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## Master Data Sheet Melamine Faced MDF 0004/0004 (grundier foil)

	<i>Specific Value</i>	<i>Standard</i>	<i>Unit</i>	<i>Thickness mm</i>		
				<i>12</i>	<i>&gt;12-19</i>	<i>&gt;19-30</i>
<b>General requirements for base plate (type MDF)</b>	Raw Density	EN 323	[kg/m <sup>3</sup> ]	780±20		
	Internal Bond	EN 319	[N/mm <sup>2</sup> ]	≥0,60	≥0,55	
	Surface Soundness	EN 311	[N/mm <sup>2</sup> ]	≥1,2		
	Bending Strength	EN 310	[N/mm <sup>2</sup> ]	≥22	≥20	≥18
	Bending E-Module	EN 310	[N/mm <sup>2</sup> ]	≥2500	≥2200	≥2100
	Swelling 24h	EN 317	[%]	≤15	≤12	≤10
	Perforator E-1	EN 120	[mg/100g]	≤8		
	Moisture Content	EN 332	[%]	5±2		
	Sand Content	ISO 3340	[%]	≤0,05		

The technical requirements are not changed in the production of FSC/PEFC plate

<i>2-sided melamine faced MDF board with purpose for further treatment</i>						
<b>General Requirements MFB</b>	Tolerance on nominal dimensions: - thickness relative to nominal value, - thickness within the board	EN 14323	mm	± 0,3		
	Length&width	EN 14323	mm	± 5		
	Flatness	EN 14323	mm/m	≤ 2 (only for balanced surfaces)		
	Edge damage	EN 14323	mm	≤ 10		
	Formaldehyde release	EN 717-1	mg/m <sup>3</sup>	≤ 0,124		
		EN 717-2	mg/m <sup>2</sup>	≤ 3,5		

update: September 2015