



PARAMETER INSPEKSI
JIS Product Standard
Customer SPF
Basis RN-25 G-MDF .

No. **P A R - 0 1 - T Q A - 0 0 4**

Efektif Date :
 March 04, 2019

Approval by,

[Signature]
 QC Manager

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Revisi :1

PROPERTIES	GLUE TYPE	TEST METHODS	UNIT	THICKNESS			
				1.0 ≤ t ≤ 2.0	2.0 < t ≤ 4.0	4.0 < t ≤ 6.0	
Density			Kg/M ³	.880	840	800	
Density Tolerance			Kg/M ³	± 30			
Thickness Tolerance			mm	± 0.15			
Single Board Thickness Tolerance			mm	≤ 0.15			
Moisture Content	UF ****	JIS A 5905	%	8 ± 3			
Banding Strength (MOR)	UF ***		N/mm ²	≥ 25			
Banding Young's Modulus (MOE)	MF ****		N/mm ²	≥ 2000			
Internal Bond	MF ***		N/mm ²	≥ 1.0	≥ 0.85	≥ 0.65	
Bending Strength Under Wet Conditioning (For M Type Only)			N/mm ²	≥ 12.5			
Swelling in thickness After Immersion In Water (For M Type Only)			%	≤ 17			
Thickness Swelling ± 20°C (Thickness swelling is not require in U- Type under JIS, this is for customer information only)			%	≤ 20			
Formaldehyde Emission							
TYPE	UF*** & MF ***		JIS A 1460	mg/L	Average 0.5		Maximum 0.7
	UF**** & MF ****				Average 0.4		Maximum 0.4



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Appearance Quality

	Item		Definition of Defects
Dimension	Length	± 2.0 mm	± 2.0 mm per order size
	Width	± 2.0 mm	± 2.0 mm per order size
	Diagonal	± 3.0 mm	Both diagonal differential does not exceed 3.0 mm
	Squareness Type A	≤ 2.0 mm	Clearance between the square and board at the point of 1000
	Squareness Type B	≤ 3.0 mm	Clearance between the square and board at the point of 1000
Side Quality	Delamination	None	Board which splits across the surface
	Distinct Layer - 3 layers	None	Visible three weak layers board, and soft at the core
	Edge Damage	None	Edge with dented, broken or knocked marks
	Brittle Edge	None	Edge surface is fragile and easily drop -off like sand particle
	Corner Split	None	Corners which are blunt or delaminate
	Wavy Board	None	Board physically wavy across the length or width
	Twisting and Warping	None	Board sag at the middle or bend upward at the middle
	Rainbow Cutting	None	Damage saw at the edge
Surface Quality	Chatter Mark	None	Even lines across the width of the
	Line	None	Spontaneous lines across the length of the
	Rough Surface	None	Rough surface on the whole board or as patches
	Pre- Cure Surface	None	Surface which looks yellowish and rough
	Groove	None	Deep depression line on surface
	Scratch	None	Abrasion line distributed evenly on surface
	Oil Stain	None	Marking or stain cause by water, which unable to stick
	Water - Stain	None	Marking or stain cause by water, which looks darker
	Fiber Spot	None	Fibre Lump which easily scratch off by finger
	Latek Spot	MLH	None
Rubber (One side)		\sum Max 3 spots/m ² ; \sum max.dia, <3 mm.	