# SLOVENSKI STANDARD
# SIST EN 326-3:2004

**01-januar-2004**

**Nadomeġ ena:**
**SIST EN 326-3:2000**

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**Lesne ploġ e ï Vzorē enje, razġagovanje in kontrola ï 3.del: Kontrola posamezne partije ploġ**

Wood-based panels - Sampling, cutting and inspection - Part 3: Inspection of an isolated lot of panels

Holzwerkstoffe - Probenahme, Zuschnitt und Überwachung - Teil 3: Abnahmeprüfung eines einzelnen Loses von Platten

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Panneaux a base de bois - Echantillonnage, découpe et contrôle - Partie 3: Contrôle d'un lot isolé de panneaux

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**Ta slovenski standard je istoveten z:** **EN 326-3:2003**

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**ICS:**

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|---|---|---|
| 79.060.01 | Lesne ploġ e na sploġno | Wood-based panels in general |

**SIST EN 326-3:2004** **en**

2003-01.Slovenski inštitut za standardizacijo. Razmnoževanje celote ali delov tega standarda ni dovoljeno.

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EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

# EN 326-3

November 2003

ICS 79.060.01

Supersedes EN 326-3:1998

English version

# Wood-based panels - Sampling, cutting and inspection - Part 3: Inspection of an isolated lot of panels

Panneaux à base de bois - Echantillonnage, découpe et contrôle - Partie 3: Contrôle d'un lot isolé de panneaux

Holzwerkstoffe - Probenahme, Zuschnitt und Überwachung - Teil 3: Abnahmeprüfung eines einzelnen Loses von Platten

This European Standard was approved by CEN on 1 September 2003.

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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 Management Centre has the same status as the official versions.

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## Foreword

This document (EN 326-3:2003) 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of an identical text or by endorsement, at the latest by May 2004, and conflicting national standards shall be withdrawn at the latest by May 2004.

This standard is one of a series on sampling, cutting and inspection of wood-based panels. The other parts of this series are listed in clause 2.

This European Standard supersedes EN 326-3:1998. Compared to the version EN 326-3:1998 the following modifications have been made:

a) The title has been changed to ‘isolated’ lot.

b) Inspection lot sizes and sample sizes modified taking into account ISO 2859-2 for isolated lot inspection.

c) Different sample sizes are given depending whether or not the production is controlled according to EN 326-2.

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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, Hungary, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Slovakia, Spain, Sweden, Switzerland and the United Kingdom.

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## 1 Scope

This European Standard specifies methods for the verification of compliance of one or more properties of an isolated lot of wood-based panels with the requirements of the relevant EN specification standards. Different sample sizes are given depending on whether or not the production is controlled according to EN 326-2.

For panels, the production of which is controlled in accordance to EN 326-2 this European Standard can be used in case of a dispute. It is not applicable for the factory production control. For these purposes, EN 326-2 applies.

In this standard, verification of compliance is based on the testing of small test pieces.

## 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 326-1:1994, *Wood-based panels — Sampling, cutting and inspection — Part 1: Sampling and cutting of test pieces and expression of test results.*

EN 326-2, *Wood-based panels — Sampling, cutting and inspection — Part 2: Quality control in the factory.*

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ISO 2859-1, *Sampling procedures for inspection by attributes — Part 1: Sampling schemes indexed by acceptable quality limit (AQL) for lot-by-lot inspection.*

ISO 2859-2, *Sampling procedures for inspection by attributes — Part 2: Sampling plans indexed by limiting quality (LQ) for isolated lot inspection.*

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## 3 Symbol

### 3.1 Letter symbols (see also EN 326-1 and EN 326-2)

*Ac* Acceptance number

*AQL* Acceptable quality level

*L* Lower specification limit

*m* Number of test pieces cut from each single panel of the sample, in either direction

*n* Sample size (number of panels)

*N* Number of panels in one lot, i.e. lot size

*Re* Rejection number

*t* Single-sided 5 % value factor related to the number of panels

*U* Upper specification limit

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### 3.2 Indices (see also EN 326-1)

cu Cumulative value

d Related to double sample plan

l,attr Related to lot inspection by attributes

l,var Related to lot inspection by variables

*i* Serial test piece number within a panel ($i$ = 1, 2, ..., $n$)

*j* Test panel identification number within a sample ($j$ = 1, 2, ..., $m$)

si Related to single sampling plan

## 4 Terms and definitions

For the purposes of this European Standard, the terms and definitions given in EN 326-1 and in EN 326-2 and the following apply.

**4.1**
**attribute**
quality characteristic which a panel do or do not possess and which is used to determine conformance with the acceptability criteria of the inspection

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**4.2**
**limiting quality**
(*LQ*)
quality level which, for the purpose of sampling inspection, is limited to a low probability of acceptance when a lot is considered in isolation [ISO 2859-1:1999, definition 3.1.28]

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**4.3**
**lot**
number of panels (N) from the same manufacturer of a single type, grade, class, thickness range or thickness, from which a sample (n) is to be drawn for inspection to determine conformance with the acceptability criteria of the characteristics to be controlled

**4.4**
**variable**
numerical quality characteristic which is used to determine conformance with the acceptability criteria of the inspection

## 5 Verification of compliance

### 5.1 Inspection body

The inspection of an isolated lot of panels shall be carried out by a recognised, independent agency, or otherwise by agreement between the parties concerned. In the case of a construction product the independent agency shall be a notified body.

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## 5.2 Sampling

### 5.2.1 Lot identification

The lot from which the sample for inspection is to be taken shall consist only of panels from the same manufacturer and of a single type, grade, class, thickness range or thickness.

### 5.2.2 Sampling of panels

#### 5.2.2.1 General

The number of panels to be selected at random for testing from each inspection lot depends on the size of the inspection lot and the control status.

#### 5.2.2.2 Sample size for inspection by variables

The size of the sample $n_{l,var}$ is given in Table 1.

**Table 1 — The size of the sample $n_{l,var}$ in relation to the size of the lot $N_{l,var}$ when inspecting by variables**

| Lot size $N_{l,var}$ | Sample size $n_{l,var}$ | |
|---|---|---|
| | Panels controlled according to EN 326-2 | Panels not controlled according to EN 326-2 |
| ≤ 90 | 5 | 7 |
| 91 to 150 | 7 | 10 |
| 151 to 280 | 10 | 15 |
| 281 to 500 | 15 | 25 |
| 501 to 1 200 | 20 | 35 |
| 1 201 to 3 200 | 25 | 50 |
| 3 201 to 10 000 | 35 | 75 |
| 10 001 to 35 000 | 50 | 100 |
| Larger lots shall be subdivided | | |
| These sample sizes correspond to ISO 3951 to a normal inspection of level I for panels controlled according to EN 326-2 and to a normal inspection of level II for uncontrolled panels, respectively. | | |

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#### 5.2.2.3 Sample size for inspection by attributes

##### 5.2.2.3.1 General

To determine the acceptability of an inspection lot a single or a double sampling plan shall be used. The choice of sampling plan shall be made before drawing the sample.

##### 5.2.2.3.2 Single sampling plan

The size of the sample $n_{l,attr,si}$ for a single sampling plan is given in Table 2.

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**Table 2 — Single sampling plan for inspection by attributes**

| Lot size $N_{l,attr}$ | Sample size $n_{l,attr,si}$ | |
|---|---|---|
| | Panels controlled according to EN 326-2 | Panels not controlled according to EN 326-2 |
| ≤ 90 | 5 | 34 |
| 91 to 150 | 8 | 38 |
| 151 to 280 | 13 | 42 |
| 281 to 500 | 20 | 50 |
| 501 to 1 200 | 32 | 80 |
| 1 201 to 3 200 | 50 | 125 |
| 3 201 to 10 000 | 80 | 200 |
| 10 001 to 35 000 | 125 | 315 |
| Larger lots shall be subdivided | | |
| These sample sizes correspond to a normal inspection of level I for an *AQL*-value of 4 % according to ISO 2859-1 for panels controlled in accordance with EN 326-2 and a *LQ*-value of 5 % according to ISO 2859-2 for uncontrolled panels, respectively. These inspection levels correspond to the requirement that at least 95 % of the inspection lot are for each property above the required quality level. | | |

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#### 5.2.2.3.3 Double sampling plan

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The size of the first sample $n_{l,attr,d}$ for a double sampling plan is given in Table 3. The second sample size shall be equal to the first sample size, and the corresponding total sample size of double sampling $n_{l,cu}$ is given in Table 3. Both, the first and second sample shall be drawn from the whole inspection lot at random.