HDF Hvid

TECHNICAL SHEET

Technical Data Sheet

01th of May 2020
Version: 6.0

Lacquered Thin HDF - LHDF

Applications and uses:

Packaging, FCPM, Door industry, Furniture industry: non-loaded furniture elements, for indoor use in dry conditions, interior fittings including furniture, back-panels etc.

Characteristics:

Besides raw boards, KRONOSPAN-MOFA Hungary Fibreboard Production Ltd also produces and sells HDF boards with lacquered surfaces. With the roll-lacquering technology, we are capable of producing uni-coloured (UNI) and wood-grain lacquered HDF boards with several wood-structures (oak, modern oak, beech, cherry, walnut, pine, anigree, wenge, maple, alder, calvados, plum, fantasy, etc.). The decors can be printed with up to 4 colours.

Lacquered HDF boards can be used in every field where aesthetic, moderately resistant surfaces are required. The main areas of application are: forming open and closed backs of cabinet furniture, door production, making bases of cabinet and bed drawers.

If the order refers one or more variant about the next special requirements, we can offer all qualities below with CARB Phase 2 & US. EPA TSCA Title VI or GPCO {what is mean German Prohibition of Chemical Ordinance (GermanVerbsotV; 01.01.2020)}; combination with FSC Controlled Wood or PEFC Controlled Source and the FSC or PEFC MIX Credit certificate and/or difference GSoC in acc. to IOS-MAT std's.

Sign	Characteristics	Control standards	Unit	Thickness range (mm) 2,0 - 2,5	> 2,5 - 4,0	> 4,0 - 6,0	> 6,0 - 8,0
B	**Basic panel parameters**						
Mb	HDF quality group of LHDF base board*	TDS of raw board	-	PLUS (Articles: 2058 / 20239 / 20268)			
t	Thickness tolerance	EN 324-1	mm	± 0,2			
lwt	Length/Width tolerance	EN 324-1	mm/m	± 2,0 (max.: ±5,0 mm)			
Sqt	Squareness tolerance	EN 324-2	mm/m	± 2,0			
St	Straightness	EN 324-2	mm/m	max.: 1,5			
D	Density	EN 323	kg/m³	860 (PLUS)			
Dt	Density tolerance	EN 323	%	±7			
Mc	Moisture content	EN 322	w/w %	4,0 – 11,0			
MR	**Resistance against mechanical effects**						
Wr	Wear resistance	MSZ 9929	g/100	≤0,350			
Pht	Pencil tip hardness test	MSZ 9929	-	min.: 3H			
hr	Hit resistance	MSZ 9929	mm	>1 500			
Ad	Adhesion	EN ISO 2409	degrees of change	0 - 2			
HR	**Heat resistance**						
dHr	Dry heat	MSZ 9927	°C	120			
wHr	Wet heat	MSZ 9927	°C	-			
Scr	Resistance against steam and cigarette	MSZ 9927	-	NO resistance			
CR	**Resistance against climate effects**						
UVr	UV radiation (Xenon, 72 hours)	MSZ 9931	level	5			
AAr	Artificial ageing (-20°C, +60°C / 20 cycles)	MSZ 9931	%	100			
Wir	Immersion in water – 24h	MSZ 9640/11	-	No resistance			
SR	**Surface resistance**						
clr	Surface resistance to cold liquids	*EN 12720*	degrees of change	≥4			
sr	Surface resistance to scratching	*EN 12317-2*	N	>1 ≤2			
R7/R4	*Fulfilling requirements concerning surface resistance according to valid IOS-MAT 0066 in accordance with customer's order after agreement with Sales Department.*						
SUR	**Surface requirements**						
Gl	Gloss, brightness, light reflection	Micro Gloss 60°	%	8 - 20			
ΔEi	Colour difference	inside of the table	-	Not allowed			
ΔEst	Colour difference @ Daylight	between sample & etalon	-	ΔE ≤ 2,0 @ uni colours perceptible colour deviation is not allowed @ woodgrains			
Sp	Spots on the (A-side) surface	(Clouded)	-	perceptible colour deviation is not allowed			
da	Shortness of lacquering, damaged edges, faulty, broken edges	visible	-	is not allowed			
Imp	Impressers, Bulging	visible	-	are allowed without any marked outlines per m² max. which are perceptible 5 pieces/m²; 0,1 mm			
Ss	Surface scratch	visible	-	3 pieces per m², at most 0,5 mm wide are allowed. which does not penetrate the design, and their common length are at most 50 cm One scratch should not be longer than 25 cm.			
FE	**Formaldehyde emissions** (Please see the difference GSoC's!)						
GA	Gas Analysis	EN ISO 12460-3:2015	mg/m²h	≤3,5 (E1) Articles: all Basic board PV ≤QCL CARB Phase 2– TSCA/EPA (E-LE)			
CTE	Chamber test-1	EN 717-1:2005	mg/m³	≤0,124 (E1)			
			ppm	≤0,05 Articles: all			
CTG	Chamber test-2	EN 16516:2017	ppm	≤0,1 Articles: all			

* Please, see the TDS of our Raw thin HDF unsanded!
(##): in brackets, the quality concerned … If nothing specified, the parameter values are applicable for all the qualities.

Surface requirements are valid for full board size.
The colour-identification happens according to the Kronospan standards (etalons), customer's decors based on previously signed etalon. In case of both sides lacquered products front (face) side are qualified in according above mentions, the two sides are not the same quality.

Herewith we certify that our lacquered goods (lacquered thin HDF, back panels) comply with EN 622-1 and with EN 622-5 norm Table 3 – Requirements for general purpose boards for use dry conditions.

Recommendations:

HDF should be stored in an area dry, temperate, ventilated and protected from the weather.
If the storage is in an area with a high content of humidity or at low or very high temperatures, the stabilization of the board before its use is recommended (temperature and humidity of the workshop). For specific applications, it is preferable to carry out preliminary tests.

J&M handel aps

J&M Handel Aps ∘ Foldagervej 3-5 ∘ DK 4623 Lille Skensved
Tlf.: 7015 3620 ∘ www.jmhandel.dk ∘ info@jmhandel.dk