Technical Data Sheet

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Raw Thin HDF unsanded

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Applications and uses:

Packaging, FCPM, Door industry, Furniture industry, Lacquering-, Laminating-, Mounting-, Finish foil-, Sandwich panel lines and any special

Characteristics:

Two faces of our RAW BOARD: THIN HDF are unsanded, homogeneous, closed and smooth.

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 and REACH-HCHO (2023/1464 of 14th July 2023 amending Annex XVII to Regulation (EC) No 1907/2006 of the European Parliament and of the Council as regards formaldehyde and formaldehyde releasers – from 07.08.2026) 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 and EUTR/EUDR, PPWR relevant final requirements.

Following qualities can be lacquered with our lacquering line: STANDARD, PLUS, EXTRA. However, the standard lacquered quality that we propose is with "PLUS" base board.

Sign	Characteristics	Control standards	Unit	Thickness range (mm)			
				2,0 - 2,5	> 2,5 - 4,0	> 4,0 - 6,0	> 6,0 - 8,0
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	820 (STANDARD); Articles: 20195 / 20197 / 20203			
				855 (PLUS); Articles: 20258 / 20239 / 20268			
				890 (EXTRA) Articles: 20262 / 20279 / 20288			
Dt	Density tolerance	EN 323	%	±7			
Mc	Moisture content	EN 322	w/w %	4,0 – 11,0			
TSW	Thickness Swelling - 24 h	EN 317	w/w %	45	35	30	17
BS	Bending strength	EN 310	N/mm²	30 (STANDARD)			
				35 (PLUS)	40 (PLUS)		
				40 (EXTRA)	45 (EXTRA)		
MOE	Modulus of elasticity	EN 310	N/mm²	3 000 (STANDARD)			
				3 300 (PLUS)	3 500 (PLUS)	4 000 (PLUS)	
				3 800 (EXTRA)	4 000 (EXTRA)	4 400 (EXTRA)	
IB	Internal Bond	EN 319	N/mm²	0,65 (STANDARD)	0,70 (STANDARD)		0,65 (STANDARD)
				0,75 (PLUS)			
				0,8 (EXTRA)	0,9 (EXTRA)	1,2 (EXTRA)	0,9 (EXTRA)
SS	Surface soundness	EN 311	N/mm²	0,8 (STANDARD)			
				1,0 (PLUS)			
				1,1 (EXTRA)		1,1 (EXTRA)	
Sta	Surface (Toluene) adsorption	EN 382-1	mm	150-300			
A-value	Surface (Water) adsorption	EN 382-2	g/m²	300-600			
Sc	Sand (grit) content	*ISO 3340*	w/w %	max.: 0,05			
HCHO	Formaldehyde content & emissions (Please see the difference GSoC's!)						
GA	Gas analysis	EN ISO 12460-3:2015	mg/m²h	≤3,5 (all) ≤**QCL** (IOS-MAT-0003 v18, v. IOS-MAT-0181 v6), E1-REACH *Articles:* 20197 / 20239 / 20279; 20203 / 20268 / 20288			
CTE	Chamber test-1	EN 717-1:2005	mg/m³	≤0,124 (Articles: all)			
			mg/m³	≤0,062 (REACH, IOS-MAT-0181 v6) [~≤0,050 ppm] (except Articles: 20195, 20258, 20262)			
CTA	Chamber test-3	ASTM E 1333-14 or ASTM D 6007-14	ppm	≤0,13 (CARB Phase 2/ EPA TSCA Title VI - § 770.10) ≤0,08 (IOS-MAT-0003 v18) (except Articles: 20195, 20258, 20262)			

(##): in brackets, the quality concerned … If nothing specified, the parameter values are applicable for all the qualities.

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

Recommendations:

HDF produced by KRONOSPAN-MOFA Hungary Ltd. 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 temperatures or very high, the stabilization of the board before its use is recommended (temperature and humidity of the workshop). If finish foil process is used, we recommend heating the board before the application of the adhesive and the paper. The edges of the full-size board must be sawed (clean cut). For specific applications, it is preferable to carry out preliminary tests.