Physical and Mechanical Properties of Standard Grade Rubberwood MDF

Board Property	Test Method	Unit	Range of Nominal Thickness (mm)					
			3.0 - 4.0	> 4.0 - 6.0	> 6.0 - 9.0	> 9.0 - 12.0	> 12.0 - 19.0	> 19.0 - 25.0
Density	EN 323	kg/m^3	800 - 830	760 - 800	740 - 780	720 - 760	690 - 730	660 - 700
Board Moisture	EN 322	%	4 - 9	4 - 9	4 - 9	4 - 9	4 - 9	4 - 9
Modulus of Rupture	EN 310	N/mm^2	35	35	32	30	28	25
Internal Bond	EN 319	N/mm^2	0.75	0.75	0.70	0.70	0.65	0.60
Screw Holding (Face)*	EN 320	N	-	-	-	-	1050	1000
Screw Holding (Edge)*	EN 320	N	-	-	-	-	850	700
Thickness Swelling**	EN 317	%	35	30	17	15	12	10
Thickness tolerance	EN 324-1	mm	+/- 0.20					
Dimension (length/width) tolerance	EN 324-1		+/- 2 mm/m; maximum +/- 5 mm					
Squareness	EN 324-2	mm/m	2					
Edge straightness	EN 324-2	mm/m	1.5					
Minor stains, fibre marks, scratch lines			Free on one side					
Latex spots			Not more than 5 spots					
Size of latex spots			Not more than 6 mm					

*Screw holding only for thickness 15 mm and above. **24-hour immersion in 20 (+/-1) degrees Celsius water.

Physical and Mechanical Properties of Standard Grade Mixed Tropical Hardwood MDF

Board Property	Test Method	Unit	Range of Nominal Thickness (mm)					
			3.0 - 4.0	> 4.0 - 6.0	> 6.0 - 9.0	> 9.0 - 12.0	> 12.0 - 19.0	> 19.0 - 25.0
Density	EN 323	kg/m^3	820 - 860	810 - 850	790 - 830	770 - 810	740 - 780	720 - 760
Board Moisture	EN 322	%	4 - 9	4 - 9	4 - 9	4 - 9	4 - 9	4 - 9
Modulus of Rupture	EN 310	N/mm^2	35	35	32	30	28	25
Internal Bond	EN 319	N/mm^2	0.75	0.75	0.70	0.70	0.65	0.60
Screw Holding (Face)*	EN 320	N	-	-	-	-	1050	1000
Screw Holding (Edge)*	EN 320	N	-	-	-	-	850	700
Thickness Swelling**	EN 317	%	35	30	17	15	12	10
Thickness tolerance	EN 324-1	mm	+/- 0.20					
Dimension (length/width) tolerance	EN 324-1		+/- 2 mm/m; maximum +/- 5 mm					
Squareness	EN 324-2	mm/m	2					
Edge straightness	EN 324-2	mm/m	1.5					
Minor stains, fibre marks, scratch lines			Free on one side					

*Screw holding only for thickness 15 mm and above. **24-hour immersion in 20 (+/-1) degrees Celsius water.

Formaldehyde Emission

Type of Test	Test Method	Unit	Classification
Perforator Method	EN 120	mg/100g o.d.	E1 - ≤ 8.0 E2 - ≤ 30.0 E3 - > 30.0
Small Chamber (CARB)	ASTM D 6007	ppm	≤ 0.11 (CARB Phase 2)

ROBIN

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