



# 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 120                      | Class E1 <8mg/100g   |                               |         |
|  | 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   |                               |         |



# MELAMINE FACED CHIPBOARD PANEL

| Nominal values by thickness group      | Standard | ≥8mm<br>≤13mm | >13mm<br>≤20mm | >20mm<br>≤25mm | >25mm<br>≤32mm | >32mm<br>≤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<br><13mm | >13mm<br><20mm | >20mm<br><25mm | >25mm<br><32mm | >32mm<br><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 95% 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/>