

Technical data sheet

HPL bonded MDF.H E1

Technical characteristics	Unit	Thickness [mm]					Standard	
		>6+9	>9+12	>12+19	>19+30	>30+45		
General requirements								
1	Density	kg/m ³ ± 7%	740	720	710		EN 323	
2	Tolerance of thickness	mm	± 0.1		± 0.15		EN 438-2.5	
3	Tolerance on length and width	mm/m	maximum + 5 mm				EN 438-2.6	
4	Squareness tolerances	mm/m	≤ 1,5				EN 438-2.8	
5	Edge straightness tolerance	mm/m	≤ 1,5				EN 438-2.7	
6	Flatness	mm	≤ 60				EN 438-2.9	
General requirements – mechanical properties								
7	Swelling in thickness 24h	%	≤ 12	≤ 10	≤ 8	≤ 7	EN 317 EN 622-5	
8	Bending strength	N/mm ²	≥ 27	≥ 26	≥ 24	≥ 22	≥ 17	EN 310 EN 622-5
9	Modulus of elasticity in bending	N/mm ²	≥2700	≥2500	≥2400	≥2300	≥2200	EN 310 EN 622-5
10	Internal bond	N/mm ²	≥ 0.80		≥ 0.75		≥ 0.70	EN 319 EN 622-5
11	Formaldehyde release – E1	mg/m ² h	≤ 3.5				EN 12460-3 EN 622-1	
12	Moisture content	%	5 ± 13				EN 322 EN 622-1	
General requirements – moisture resistance								
Option 1								
13	Internal bond after cyclic test	N/mm ²	≥ 0.30	≥ 0.25	≥ 0.20	≥ 0.15	≥ 0.10	EN 319 EN 622-5
14	Swelling in thickness after cyclic test – 24h	%	≤ 19	≤ 16	≤ 15			EN 317 EN 622-5

Option 2						
15	Internal bond after boil test	N/mm ²	≥ 0.15	≥ 0.12	≥ 0.10	EN 1087-1 EN 622--5
Technical characteristics		Unit	Value			Standard
General requirements – Optical properties						
16	Resistance to surface abrasion	rpm	≥ 150			EN 438-2.10
17	Resistance to impact with large diameter ball	Drop height [mm]	≥ 800			EN 438-2.21
18	Scratch resistance	grade	Smooth finishes ≥ 2 Texture finishes ≥ 3			EN 438-2.25
19	Resistance to dry heat (160°C)	grade	Smooth finishes ≥ 3 Texture finishes ≥ 4			EN 438-2.16
20	Resistance to wet heat (85°C)	grade	Smooth finishes ≥ 3 Texture finishes ≥ 4			EN 438-2.18
21	Resistance to staining	grade	Smooth finishes ≥ 5 Texture finishes ≥ 5			EN 438-2.26



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