

TECHNICAL SPECIFICATIONS

GLOSSMAX MEDELAM Harmonized Standard: EN 13986

CONTROL CRITERIA	TEST STANDARD	UNIT OR FEATURE	THICKNESS RANGE		
			6<t≤9	9<t≤12	12<t≤19
TOLERANCES ACCORDING TO NOMINAL DIMENSIONS ^{*1} -THICKNESS COMPARED TO RATED VALUES -THICKNESS t WITHIN THE BOARD	EN 14323	mm	<15 / ≥15 to 20 mm ; +0,5 /-0,3; >20 mm; ± 0,5 <15 / ≥15 to 20 mm ; t _{max} - t _{min} ≤ 0,6		
LENGTH AND WIDTH	EN 14323	mm	± 5		
FLATNESS	EN 14323	mm/m	only for balanced surfaces which t ≥ 15mm; ≤ 2		
EDGE DAMAGE	EN 14323	mm	≤ 10		
SURFACE DEFECTS	EN 14323	mm ² /m ²	point ≤ 2		
		mm/m ²	line ≤ 20		
RESISTANCE TO SCRATCHING ^{*2}	EN 14323	N	Class B 2≤t<3,5		
RESISTANCE TO CRACKING	EN 14323	Rating	≥ 3		
RESISTANCE TO STAINING	EN 14323	Rating	≥ 3		
GLOSS	EN 14323	Gloss Unit (GU)	20° min.85		
CROSS CUT ^{*3}	EN ISO 2409	Class	0 or 1		
SURFACE SOUNDNESS	EN 311	N/mm ²	≥ 1		
FORMALDEHYDE RELEASE	EN ISO 12460-3	mg/m ² air	E0 < 1,75, E1 ≤ 3,5 E2; 3,5 < release ≤ 8		
MIRROR EFFECT ^{*4}	TSE K 479	Observation	Min.6		
LIGHT FASTNESS (XENON ARC LAMP) ^{*5}	EN 15187	Scale	Grey Scale ≥ 4 Blue Wool > 6 ^{*6} Suitable for pigmented products only		


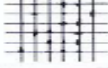



As an official trademark of Kastamonu, **Glosmax Medelam** boards are **decorative UV lacquer covered MDF** boards for interior furniture and decoration applications. This type of boards are especially used for kitchen cabinets, bathroom cabinets, bedrooms, rail cabinets, young rooms, office furniture, decoration and all modular products.

Please refer to the “**Medepan Technical Specifications**” for the substrate raw board specifications

***1 Thickness tolerances:** Here the thickness expresses the total thickness of the raw MDF board and the coatings of both surfaces of the board.

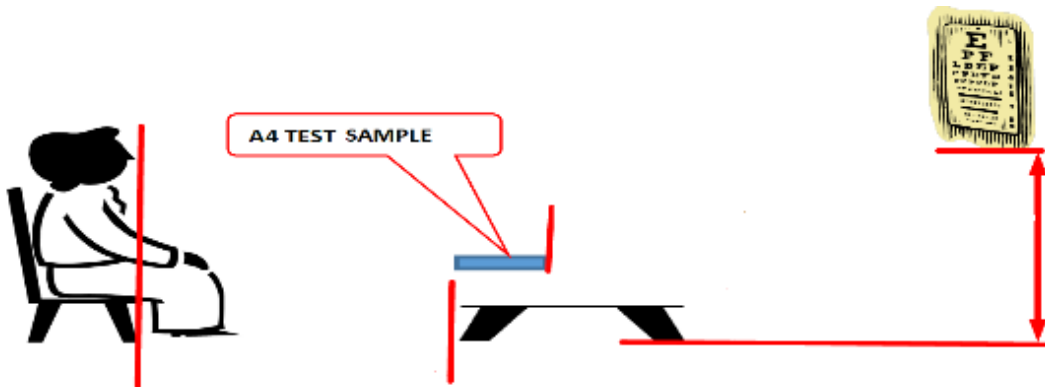
***2 Resistance to scratching:** Does not include the pearlescent surface treatment.

***3 Cross Cut:** Specifies assessing the resistance of paint coatings to separation from substrates when a light-angle lattice pattern is cut into the coating, penetrating through to the substrate.

Classification	Description	Appearance of surface of cross-cut area from which flaking has occurred ² (Example for six parallel cuts)
0	The edges of the cuts are completely smooth; none of the squares of the lattice is detached.	
1	Detachment of small flakes of the coating at the intersections of the cuts. A cross-cut area not greater than 5 % is affected.	
2	The coating has flaked along the edges and/or at the intersections of the cuts. A cross-cut area greater than 5 %, but not greater than 15 %, is affected.	
3	The coating has flaked along the edges of the cuts partly or wholly in large ribbons, and/or it has flaked partly or wholly on different parts of the squares. A cross-cut area greater than 15 %, but not greater than 35 %, is affected.	
4	The coating has flaked along the edges of the cuts in large ribbons and/or some squares have detached partly or wholly. A cross-cut area greater than 35 %, but not greater than 65 %, is affected.	
5	Any degree of flaking that cannot even be classified by classification 4.	—

² The figures are examples for a cross-cut within each step of the classification. The percentages stated are based on the visual impression given by the pictures and the same percentages will not necessarily be reproduced with digital imaging.

***4 Mirror Effect:** The mirror effect is measured as shown in the figure below and test rating is defined as the thorough and completely correct readable last sentence number.



***5 Light Fastness:** It covers the evaluation of the light effect on the rigid surfaces of all products whose surface treatments have been completed, regardless of their materials

***6** For detailed information about UV resistant pigmented products, get information from the relevant Sales Executive.

Colour matching and surface texture: A slight deviation of colour and / or surface texture according to Rating4 EN14323 between the test sample and Kastamonu reference sample.

It is recommended the components that will be used side by side should be selected from the same production batch to maintain colour compatibility.

Note 1: This document may be modified at any time by the company without any express obligation to send any updated edition to all original recipients. To verify that you have the latest edition available, you are advised to contact the relevant Sales Executive..

Note 2: For current EN and TSE document / document scope, it is recommended to contact relevant Sales Executive.