



PARAMETER INSPEKSI
HDF-HMR Product Standard

No.	P	A	R	-	0	1	T	Q	A	-	0	0	4
Tgl. Efektif : 05 Mei 2022	Disetujui oleh <i>Rahmawati</i> QMR							Halaman 1 dari 1 Revisi : 7					

PROPERTIES	TEST METHODS	UNIT	THICKNESS							
			2.5 ≤ t ≤ 4.0	4.0 < t ≤ 6.0	6.0 < t ≤ 9.0	9.0 < t ≤ 12.0	12.0 < t ≤ 19.0	19.0 < t ≤ 30.0		
Density	EN 323	Kg/M3	≥ 880	≥ 870	≥ 860	≥ 850	≥ 810	≥ 790		
Thickness Tolerance	EN 324-1	mm	-0.1/+0.15	-0.1/+0.15	-0.1/+0.15	-0.1/+0.15	+0.15	+0.15		
Moisture Content	EN 322	%	8 ± 3							
Bending Strength (MOR)	EN 310	N/mm2	≥ 35	≥ 35	≥ 35	≥ 35	≥ 35	≥ 35		
Bending Young's Modulus (MOE)	EN 310	N/mm2	≥ 3000	≥ 3000	≥ 3000	≥ 3000	≥ 3000	≥ 3000		
Internal Bond	EN 319	N/mm2	≥ 1.2	≥ 1.0	≥ 1.0	≥ 1.0	≥ 1.0	≥ 1.0		
Wood Screw Holding Power	For Thickness 15mm Up	Face	EN 320	N	--	--	--	--	≥ 2000	≥ 2000
		Edge			--	--	--	--	≥ 1500	≥ 1500
Thickness Swelling (after 24 h. immersion)	EN 317	%	≤ 12	≤ 11	≤ 9	≤ 6	≤ 5	≤ 4		
V 313 Swelling after Cyclic Test	EN 317 EN 321	%	≤ 35	≤ 30	≤ 25	≤ 20	≤ 15	≤ 13		
Tensile Strength After Cyclic Test	EN 319 EN 321	N/mm2	≥ 0.60	≥ 0.55	≥ 0.50	≥ 0.45	≥ 0.40	≥ 0.35		
TYPE GLUE										
Formaldehyde Emission	UF ***	JIS A 5905 : 2014	mg/l	Average : ≤ 0.5 Maximum : ≤ 0.7						
	UF ****		mg/l	Average : ≤ 0.3 Maximum : ≤ 0.4						
	Phase 2	ASTM D 6007 : 2014	Ppm	Thickness ≤ 8.0 mm			Thickness > 8.0 mm			
				≤ 0.13			≤ 0.11			
Formaldehyde Content	E2	BS EN ISO 12460-5 : 2015	mg/100g	8 < FC ≤ 30						
	E1			≤ 8						
	SPF'S E0			≤ 5						



ISO 9001 : 2015



JQID06001

TPC6/CARB-ATCM/M005-MDF002
TPC6/EPA-TSCA/M005-MDF002

BRIK-VLK-0062



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Appearance Quality

ITEM			
Dimension	Length	± 3.0mm	Not more than 3.0mm with reference to target length
	Width	± 3.0mm	Not more than 3.0mm with reference to target width
	Diagonal	± 4.0mm	Both diagonal differential does not exceed 4.0mm
	Squareness	< 2.0 mm	Clearance between the square and board at the point of 1000 mm
Side Quality	Delamination	None	Board which splits across the surface
	Distinct Layer - 3 Layer	None	Visible three weak layers board, and soft at the core layer
	Edge Damage	None	Edge with dented, broken or knocked marks
	Brittle Edge	None	Edge surface is fragile and easily drop-off like send particle
	Corner Split	None	Corners which are blunt or delaminate
	Wavy Board	None	Board physically wavy across the length or width
	Warping	Not Visible	Board sag at the middle or bend upward at the middle
	Rainbow Pattern	Max ≤ 0.09 mm	Pattern on the side cause by saw blade
Surface Quality	Chatter Mark	One side	Even lines across the width of the board
	Line (one side only)	Max 1 lie ; Width max 2 cm	Spontaneous lines across the length of the board
	Press Mark (one side only)	Max 1 spot/m2	Pre-cure dot or lines (Depend on the Press belt dented spot)
	Rough Surface	None	Rough surface on the whole board or as patches
	Pre-cure Surface	One side	Surface which looks yellowish and rough
	Groove	One side	Deep depression line on surface
	Scratch	None	Abrasion line distributed evenly on surface
	Oil Stain (One side only)	Max 3 spots/m2	Marking or stain cause by oil , which unable to stick
	Water stain (One side only)	Max 3 spots/m2; dia.max 3 cm	Marking or stain cause by water , which looks darker
	Fibre Spot (One side only)	Max 3 spots/m2; dia.max 3 cm	Fible lump which easily scratch off by finger
	Latex Spot	Max 2 spots/m2; dia.< 5 cm	White or black color spot which looks like a rock
MLH	Non Latex		
Colour	No Colour, Black & Green		Indication



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