



LACQUERED PAINT BOARD

TECHNICAL DATA SHEET

MDF ST E1 BOARD ACCORDING TO EN 622 TYPE 5

DIMENSIONAL TOLERANCES

	PROPERTY	VALUE	STANDARD
	Length & width	± 2 mm.	EN 324-1
	Thickness	± 0,3 mm.	EN 324-1
	Squaring	2 mm.	EN 324-2

SURFACE PROPERTIES

	PROPERTY	Thickness (mm)
		16-18
	Density (kg/m ³)	770 ± 30
	Tensile strength (N/mm ²) – min.	1,00
	Swelling 24h (%) – min.	12%
	Flexural strength (N/mm ²) – min.	20
	Elastic modulus (N/mm ²) – min.	2200
	Residual humidity (%) – range	4 - 11%
	Silica content (%) – max.	0,05%
	Formaldehyde content E1 (mg/100g) – max.	8 mg.
	Fire performance (class)	D-s2, d0

PROPERTY



Stain resistance

Grade 5



Resistance to cold liquids

Grade 5



Crosscut test (adherence)

1



Crack resistance

Grade 5



Cold check (40 cycles 1 hour, a 60° C, 1h a -20° C, 15 min. room temp.)

No damage



Light fastness

Conforming



Dry Heat Resistance

Grade 5



Moist heat resistance

Grade 5



Scratch resistance

Grade 5
(6±2N)



Abrasion resistance

Cl. 2 (200/225)



Resistance to water steam

Grade 4



Resistance to impact stress (large diameter steel ball)

110 cm



Measures tolerance (Processed edge pieces)

± 0,5 mm



Edge Banding (Processed edge pieces)

Conforming



Warping tolerance

2 mm / 1 m



Plain colour tolerance between

$\Delta E \leq 0,70$



Gloss

90 ± 5 GU

Resistance to dry heat				
	DIN 68861-7 / DIN EN 12722	7C	100	°C
		7B *5)	140	°C
Resistance to wet heat				
	DIN 68861-8 / DIN EN 12721	8B	70	°C
		8A *5)	100	°C
Abrasion resistance				
	DIN 68861-2	2B	> 350 to ≤ 650	WR
Light fastness				
	EN 15187		Blue scale ≥6 Grey scale >4	
Wet climate resistance *6)				
(Climate 40 ± 2 ° C; relative humidity 85 ± 5%; duration 14 days)	AMK-MB-005, module 2		No gap forming or edge breaking	
Alternating climate resistance *6)				
(10 cycles: 1h Climate -20 ± 2 ° C; 3h Climate 20 ± 2 ° C / humidity 85 ± 5%; 3h Climate 60 ± 2 ° C / humidity 55 ± 5%)	AMK-MB-005, module 3		No surface cracking, no discolouration, no gap forming or edge breaking	
Surface defects according to AMK-MB- 009				

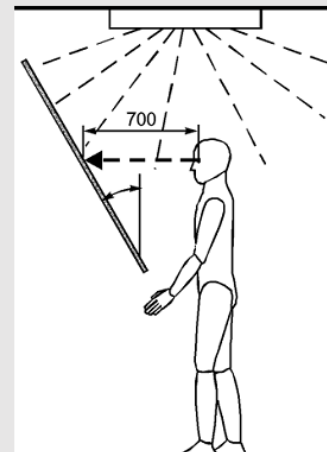
On an even surface, defects must not be apparent at a distance of 0.7 m. Where surfaces without any defects cannot be realised, small flaws and irregularities in the surface are admissible.

Surface defects are only those defects, which are greater than 1.0 mm² and are recognised

when examining the surface at a distance of 0.7 m and an angle of view of about 30°. Maximum allowed is 1 defect/m².

The following framework conditions apply:

- Viewing distance: 700 mm
- Lighting intensity: 1000 – 2000 lx
- Inclination angle: 30° to the vertical
- Type of light (daylight, colour temperature) D 65: 6500 K
- Viewing duration: max. 20 seconds



*1) upon delivery

*2) formaldehyde content: According to the Regulation of Chemical Interdiction of October 1993 in connection with the DiBt Directive concerning the classification and monitoring of wood-based material boards with regard to formaldehyde emissions of June 1994, the Perforator threshold (photometric) of uncoated chipboard may not exceed 8 mg HCHO/100g dry board for a material moisture of 6.5%. The moving six-monthly average is max. 6.5 mg HCHO/100g dry board. Perforator value according to DIN EN 120 as sliding six-monthly average.

*2b) Examination in accordance with American test chamber. According to CARB (California Air Resources Board) requirements Table 1 § 93120.2 Phase 2 is fulfilled (≤0.11 ppm according to ASTM 1333 E).

*3) relative to the nominal value

*4) only with balanced construction of surfaces

*5) with gloss surfaces slight gloss changes are permitted

*6) refers to the surface coating



SHOWROOM:IKITELLI OSB MH HURRIYET BULV.DEPARKO PLAZA 1/2C 34439 BASAKSEHIR ISTANBUL TURKEY

FACTORY:IKITELLI OSB MH HURRIYET BULV. DEPARCO S.S 1/38 B 201 -B 301 34439 BASAKSEHIR ISTANBUL TURKEY