

KASTAMONU BULGARIA JSC, 24 Shipchenska epopeya, Str. Stara Zagora / Pavel Banya / Gorno Sahrane
 Postal Code: 6151, Tel: +359 (0)431 628 90, Email: info@keas.bg

This document has been prepared in accordance with Standard EN ISO/IEC 17 050-1

This product is manufactured in accordance with Standard EN 312 and EN 14 322

№	Mechanical properties and general tolerances	Test method	Unit	Requirements				
				Thickness range (mm, nominal)				
				≥ 8 to 13	> 13 to 20	> 20 to 25	> 25 to 32	> 32 to 40
1	Tolerances on nominal dimensions:	EN 324-1						
	- Thickness (sanded) boards		mm	± 0.3				
	- Length and width		mm	± 5				
	- Density		kg/m ³	± 10 %				
2	Edge straightness tolerance	EN 324-2	mm/m	≤ 1.5				
3	Squareness tolerance	EN 324-2	mm/m	≤ 2				
4	Moisture content	EN 322	%	5 - 13 %				
5	Density	EN 323	kg/m ³	660	650	640	630	620
6	Bending strength	EN 310	N/mm ²	≥ 15	≥ 14	≥ 12	≥ 11	≥ 9
7	Modulus of elasticity in bending	EN 310	N/mm ²	≥ 2050	≥ 1950	≥ 1850	≥ 1700	≥ 1550
8	Tensile strength	EN 319	N/mm ²	≥ 0.45	≥ 0.45	≥ 0.4	≥ 0.35	≥ 0.3
9	Thickness swelling, (24 h.)	EN 317	%	≤ 17	≤ 14	≤ 13	≤ 13	≤ 12
10	Water absorption, (24 h.)	EN 317	%	≤ 50	≤ 50	≤ 50	≤ 50	≤ 50
11	Tensile strength after cross examination by boiling	EN 1087-1	N/mm ²	≥ 0.09	≥ 0.08	≥ 0.07	≥ 0.07	≥ 0.06
12	Surface soundness	EN 311	N/mm ²	≥ 0.8				
13	Screw hold edge	EN 320	N	≥ 450				
14	Formaldehyde release according to EN 13986 - Class E1 Perforator value	EN 12460-5 (EN 120)	mg/100 g	≤ 8 mg/100 g.				

Technical data about melamine faced chipboards

15	Edge damage	EN 14 323	mm	≤ 10				
16	Surface defects	EN 14 323	mm ² /m ²	points ≤ 2				
			mm/m ²	length ≤ 20				
17	Resistance to scratching	EN 14 323	N	≥ 1.5				
18	Resistance to staining	EN 14 323	Rating	≥ 3				
19	Resistance to cracking	EN 14 323	Rating	≥ 3				
20	Resistance to steam	EN 14 323	Rating	≥ 3				
21	Porosity	EN 14 323	Rating	≥ 3				
22	Resistance to hot cover	EN 14 323	Rating	≥ 3				

NOTE: Laminated Chipboard panels with melamine impregnated paper.

The values are characterised by a moisture content in the material corresponding to a relative humidity of 65 % and a temperature of 20 °C.

NOTE: Upon customer's demand we may offer FSC™ certified products. FSC certified products are specified in the invoice.

Application: Particleboards, three-layered, flat-pressed.

- P3 type intended for non-bearing structures and use in damp conditions.

Delivery dimensions (mm) (length and width)

- 1830 - 3660
- 1830 - 2440
- 2070 - 2800



Elaborated: **Quality Control Manager**
 Nefize Seydi

Approved: **General Manager**
 Mehmet Safaltin