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Technicals Specifications (2024-25, Initial Release)

Standard Grade Medium Density Fibreboard

Mechanical Properties		Test Method	Unit	Range of thickness (mm)					
				≥ 2.5 - 4	≥ 4 - 6	≥ 6 - 9	≥ 9 - 12	≥ 15 - 18	25
Tolerance of Dimension	Thickness	BS EN 324-1	mm	± 0.3					
	Length & Width	BS EN 324-1	mm	+ 5mm (width) & + 5mm (length) for nett sized panel					
Squareness		BS EN 324-2	mm/m	< 1.5					
Squareness (diagonal)			mm	< 5					
Average density		BS EN 323	kg/m3	800 - 860	780 - 840	760 - 800	720 - 760	700 - 740	650 - 690
Board Moisture		BS EN 322	%	min 5 - max 8					
Modulus of Rupture		BS EN 310	N/mm2 (Avg)	23	23	23	22	20	18
Modulus of elasticity in bending		BS EN 310	N/mm2 (Avg)	NA	2700	2700	2500	2200	2100
Internal bond (dry)		BS EN 319	N/mm2 (Avg)	0.65	0.65	0.65	0.6	0.55	0.55
Screw Retaining Force	Face	BS EN 320	N (Avg)	NA	NA	NA	NA	1500	1500
	Edge	BS EN 320		NA	NA	NA	NA	1250	1250
Thickness Swelling (24 hour)		BS EN 317	% (max)	35	30	17	15	12	10
Formaldehyde Emission									
Class I (E1)		EN 120	mg/100g	≤ 8.0					
Class 2 (E2)		EN 120	mg/100g	≥ 8.0 to 30					
CARB EPA Title VI		ASTM D 6007	ppm	≤ 0.13			≥ 0.11		

HDF HMR V313

Property	Test Method	Unit	Range of thickness (mm)			
			≥ 8 to 10	≥ 10 to 15	≥ 15 to 19	≥ 19 to 25
Target Density		KG/m3	825+	825+	825+	825+
Bending Strength	EN 310	N/mm2	35	35	35	35
Modulus of Elasticity	EN 310	N/mm2	3200	3100	3000	2700
Internal Bond	EN 319	N/mm2	0.8	0.8	0.75	0.75
Thickness Swelling 2 hrs	EN 317	%	4	4	4	4
Thickness Swelling 24 hrs	EN 317	%	7	7	7	7
Thickness swelling after cyclic testing	EN 317	%	19	16	15	15
	EN 321					
Internal bond after cyclic testing	EN 319	N/mm2	0.3	0.25	0.2	0.2
	EN 321					
Water Absorption 2 hrs	S 2380 PART 1	%	6	6	6	6
Water Absorption 24 hrs	S 2380 PART 1	%	12	12	12	12

Standard P2 Grade Chipboard

Mechanical Properties		Test Method	Unit	Range of thickness (mm)			
				≥ 8 - 9	≥ 9 - 12	≥ 15 - 18	25
Tolerance of Dimension	Thickness	BS EN 324-1	mm	± 0.3			
	Length & Width	BS EN 324-1	mm	± 5.0			
Squareness		BS EN 324-2	mm/m	2			
Average density		BS EN 323	kg/m3	670-720	650-700	640-690	620-660
Board Moisture		BS EN 322	%	5 to 13			
Modulus of Rupture		BS EN 310	N/mm2 (Avg)	11	11	11	10.5
Modulus of elasticity in bending		BS EN 310	N/mm2 (Avg)	1800	1800	1600	1500
Internal bond (dry)		BS EN 319	N/mm2 (Avg)	0.4	0.4	0.35	0.3
Screw Retaining Force	Face	BS EN 320	N (Avg)	NA	NA	1250	1312
	Edge	BS EN 320		NA	NA	750	902
Thickness Swelling (2 hour)		JIS A 5908	% (max)	8	8	8	8
Formaldehyde Emission							
Class I (E1)		EN 120	mg/100g	≤ 8.0			
Class 2 (E2)		EN 120	mg/100g	≥ 8.0 to 30			
CARB EPA Title VI		ASTM D 6007	ppm	≤ 0.09			

HD HMR V313 Chipboards (E1)

Target Density		KG/m3	700+		
Modulus of Rupture	BS EN 310	N/mm2 (Avg)	17	16	15
Modulus of elasticity in bending	BS EN 310	N/mm2 (Avg)	2650	2450	2200
Internal bond (dry)	BS EN 319	N/mm2 (Avg)	0.6	0.6	0.55

Thickness Swelling (24 hour)	JIS A 5908	% (max)	12	11	9
Thickness swelling after cyclic testing	EN 321	%	12	11	10
Internal bond after cyclic testing	EN 321	N/mm2	0.18	0.18	0.15

MFMDF & MFC Surface		
Test	Standard	Average Values attained
Surface Abrasion	Annexure C C1 10 - 10	600-900
Steam Test	Annexure D C1 10 - 11	No Change on Surface Finish
Heat Test @ 70 Deg c for 24hrs (Cracking Test)	Annexure E C1 10 - 12	No Change on Surface Finish
Cigarette Burn Test	Annexure F C1 10 - 13	No Change on Surface Finish
Stain Test	Annexure G C1 10 - 14	No Change on Surface Finish
Resin		Melamine Formaldehyde Resin

Mechanical and Surface Properties of Strato Core	
Parameter	Actual Values
Grade	BWR
Species of wood	
Surface	Tropical Hardwood
Back	Tropical Hardwood
Core	Tropical Hardwood
Size	
Length	2440 (+3mm)
Width	1220 (+3mm)
Thickness	16mm (+0.4mm)
Core thickness	1.5mm to 2mm
Face Veneer thickness	0.6mm
Glue	Melamine
Edge Straightness	0.2mm
Squareness	0.2mm
Density	600 +
Moisture content	max 12%
Core gap	None
Ply overlap	None
Thickness Swelling (2 hours)	< 2%
Thickness Swelling (24 hours)	< 5%
Warpage	Max 6mm (centre)
Standard Testing IS 1734:1983	Passes IS 303 specifications

Mechanical and Surface Properties of Decorative Laminates (HPL)				
Mechanical Properties		Test Method	Unit	Range of thickness (mm)
				0.7mm, 0.8mm, 0.9mm, 1mm +
Tolerance of Dimension	Thickness	BS EN 324-1	mm	± 5%
	Length & Width	BS EN 324-1	mm	± 5.0 for nett sized panel
Resistance to immersion in Boiling Water	Thickness	BS EN 324-1	mm	3.75
	Mass increasing	BS EN 324-1	mm	3.65
Resistance to Scratching	Load		N	3.0N
Resistance to impact test	Load		N	65.0N
Resistance to color change	Zenon Light		Visual	Blue Standard
Resistance to Dry Heat			Visual	Should pass test
Dimension Stability at Clevated temp	Logitudinal		%	0.5
	Transverse		%	0.58
Surface Abrasion		Annexure C C1 10 - 10		500
Steam Test		Annexure D C1 10 - 11		No change on surface Finish
Heat Test @ 70 Deg c for 24hrs (Cracking Test)		Annexure E C1 10 - 12		No change on surface Finish
Cigarette Burn Test		Annexure F C1 10 - 13		No change on surface Finish

Stain Test	Annexure G C1 10 - 14	No change on surface Finish
Resin	Phenol and Melamine formaldehyde Resin	
Additional Properties for Decorative Laminated Strato Core		
8x4x18mm	Both Sides Decorative Laminate pressed on a Flat-Lamination line bonded with PUR Glue	

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