

## Technical data sheet

### PET Laminated MDF High Gloss

Technical characteristics	Unit	Thickness [mm]					Standard	
		>6+9	>9+12	>12+19	>19+30	>30+40		
<b>General requirements</b>								
1	<b>Density</b>	kg/m <sup>3</sup> ± 7%	740	720	710		EN 323	
2	<b>Tolerance of thickness</b>	mm	± 0.2		± 0.3		EN 324-1 EN 622-1	
3	<b>Tolerance on length and width</b>	mm/m	+ 2 mm/m; maximum + 5 mm					EN 324-1 EN 622-1
4	<b>Squareness tolerances</b>	mm/m	2					EN 324-2 EN622-1
5	<b>Edge straightness tolerance</b>	mm/m	1,5					EN 324-2 EN 622-1
<b>General requirements – mechanical properties</b>								
6	<b>Swelling in thickness 24h</b>	%	≤ 17	≤ 15	≤ 12	≤ 10	≤ 8	EN 317 EN 622-5
7	<b>Bending strength</b>	N/mm <sup>2</sup>	≥ 23	≥ 22	≥ 20	≥ 18	≥ 17	EN 310 EN 622-5
8	<b>Modulus of elasticity in bending</b>	N/mm <sup>2</sup>	≥2700	≥2500	≥2200	≥2100	≥1900	EN 310 EN 622-5
9	<b>Internal bond</b>	N/mm <sup>2</sup>	≥ 0.65	≥ 0.60	≥ 0.55		≥ 0.50	EN 319 EN 622-5
10	<b>Formaldehyde release – E1</b>	mg/m <sup>2</sup> h	≤ 3.5					EN 12460-3 EN 622-1
11	<b>Moisture content</b>	%	4 ± 11					EN 322 EN 622-1
12	<b>Bonding strength</b>	N/mm <sup>2</sup>	≥ 0.9					EN 311
<b>Technical characteristics</b>		<b>Unit</b>	<b>Value</b>					<b>Standard</b>
<b>General requirements – Optical properties</b>								
13	<b>Chemical resistance</b>	rate	1 B					DIN EN 12720 DIN 68861/1
14	<b>Resistance against Micro Scratching</b>	%	≤ 25 % alternation of gloss					DIN CEN/TS 16611, Method A

15	<b>Resistance against Scratching</b>	N	≤ 0.5	DIN EN 15186, Method B
16	<b>Resistance against Wet Heat - 70°C</b>	rate	Level 5	DIN EN 12721
17	<b>Resistance against Dry Heat – 70 °C</b>	rate	Level 5	DIN EN 12722
18	<b>Color Consistency (Solid white beige colors)</b>	rate	$\Delta E \leq 0.5$ $\Delta L \pm 0.3$ $\Delta a \pm 0.2$ $\Delta b \pm 0.3$	DIN 53236 (45/0) DIN 6174
19	<b>Gloss level</b> 60° measuring head, measuring crosswise	units	≥ 90	DIN EN ISO 2813
20	<b>Light fastness</b>		≥ 7	DIN EN ISO 4892-2 DIN EN ISO 105 B 02
21	<b>Fault Definition</b>	Optical deviations are regarded as faults if they are recognizable with the naked eye from a distance of 50 cm, within 30 seconds in good lighting		

  
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