



SLOVENSKI STANDARD
SIST EN 324-2:1996

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Wood-based panels - Determination of dimensions of boards - Part 2: Determination of squareness and edge straightness

Holzwerkstoffe - Bestimmung der PlattenmaÙe - Teil 2: Bestimmung der Rechtwinkligkeit und der Kantengeradheit

Panneaux a base de bois - Détermination des dimensions des panneaux - Partie 2: Détermination de l'équerrage et de la rectitude des bords

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Ta slovenski standard je istoveten z: EN 324-2:1993

ICS:

79.060.01 Š^•} ^Á || z ^Á æÁ || z} [Wood-based panels in general

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en

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UDC 674.815:531.74

Descriptors: Wood-based panel, fibreboard, particleboard, plywood, OSB, cement-bonded particleboard, test method, dimensions of boards, squareness, edge straightness

English version

**Wood-based panels - Determination of dimensions
of boards - Part 2: Determination of squareness
and edge straightness**

Panneaux à base de bois - Détermination des
dimensions des panneaux - Partie 2:
Détermination de l'équerrage et de la rectitude
des bords

Holzwerkstoffe - Bestimmung der Plattenmaße -
Teil 2: Bestimmung der Rechtwinkligkeit und der
Kantengeradheit

This European Standard was approved by CEN on 1992-12-15. CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

The European Standards exist in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

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Foreword

This European Standard was prepared by Working Group 4 "Common test methods" (Secretariat: United Kingdom) Technical Committee CEN/TC 112, Wood-based panels (Secretariat: Germany).

The text is based on ISO 9426-2 which has been elaborated with European participation.

This standard is one of a series of standards specifying methods of test for determining dimensions and properties of wood based panels.

No existing European Standard is superseded.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by August 1993, and conflicting national standards shall be withdrawn at the latest by December 1994.

In accordance with the CEN/CENELEC Internal Regulations, the following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, United Kingdom.

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1 Scope

This European Standard specifies methods for measuring the squareness and edge straightness of wood-based panels.

It applies to whole flat boards.

The methods for the determination of thickness, width and length are specified in EN 324-1.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard, only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 322 Wood-based panels - Determination of moisture content

EN 326-1 Wood-based panels - Sampling, cutting and inspection
Part 1: Sampling and cutting of test pieces and expression of test results ¹⁾

3 Principle

Squareness and edge straightness of full size boards is determined by measurement of deviation from a mechanical square or straight edge.

4 Sampling

Sampling of panels shall be in accordance with EN 326-1.

5 Moisture content at time of measurement

Normally boards are measured in the as-received state.

If necessary the moisture content of the boards shall be determined in accordance with EN 322.

6 Conditioning

If required, the boards shall be conditioned to constant mass in an atmosphere with a relative humidity of $(65 \pm 5) \%$ and a temperature of $(20 \pm 2) ^\circ\text{C}$. Constant mass is considered to be reached when the results of two successive weighing operations, carried out at an interval of 24 h, do not differ by more than 0,1 % of the mass of the board.

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1) At present at the draft stage

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7 Apparatus

7.1 Measuring instrument for length and width measurement

Steel measuring tape graduated to at least 1 mm

7.2 Mechanical square

A mechanical square having two arms of $1000 \text{ mm} \pm 1 \text{ mm}$ for measuring the deviation of the angles of adjacent sides of a board from a right angle. It shall be accurate to 0,2 mm in 1000 mm (see figure 1).

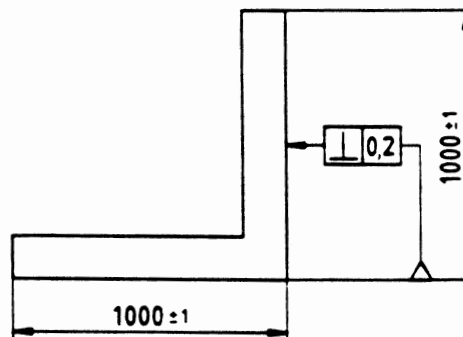


Figure 1: Accuracy requirements of mechanical square

7.3 Straightedge

A straightedge of length at least equal to the length of the board, or wire of constant cross-section and flexible enough to be stretched to assure linearity.

7.4 Steel rule, wedge or caliper for deviation measurements

A steel rule, wedge or caliper graduated to at least 0,5 mm.

8 Procedure

8.1 Determination of squareness of boards

8.1.1 Place one side of the square against one side of the board the squareness of which is to be measured (see figure 2).

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8.1.2 At a distance of $1000 \text{ mm} \pm 1 \text{ mm}$ from the corner of the board, measure the distance δ_1 between the board edge and the side of the other arm of the square by means of one of the measuring devices specified in 7.4 (see figure 2).

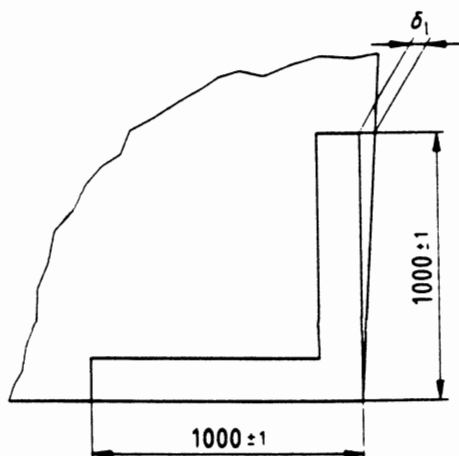


Figure 2: Use of mechanical square to measure board squareness

8.1.3 Follow the same procedure for each of the other corners.

8.2 Determination of edge straightness of boards

8.2.1 Place the straight edge against a board edge, or locate the wire at the corners of the board and stretch it.

8.2.2 Measure the largest deviation between the straight edge (or wire) and the edge of the board using one of the measuring devices specified in 7.4 and read the result to 0,5 mm.

8.2.3 Follow the same procedure for each of the other edges.

9 Expression of results

9.1 Squareness of boards

The result is the largest measured value of the deviation of the side of the square and the board edge. It is expressed in mm over 1 m board edge-length (mm/m) to 0,5 mm/m.

9.2 Straightness of board edges

The result, expressed separately for width and length, in mm/m, is the larger value of the measured deviations divided by the length of the appropriate edge.

10 Test report

As described in EN 326-1.

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