



TECHNICAL DATA SHEET  
**MELAMINE FACED TSS  
PARTICLE BOARD PANELS**

Chipboard not recycled to be used in internal place (type P2 according to EN 312) faced on the top side with melamine décor patterns through a pressing process.  
Available on request FSC-COC, water and fire resistant.



**SURFACE CHARACTERISTICS**

RESISTANCE TO ABRASION	EN 14323	Printed Class 1, Solid colors Class 3A
RESISTANCE TO STEAM	EN 14323	≥ Level 4
RESISTANCE TO SCRATCH	EN 14323	≥ 1,5N
RESISTANCE TO STAIN	EN 14323	Group 1 e 2, class ≥ 4
RESISTANCE TO LIGHT	EN 14323	≥ 6 blue wool scale
RESISTANCE TO CRACKS	EN 14323	Class ≥ 3
RESISTANCE TO DRY HEAT	EN 12722	Class B
TENDENCY TO KEEP DIRT	UNI 9300	Level ≥ 4

**PARTICLE BOARD CHARACTERISTICS**

Composition	Wood	trunks, stems, branchwood, billets, root collars, fast-growth trees and shrubs, residues from the sawing, veneer cutting, stripping and carpentry of broadleaves and coniferous species.		78 - 88%					
	Adhesive	Urea – formaldehyde glue		7 - 9%					
	Additives	Water		5 - 13%					
		Ammonium sulphate		0,2%					
		Paraffin		Tracce					
Density	EN 323	500 - 700 Kg/m <sup>3</sup>							
Moisture content	EN 322	5 - 13%							
Formaldehyde content	EN 120	Class E1	<8mg/100g						
	ASTM E1333-96	CARB (2)	<0,09ppm						
Dimension tolerances	Thicknes vs nominal value		≤15mm +/-0,2mm	>15mm +/-0,3mm					
	Thickness within same panel		+/-0,3mm						
	Lenght and width		+/-5mm						
Planarity (both sides melamine faced ≥ 15mm)	EN 14323	≤2mm/m							
Surface difects	EN 14323	Spots: ≤2 mm <sup>2</sup> /m <sup>2</sup>		Lenght: ≤20 mm/m <sup>2</sup>					
Requirements	Stand.	>3mm ≤4mm	>4mm ≤6mm	>6mm ≤13mm	>13mm ≤20mm	>20mm ≤25mm	>25mm ≤32mm	>32mm ≤40mm	>40mm
Internal bonding N/mm <sup>2</sup>	EN 319	> 0,45	> 0,45	> 0,40	> 0,35	> 0,30	> 0,25	> 0,20	> 0,20
Bending strenght N/mm <sup>2</sup>	EN 310	> 13	> 15	> 14	> 13	> 11,5	> 10	> 8,5	> 7
Elasticity modulus N/mm <sup>2</sup>	EN 310	> 1800	> 1950	> 1800	> 1600	> 1500	> 1350	> 1200	> 1050
Surface delamin. N/mm <sup>2</sup>	EN 311	> 0,8	> 0,8	> 0,8	> 0,8	> 0,8	> 0,8	> 0,8	> 0,8



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**ON REQUEST**

**WATER RESISTANT MELAMINE FACED PARTICLE BOARD**

Same properties as standard, but with water resistance:

Requirements	Stand.	>3mm <4mm	>4mm <6mm	>6mm <13mm	>13mm <20mm	>20mm <25mm	>25mm <32mm	>32mm <40mm	>40mm
Swelling H <sub>2</sub> O 24hr (*) V100	EN317	-	-	< 11%	< 10%	< 10%	< 9%	< 9%	< 9%
Int. bond. after H <sub>2</sub> O N/mm <sup>2</sup> (*) V100	EN1087			> 0,15	> 0,14	> 0,12	> 0,11	> 0,10	> 0,09

**FIRE RESISTANT MELAMINE FACED PARTICLE BOARD**

B-s2, d0 EN 13986 EN13501-1  
Class B ASTM E84 NFPA 101

**FSC CERTIFIED MELAMINE FACED PARTICLE BOARD**

FSC mix 75% ICILA-COC-000343



**STORAGE AND HANDLING**

Keep the goods in a dry and ventilated place (relative humidity 35%-65%). Do not store with easily inflammable substances. If exposed to ultraviolet rays of the sun the panel may deteriorate. Avoid creating unmanageably high and unstable stacks. To avoid warping or damp stains place the panels on pallets with suitable spaces. Use suction pads or gloves when handling the panels. Machinery and equipments must be fitted with appropriate aspiration devices.



**CLEANING AND CARE**

The melamine surfaces are the most resistant among the ones used in the furniture field. For cleaning use common detergent for domestic surfaces. It is suggested to avoid using of spray products directly on the surface as this can leave halos; it is preferred to apply the detergent on a soft damp cloth, clean and then rinse it. Avoid to use abrasive products, bleach or highly chlorate matters, acids.