

# MELAMINE FACED CHIPBOARD PANEL

Chipboard of wood for interior use (type P2 in accordance with standard EN 312) whose sides are covered by a melamine decorative paper through a pressing process. Available on request: FSC, water repellent and fire resistant.



## SURFACE TECHNICAL CHARACTERISTICS\*

RESISTANCE TO ABRASION	EN 14323	Printed Class 1, Unicolour Class 3A
RESISTANCE TO WATER STEAM	EN 14323	≥ Level 4
RESISTANCE TO SCRATCHES	EN 14323	≥ 1,5N
RESISTANCE TO STAINS	EN 14323	Groups 1 and 2, class ≥ 4
RESISTANCE TO LIGHT	EN 14323	≥ 6 grey scale
RESISTANCE TO CRACKS	EN 14323	Class ≥ 3
RESISTANCE TO DRY HEAT	EN 12722	Class B
TENDENCY TO RETAIN DIRT	UNI 9300	Level ≥ 4
SURFACE DEFECTS	EN 14323	Spots: ≤2 mm <sup>2</sup> /m <sup>2</sup> Length: ≤20 mm/m <sup>2</sup>
THICKNESS VS. NOMINAL VALUE**	-	+/-0,3mm



## CHIPBOARD TECHNICAL CHARACTERISTICS

Composition	Wood	Trunks, stems, branches, logs, billets, root collars, fast-growing trees and shrubs, residues from sawmilling, veneer cutting, joinery and carpentry of broad-leaved and coniferous species.	78 - 88%	
	Adhesive	Urea – formaldehyde glue	7 - 9%	
	Additives	Water		5 - 13%
		Ammonium sulfate		0,2%
Paraffin			Traces	
Density	EN 323	500 - 700 Kg/m <sup>3</sup>		
Moisture content	EN 322	5 - 13%		
Formaldehyde content	EN ISO 12460-1	Class E1 < 0,1ppm		
	ASTM E1333-96	CARB (P2) <0,09ppm - TSCA Title VI		
Dimensional tolerances	Thickness vs. nominal value	EN 14323	≤15mm +/-0,2mm >15mm +/-0,3mm	
	Thickness within same panel		+/-0,3mm	
	Length and width		+/-5mm	
Planarity (both sides melamine faced ≥ 15mm)	EN 14323	≤2mm/m		
Fire resistance class	EN 13986	D-s2, d0		

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Nominal values by thickness group	Standard	≥8mm ≤13mm	>13mm ≤20mm	>20mm ≤25mm	>25mm ≤32mm	>32mm ≤40mm	>40mm
Internal bonding N/mm <sup>2</sup>	EN 319	> 0,40	> 0,35	> 0,30	> 0,25	> 0,20	> 0,20
Bending strength N/mm <sup>2</sup>	EN 310	> 12	> 11	> 10,5	> 9,5	> 8,5	> 7
Elasticity modulus N/mm <sup>2</sup>	EN 310	> 1800	> 1600	> 1500	> 1350	> 1200	> 1050
Surface delamination N/mm <sup>2</sup>	EN 311	> 0,8	> 0,8	> 0,8	> 0,8	> 0,8	> 0,8



## ON REQUEST

### WATER REPELLENT MELAMINE FACED CHIPBOARD

Same properties as the standard panel, but with water resistance:

Nominal values by thickness group	Standard	≥8mm <13mm	>13mm <20mm	>20mm <25mm	>25mm <32mm	>32mm <40mm	>40mm
Swelling after immersion in water 24hr (*)	EN317	< 17%	< 14%	< 13%	< 13%	< 12%	< 12%
Tensile strenght after cooking N/mm <sup>2</sup> (*)	EN1087	> 0,09	> 0,08	> 0,07	> 0,07	> 0,06	> 0,06

### FIRE RESISTANT MELAMINE FACED CHIPBOARD

B-s2, d0 EN 13986 EN13501-1

Class B ASTM E84 NFPA 101

### FSC CERTIFIED MELAMINE FACED CHIPBOARD

FSC Mix Credit ICILA-COC-000343



## STORAGE AND HANDLING

Goods must be stored in a dry and ventilated place (relative air humidity 35%-65%). Do not store with inflammable substances. If exposed to direct sunlight, the laminate may deteriorate. Stacks should be stored correctly, at a manageable height to ensure stability. To avoid warping or damp stains, place the panels on pallets with adequate spaces. When handling the laminates, use suction pads or gloves. Machinery and equipment must be fitted with suitable aspiration systems.



## CLEANING & MAINTENANCE

The melamine surfaces are the most resistant among those used in the furniture field. For cleaning, it is preferable to choose a detergent for domestic use. It is recommended that you avoid spraying products directly onto the surface, as this may leave stains and marks; instead, it is preferable to apply the detergent product on a soft damp cloth, clean the surface and then rinse it. Avoid using abrasive products, bleach or highly chlorinated products or acids.

\* Values reported herein are related to a standard product configuration. For customized products please contact our sales office.

\*\* The nominal values of each texture are indicated in the relevant product section of the Cleaf web site

<https://www.cleaf.it/en/prodotti/pannelli/>