

		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
L	2025-11-21	Update	Team, customers		2025-11-21	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	+ 0,3 ; - 0.2 without barrier / + 0,5 ; - 0.2 with barrier	+ 0,3 ; - 0.2 without barrier / + 0,5 ; - 0.2 with barrier	E
	<i>Thickness</i> (detected in the center of the board)						L
	<i>Lenght</i>						
	<i>Widht</i>						
2	Flatness	<i>Only for balanced surfaces</i> ≥ 18mm	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

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	0,80					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