



**PARAMETER INSPEKSI**  
**Flame Retardant ( FR )**  
**Products Standard**

No.	P A R - 0 1 - T Q A - 0 0 4
Tgl. Efektif :	Disetujui oleh, <i>[Signature]</i> Q.M.R.
29 Dec 2020	Halaman 1 dari 2
	Revisi : 5

PROPERTIES	METHODS	UNIT	Thickness (mm)								
			2.5 < t ≤ 3.0	3.0 < t ≤ 4.0	4.0 < t ≤ 6.0	6.0 < t ≤ 9.0	9.0 < t ≤ 13.0	13.0 < t ≤ 16.0	16.0 < t ≤ 21.0	25.00	27.00
Density	EN 323	Kg/M <sup>3</sup>	820	800	760	750	720	700	680	630	610
Density Tolerance	EN 323	Kg/M <sup>3</sup>	-10,+20								
Thickness Tolerance	EN 324-1	mm	± 0.15			± 0.20			± 0.25		
Moisture Content	EN 322	%	8 ± 3								
Bending Strength (MOR)	EN 310	N/mm <sup>2</sup>	≥ 30				≥ 28				
Bending Young's Modulus (MOE)	EN 310	N/mm <sup>2</sup>	≥ 3000			≥ 2800			≥ 2500		
Internal Bonding	EN 319	N/mm <sup>2</sup>	≥ 0.80	≥ 0.75	≥ 0.70		≥ 0.65	≥ 0.60			
Wood Screw Holding Power	EN 320	N	For Thickness 15mm Up	Face	-	-	-	-	-	1050	
			Edge	-	-	-	-	-	850		
Thickness Swelling (after 24 h. immersion)	EN 317	%	≤ 45	≤ 35	≤ 25		≤ 17				
<b>Type Glue</b>											
Phase 2	Formaldehyde Emission	ASTM D 6007 : 2014 Thickness ≤ 8mm	Ppm	≤ 0.13							
		ASTM D 6007 : 2014 Thickness ≥ 8mm		≤ 0.11							
E1	Formaldehyde Content	EN 120	mg/100g	≤ 8							
E2				8 < PV ≤ 30							
E0	Formaldehyde Content SPF Standard	EN 120	mg/100g	≤ 5							



**PARAMETER INSPEKSI  
Flame Retardant ( FR )  
Products Standard**

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

Tgl. Efektif :  
29 Dec 2020

Disetujui oleh,

*[Signature]*  
QMR

Halaman  
2 dari 2  
Revisi : 5

**A. Appearance Quality**

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	± 1.5 mm / m	Both diagonal differential does not exceed 1.5 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 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	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 / m <sup>2</sup>	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 )	Σmax 3 spots/m <sup>2</sup>	Marking or stain cause by oil, which unable to stick
	Water-stain ( one side only )	Σmax 3 spots/m <sup>2</sup> ; dia max 3 cm	Marking or stain cause by water, which looks darker
	Fiber Spot ( one side only )	Σmax 3 spots/m <sup>2</sup> ; dia max 3 cm	Fiber lump which easily scratch off by finger
Latex spot ( one side only )	Σmax 3 spots/m <sup>2</sup> ; Σmax.dia.< 5 mm.	White or black color spot which looks like a rock.	
Colour	Red	For FR	