

Master Data Sheet MDF STD										
MDF STD		MDF V20 STD E-1		Creation Date: 11-09-2014						
Product Specific Value	Specific Value	Standard	Unit	Thickness [mm]						
				6	6 - 9	9 - 12	12 - 19	19 - 25		
	Raw Density	EN 323	[kg/m ³]	≥ 740	≥ 730	≥ 720	≥ 690	≥ 680		
	Internal Bond	EN 319	[N/mm ²]	≥ 0,65		≥ 0,60	≥ 0,55			
	Bending Strenght	EN 310	[N/mm ²]	≥ 23		≥ 22	≥ 20	≥ 18		
	Swelling 24h	EN 317	[%]	≤ 30	≤ 17	≤ 15	≤ 12	≤ 10		
	Formaldehyde E-1	EN 120	[mg/100g]	≤ 8,0						
	Moisture Content	EN 322	[%]	4 - 11						
	Sand Content	ISO 3340	[%]	≤ 0,05						
	Length	EN 324-1	[mm/m]	± 2 max 5mm						
	Width	EN 324-1	[mm/m]	± 2 max 5mm						
	Straightness tolerance	EN 324-2	[mm/m]	≤ 1,5						
	Squareness tolerance	EN 324-2	[mm/m]	≤ 2,0						
	Thickness tolerance	EN 324-1	[mm]	± 0,2					± 0,3	
	Grit sandpaper	ISO 6344	-	P150						

Master Data Sheet MDF HLS							
MDF HLS*		MDF V313 HLS E-1		Creation Date: 11-09-2014			
Product Specific Value	Specific Value	Standard	Unit	Thickness [mm]			
				10 - 12	12 - 19	19 - 22	
	Raw Density	EN 323	[kg/m ³]	≥ 750	≥ 730	≥ 720	
	Internal Bond	EN 319	[N/mm ²]	≥ 0,80	≥ 0,75		
	Internal Bond after cyclic test	EN 321/ EN 317	[N/mm ²]	≥ 0,25	≥ 0,20	≥ 0,15	
	Surface Soundness	EN 311	[N/mm ²]	≥ 1,20			
	Bending Strenght	EN 310	[N/mm ²]	≥ 32	≥ 30	≥ 28	
	Swelling 24h	EN 317	[%]	≤ 10	≤ 8	≤ 7	
	Swelling after cyclic test	EN 321/ EN 317	[%]	≤ 16	≤ 15		
	Formaldehyde E-1	EN 120	[mg/100g]	≤ 8,0			
	Moisture Content	EN 322	[%]	4 - 11			
	Sand Content	ISO 3340	[%]	≤ 0,05			
	Length	EN 324-1	[mm/m]	± 2 max 5mm			
	Width	EN 324-1	[mm/m]	± 2 max 5mm			
	Straightness tolerance	EN 324-2	[mm/m]	≤ 1,5			
Squareness tolerance	EN 324-2	[mm/m]	≤ 2,0				
Thickness tolerance	EN 324-1	[mm]	± 0,3				
Grit sandpaper	ISO 6344	-	P150				

* MDF.HLS - Load-bearing boards for use in humid conditions, construction product, certificate CE 1488-CPD-0209/2