

		Project	MELAMINE FACED CHIPBOARD		Doc	18.12.22.01_1		
			MF - PB	TDS - Technical Data Sheet	Date	2025-03-25		
Rev.	Data	Description	Distribution		Date	Issued	Controlled	Approved
H	2021-06-08	Update	Team, customers		2021-06-08	DBA	MQ	MQ
I	2025-03-07	Update	Team, customers		2025-03-25	DC	MCR	MCR
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TECHNICAL PROPERTIES				P2	P3	Rev.		
				8mm - 40mm	8mm - 40mm			
Physical		Test method	Unit	Value	Value	A		
1	Tolerances on nominal dimensions		EN 14323	mm		E		
	<i>Thickness (detected in the center of the board)</i>					-0,2; +0,6	-0,2; +0,6	E
	<i>Lenght</i>					± 5	± 5	
	<i>Widht</i>					± 5	± 5	
2	Flatness	<i>Only for balanced surfaces ≥ 18mm</i>	EN 14323	mm/m	≤ 2	≤ 2	A	
3	Edge damage		EN 14323	mm	10	10	A	
4	Surface defects	<i>Points</i>	EN 14323	mm ² /m ²	≤ 2	≤ 2	A	
		<i>Lenght</i>		mm/m ²	≤ 20	≤ 20		
5	Resistance to scratching		EN 14323	N	≥ 1,5	≥ 1,5	A	
6	Resistance to staining		EN 9300	Rating	≥ 3	≥ 3	I	
7	Resistance to cracking		EN 14323	Rating	≥ 3	≥ 3	A	
8	Cold liquids		EN 12720	Rating	≥ 3	≥ 3	E	
9	Dry heat		EN 12722	Rating	≥ 3	≥ 3	E	
10	Color matching		EN 14323	Rating	≥ R 4	≥ R 4	G	
	<i>Valid only for uni-color, with the same raw board type and the same texture</i>		Colorimeter	ΔE	≤ 0,70	≤ 0,70		
11	Formaldehyde release		EN 12460-3	mgHCHO/(m ² h)	≤ 1.75	≤ 1.75	I	

N.B. Certificates as FSC & PEFC and Formaldehyde release class do not change the values indicated above.

MECHANICAL PROPERTIES				Production specification related to core particleboard EN 312, type P2					Rev.
		Test method	Unit	> 8 to 13 mm	> 13 to 20 mm	> 20 to 25 mm	> 25 to 32 mm	> 32 to 40 mm	
1	Internal Bond	EN 319	N/mm ²	0.40	0.35	0.30	0.25	0.20	I
2	Surface soundness	EN 311	N/mm ²	0.8					I
3	Swelling 24h	EN 317	%	/					I
4	Modulus of elasticity "	EN 310	N/mm ²	1800	1600	1500	1350	1200	I
5	Bending strength	EN 310	N/mm ²	11	11	10.5	9.5	8.5	I
MECHANICAL PROPERTIES				Production specification related to core particleboard EN 312, type P3					Rev.
		Test method	Unit	> 8 to 13 mm	> 13 to 20 mm	> 20 to 25 mm	> 25 to 32 mm	> 32 to 40 mm	
1	Internal Bond	EN 319	N/mm ²	0.45	0.45	0.40	0.35	0.25	I
2	Surface soundness	EN 311	N/mm ²	/					I
3	Swelling 24h	EN 317	%	17	14	13	13	12	I
4	Modulus of elasticity "	EN 310	N/mm ²	2050	1950	1850	1700	1550	I
5	Bending strength	EN 310	N/mm ²	15	14	12	11	9	I

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