800 – 820	770 – 780	750 – 780	730 – 770	680 – 720	650 – 690			
	HDF	EN 323	Kg/M3			≥ 880	≥ 870	≥ 860	≥ 850	820 ± 20	700 ± 20			
Density Tolerance	MDF	EN 323	Kg/M3	± 30										
Thickness Tolerance	MDF, HMR	EN 324-1	Mm	± 0,20	± 0,15	± 0,15	± 0,15	± 0,15	± 0,15	± 0,20	± 0,20	± 0,20	± 0,30	
	HDF			-0,1 / + 0,15										
Moisture Content	MDF, HMR, HDF	EN 322	%	8 ± 3		8 ± 3								
Bending Strength (MOR)	MDF	EN 310	N/mm2	≥ 25	≥ 25	≥ 25	≥ 25	≥ 30	≥ 30	≥ 30	≥ 30	≥ 30	≥ 30	
	HMR					≥ 25	≥ 25	≥ 30	≥ 30	≥ 30	≥ 30	≥ 30	≥ 30	
	HDF							≥ 35				≥ 40		
Bending Young's Modulus (MOE)	MDF	EN 310	N/mm2	≥ 3000	≥ 3000	≥ 2500	≥ 2500	≥ 2800	≥ 2800	≥ 2500	≥ 2500	≥ 2300	≥ 2300	
	HMR					≥ 2500	≥ 2500	≥ 2800	≥ 2800	≥ 2500	≥ 2500	≥ 2300	≥ 2300	
	HDF							≥ 3000						
Internal Bond	MDF	EN 319	N/mm2	≥ 0,85	≥ 0,85	≥ 0,80	≥ 0,75	≥ 0,70	≥ 0,70	≥ 0,65	≥ 0,65	≥ 0,60	≥ 0,55	
	HMR					≥ 1,0		≥ 0,80						≥ 0,70
	HDF					≥ 1,20	≥ 1,20	≥ 1,00	≥ 1,00	≥ 1,00	≥ 1,00	≥ 1,00	≥ 1,00	≥ 1,00
Wood Screw Holding Power	For Thickness 15mm Up	Face	EN 320	N									≥ 1050	
		Edge											≥ 850	
		Face			HDF									≥ 2000
		Edge												≥ 1500
Thickness Swelling (after 24 h. immersion)	MDF	EN 317	%	≤ 45	≤ 45	≤ 45	≤ 35	≤ 25	≤ 25	≤ 17	≤ 17	≤ 17	≤ 13	
	HMR					≤ 17		≤ 12	≤ 10	≤ 7		≤ 5		
	HDF					≤ 17	≤ 15	≤ 14	≤ 13	≤ 12	≤ 11	≤ 11	≤ 10	
Surface Absorbtion	MDF, HMR, HDF	Mm	EN 112.307/1	≥ 150										
TYPE GLUE														
Formaldehyde Content	E2	mg/100 g	BS EN ISO 12460-5 : 2015	8 < FC ≤ 30										
	E1			≤ 8										
	SPF'S EO			≤ 5										
Formaldehyde Emission	CARB P2 & EPA T SCA Title VI	Ppm	ASTM D 6007 : 2014	Thickness ≤ 8,0 mm					Thickness > 8,0 mm					
				≤ 0,13					≤ 0,11					



ISO 9001 : 2015

JQA
JQID06001

TPC6/CARB-ATCM/M005-MDF002
TPC6/EPA-TSCA/M005-MDF002

BRIK-VLK-0062



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No.	P A R - 0 1	T O A - 0 0 4	Disetujui oleh,	Halaman
Tgl. Efektif : 03 January 2022	 QMR		1 dari 2	Revisi : 10

Item	Definition of Defects		
Dimension	Length	± 2.0 mm / m	Not more than 2 mm / meter
	Width	± 2.0 mm / m	Not more than 2 mm / meter
	Diagonal	± 2.0 mm / m	Both diagonal differential does not exceed 2.0 mm / meter
	Square ness	≤ 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 denfed, 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	Not Visible	Board sag at the middle or bend upward at the middle
	Rainbow Pattern	Max ≤ 0.09 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 / m2	Pre-cure dot or lines (Depend on the Press belt dented spot.)
	Rough Surface (MDF Sanded)	None	Rough surface on the whole board or as patches
	Rough Surface (MDF Unsanded)	One Side	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)	max 3 spots/m2	Marking or stain cause by oil, which unable to stick
	Water-stain (one side only)	max 3 spots/m2 ; dia max 3 cm	Marking or stain cause by water, which looks darker
	Fiber Spot (one side only)	max 3 spots/m2 ; dia max 3 cm	Fiber lump which easily scratch off by finger
	Latex spot (one side only)	max 3 spots/m2.; max. dia. < 5 mm.	White or black color spot which looks like a rock.
	MLH	None Latex Spot	
Colour	Red	For FR	
	Green	For HMR	



ISO 9001 : 2005

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