



SLOVENSKI STANDARD
SIST EN 622-1:1998
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Fibreboards - Specifications - Part 1: General requirements

Faserplatten - Anforderungen - Teil 1: Allgemeine Anforderungen

Panneaux de fibres - Exigences - Partie 1: Exigences générales

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Ta slovenski standard je istoveten z: EN 622-1:1997

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ICS:

79.060.20 X|a } ^ } ^ / ^ / ^ ! } ^ A || z ^ Fibre and particle boards

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EUROPEAN STANDARD

EN 622-1

NORME EUROPÉENNE

EUROPÄISCHE NORM

June 1997

ICS 79.060.20

Descriptors: wooden boards, fibreboards, characteristics, specifications

English version

Fibreboards - Specifications - Part 1: General requirementsPanneaux de fibres - Exigences - Partie 1:
Exigences généralesFaserplatten - Anforderungen - Teil 1:
Allgemeine Anforderungen**ITeH STANDARD PREVIEW**
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This European Standard was approved by CEN on 1997-04-21. 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, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CENEuropean 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 has been prepared by Technical Committee CEN/TC 112 "Wood-based panels" the secretariat of which is held by DIN.

This standard is one of a series specifying requirements for fibreboards. The titles of the other parts of this series are listed in clause 2.

In some CEN member countries, legislative requirements concerning the formaldehyde emission of wood-based panels exist. These A-deviations are outlined in the informative annex C.

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 December 1997, and conflicting national standards shall be withdrawn at the latest by December 1997.

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.



1 Scope

This European Standard specifies the requirements for some properties which are common to all uncoated fibreboard types as defined in EN 316.

2 Normative references

This 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 standard only when incorporated in it by amendment or revision. For undated references, the latest edition of the publication referred to applies.

EN 120

Wood-based panels – Determination of formaldehyde content – Extraction method called the perforator method

EN 316

Wood fibreboards – Definition, classification and symbols

EN 322

Wood-based panels – Determination of moisture content

EN 323

Wood-based panels – Determination of density

EN 324-1

Wood-based panels – Determination of dimensions of boards – Part 1: Determination of thickness width and length

EN 324-2

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

EN 622-2

Fibreboards – Specifications – Part 2: Requirements for hardboards

EN 622-3

Fibreboards – Specifications – Part 3: Requirements for medium boards

EN 622-4

Fibreboards – Specifications – Part 4: Requirements for softboards

EN 622-5

Fibreboards – Specifications – Part 5: Requirements for dry process boards (MDF)

3 Requirements

Fibreboards shall comply with the general requirements listed in table 1 and the thickness tolerances listed in table 2 when dispatched from the producing factory. For certain uses of fibreboards (see specific standards for fibreboards types and general performance standards for wood-based panels), in the case of dispatch in cut sizes, or when further machined (e.g. tongued and grooved), special tolerances for nominal dimensions, squareness and edge straightness may be agreed upon. The values given in table 1 and table 2 for tolerances for nominal dimensions (thickness, width and length), squareness, edge straightness and density within a panel, are characterized by a moisture content in the material corresponding to a temperature of 20 °C and a relative humidity of 65 %. Properties not required for specific board types are marked "-".

The requirements relating to formaldehyde potential (perforator value) shall be met by the 95 percentile value based on test values of individual boards. The 95 percentile value shall be equal to or less than the value given in table 1.

Table 1: General requirements for different types of fibreboard at dispatch

Property	Test method	Board Type			
		Hard-boards (HB)	Medium boards (MBL and MBH)	Soft-boards (SB)	Dry process boards (MDF)
Tolerances on nominal dimensions: Thickness Length and width	EN 324-1 EN 324-1	see Table 2 ± 2 mm/m, maximum ± 5 mm			
Squareness tolerances	EN 324-2	2 mm/m			
Edge straightness tolerance	EN 324-2	1,5 mm/m			
Moisture content	EN 322	4 % to 9 %	4 % to 9 %	4 % to 9 %	4 % to 11 %
Tolerance on mean density within a panel	EN 323	–	–	–	± 7 %
Formaldehyde potential (Perforator value) *) Class A Class B	EN 120	– –	– –	– –	≤ 9 mg/100 g ≤ 40 mg/100 g

*) The perforator values apply to panels with a moisture content H of 6,5 %. In the case of dry process boards with different moisture contents, the perforator value shall be multiplied by a factor F calculated from the following equations:

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For panels with moisture contents in the range of $4 \% \leq H \leq 9 \%$:

$$F = -0,133 H + 1,86$$

Respectively for panels with moisture contents $H < 4\%$ and $H > 9\%$:

$$F = 0,636 + 3,12 e^{(-0,346 H)}$$

Table 2: Tolerances on nominal thickness for fibreboards at dispatch

Board types	Hardboards (HB)	Nominal thickness (mm)		
		$\leq 3,5$	$> 3,5$ to $5,5$	$> 5,5$
		$\pm 0,3$ mm	$\pm 0,5$ mm	$\pm 0,7$ mm
	Medium boards (MBL and MBH)	Nominal thickness (mm)		
		≤ 10	> 10	
		$\pm 0,7$ mm	$\pm 0,8$ mm	
	Softboards (SB)	Nominal thickness (mm)		
		≤ 10	> 10 to 19	> 19
		$\pm 0,7$ mm	$\pm 1,2$ mm	$\pm 1,8$ mm
	Dry process boards (MDF)	Nominal thickness (mm)		
		≤ 6	> 6 bis 19	> 19
		$\pm 0,2$ mm	$\pm 0,2$ mm	$\pm 0,3$ mm

4 Verification of compliance

4.1 General

Verification of compliance with this European Standard shall be carried out using the test methods listed in table 1.

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4.2 External control

External control of the factory, if any, shall be carried out according to a statistical basis¹⁾.

The inspection of a consignment of panels shall be carried out according to a statistical basis¹⁾.

In the case of formaldehyde potential, however, for both external control and inspection of a consignment of panels, the respective requirements set out in table 1 shall be met by the average value of at least three boards controlled. Additionally, no individual boards is allowed to exceed an upper tolerance limit of +10 %.

4.3 Internal control

Internal control shall be carried out according to a statistical basis¹⁾.

The properties listed in tables 1 and 2 shall be controlled, using intervals between tests not exceeding those given in table 3. Sampling shall be carried out at random. Alternative test methods and/or unconditioned test pieces may be used if a valid correlation to the specified test methods can be proven. The intervals between tests given in table 3 are related to a production under statistical control.

¹⁾ It is intended to apply EN 326-2 and EN 326-3 (which are under preparation for the time being) as a statistical basis when implemented.

Table 3: Maximum intervals between tests for each production line

Property	Maximum test interval
Formaldehyde potential*) Class A Class B	24 h per type of board 1 week per type of board
Moisture content	8 h per type of board
All other properties listed in tables 1 and 2	8 h per type and thickness range
*) Some types of fibreboards are known to release little or no formaldehyde. In these cases, maximum test intervals may be increased. However, it remains the responsibility of the producer or inspection agency, if any, to ensure compliance with this EN.	

5 Marking

Marking of fibreboards shall be carried out in accordance with EN 622-2, EN 622-3, EN 622-4 and EN 622-5 as appropriate.

Colour coding is voluntary. If applied, it shall comply with the system shown in Annex B. This standard does not exclude colour dyeing of the whole board or individual layers of the board according to traditional national practices.

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Annex A (informative)**Bibliography**

prEN 326-2

Wood-based panels – Sampling, cutting and inspection – Part 2: Quality control in the factory

prEN 326-3

Wood-based panels – Sampling, cutting and inspection – Part 3: Inspection of a consignment of panels

Annex B (normative)**Voluntary colour coding system for fibreboards**

Two colours are used in each case. The first colour defines the panel as either intended for general purposes use or for loadbearing applications (either one or two stripes of this colour are used). The second colour identifies the panel as being suitable for use either in dry or in humid or in exterior conditions.

The colours used are as follows:

First colour	white	general purpose
First colour	yellow	loadbearing
Second colour	blue	dry conditions
Second colour	green	humid conditions
Second colour	brown	exterior conditions.

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