



**SLOVENSKI STANDARD
SIST EN 14322:2004**

01-september-2004

Številni podatki, ki so potrebni za uporabo tega standarda, so na voljo na spletni strani <http://standards.iteh.ai>

Wood-based panels - Melamine faced boards for interior uses - Definition, requirements and classification

Holzwerkstoffe - Melaminbeschichtete Platten zur Verwendung im Innenbereich - Definition, Anforderungen und Klassifizierung

Panneaux a base de bois - Panneaux surfacés mélaminés pour usages intérieurs - Définition, exigences et classification

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79.060.01 Številni podatki, ki so potrebni za uporabo tega standarda, so na voljo na spletni strani <http://standards.iteh.ai> Wood-based panels in general

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 14322

March 2004

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English version

Wood-based panels - Melamine faced boards for interior uses - Definition, requirements and classification

Panneaux à base de bois - Panneaux surfacés mélaminés
pour usages intérieurs - Définition, exigences et
classification

Holzwerkstoffe - Melaminbeschichtete Platten zur
Verwendung im Innenbereich - Definition, Anforderungen
und Klassifizierung

This European Standard was approved by CEN on 16 January 2004.

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.

This European Standard exists 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, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
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Foreword

This document (EN 14322:2004) has been prepared by Technical Committee CEN/TC 112 "Wood-based panels", the secretariat of which is held by DIN.

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 September 2004, and conflicting national standards shall be withdrawn at the latest by September 2004.

Annexes A and B are normative.

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

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EN 14322:2004 (E)

1 Scope

This European Standard specifies the surface requirements and dimensional tolerances for decorative melamine faced boards for interior use which are common for particleboards and fibreboards.

This standard does not apply to boards laminated with so called priming foils, finish foils, laminates according to EN 438-1.

This standard does not apply to laminate floor coverings.

Melamine faced wood-based boards in accordance with this standard may be referred to as MFB.

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 (including amendments).

EN 311, *Wood-based panels - Surface soundness - Test method*

ENV 717-1, *Wood-based panels - Determination of formaldehyde release - Part 1: Formaldehyde emission by the chamber method*

EN 717-2, *Wood-based panels - Determination of formaldehyde release - Part 2: Formaldehyde release by the gas analysis method*

EN 14323, *Wood-based panels - Melamine faced boards for interior uses - Test methods*

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3 Terms and definitions

For the purposes of this European Standard, the following term and definition applies.

melamine faced board

MFB

board manufactured by directly applying uncured aminoplastic resin impregnated papers to one or both faces of board substrates and achieving bonding and curing in the same process using heat and pressure but without the use of an intermediate adhesive. The resin of the surface layer is an aminoplastic resin (mainly melamine resin).

The board surfaces may be smooth or structured on one or both faces and the outer surfaces having decorative colours or design

4 Requirements

Melamine faced boards shall comply with the general requirements as listed in Table 1 when dispatched from the producing factory.

Table 1 — General requirements at dispatch

No	Property	Test method	Unit	Requirement		
				Thickness range (mm, nominal)		
				< 15	≥ 15 to 20	> 20
1)	Tolerances on nominal dimensions — thickness relative to nominal value — thickness within the board	EN 14323	mm	± 0,3 for class 1 and class 2 according to Table 2. + 0,5/– 0,3 for class 3A, 3B and class 4 according to Table 2 and all gloss finishes		± 0,5
	$t_{\max} - t_{\min} \leq 0,6$					
	Length & width — commercially available size — pre-cut panels	EN 14323	mm	± 5 ± 2,5		
2)	Flatness	EN 14323	mm/m	—	≤ 2 (only for balanced surfaces)	
3)	Edge damage — commercially available sizes — pre-cut panels	EN 14323	mm	≤ 10 ≤ 3		
4)	Surface defects	EN 14323	mm ² /m ² mm/m	points ≤ 2 length ≤ 20		
5)	Resistance to scratching	EN 14323	N	≥ 1,5		
6)	Resistance to staining	EN 14323	Rating	≥ 3		
7)	Resistance to cracking	EN 14323	Rating	≥ 3		
8)	Formaldehyde release (see annex B)			Class E1 or Class E2		
NOTE 1 For the physical and dimensional properties, refer to the relevant standards from the series EN 312 or EN 622.						
NOTE 2 Normally, unless otherwise specified, the particleboard grade used will be as required in EN 312/P2, the MDF grade will be as described in EN 622-5 (MDF) and the hardboard grade will be as described in EN 622-2 (HB).						
NOTE 3 On request of the customer other values can be specified.						
NOTE 4 Numerous factors including changes in temperature and relative humidity in storage and fabrication areas at building sites may cause boards and panels to bow or twist irreversibly.						

5 Appearance

5.1 Colour matching

Where colour matching is required by the purchaser there shall be only slight deviation (rating 4) between the reference sample and test piece under examination when inspected according to test method given in EN 14323. For mother of pearl and metallic finishes a rating 3 is permitted.

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NOTE Since slight variations in colour will occur due to inherent variation in the surfacing papers and the core board, it is recommended that boards or panels to be used side by side should be selected from the same production batch where possible and matched to ensure colour compatibility before fabrication or installation.

5.2 Surface texture

Where matching of surface texture is required by purchaser there shall be only slight deviation (rating 4) between the reference sample and test piece under examination when inspected according to test method given in EN 14323.

6 Classification by resistance to abrasion

Five classes are defined in the classification system based on the wear resistance (WR) and the initial wear point (IP) as shown in Table 2. The number of revolutions for each classification is determined according to EN 14323.

Table 2 — Classification of MFB according to the wear resistance and the initial wear point

Class	IP Revolutions	WR Revolutions
1	< 50	< 150
2	≥ 50	≥ 150
3A	≥ 150	≥ 350
3B	≥ 250	≥ 650
4	≥ 350	≥ 1 000

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7 Verification of compliance

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7.1 General

Verification of compliance with this EN shall be carried out using the test methods specified in EN 14323.

7.2 Factory production control

The properties in Tables 1 and 2 shall be controlled by the producer. Sampling shall be carried out at random. Alternative test methods and/or unconditioned test pieces may be used for factory production control.

7.3 External control

If external control is deemed necessary, the test method listed in EN 14323 shall be used.

8 Marking

Each panel shall be clearly marked by the manufacturer by indelible direct printing on the edge or by a label with at least the following information in this sequence:

- a) manufacturer's name, trade mark, or identification mark;
- b) number of the relevant specification EN of the substrate and the type;
- c) nominal thickness;
- d) formaldehyde class;
- e) batch number.

NOTE Where the first purchaser is the user of the product and where he/she agrees that marking (other than on the package) is unnecessary, the marking of such individual panels in the package need not be undertaken.

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