


Type: Mirror Gloss according to EN 14322
Wood based panels – Melamine faced boards for interior use

General requirements at delivery according to table 1:

Characteristic	Requirement	Test standard	Unit	Mirror Gloss
Thickness tolerance Laminate thickness Class 1+2	EN 14322	EN 14323	mm	± 0,5
Thickness within the panel $t_{max} - t_{min}$	EN 14322	EN 14323	mm	≤ 1
Length and width Complete format	EN 14322	EN 14323	mm	± 0,5
Flatness Thickness range ≤ 15 mm	EN 14322	EN 14323	mm/m	-
Flatness Thickness range ≥ 15 mm Only with balanced structure of the surface	EN 14322	EN 14323	mm/m	≤ 2
Edge chipping Complete formats	EN 14322	EN 14323	mm	≤ 10
Surface defects - points	EN 14322	EN 14323	mm ² /m ²	≤ 2
Surface defects - length	EN 14322	EN 14323	mm/m	≤ 20
Resistance to scratching *	EN 14322	EN 14323	N	≥ 1.5
Resistance to staining	EN 14322	EN 14323	Grade	≥ 3
Resistance to cracking	EN 14322	EN 14323	Grade	≥ 3
Quality Formaldehyde release	EN 14322	EN 14323	Class	E-LE

Some parameters e.g. changes in temperature or relative humidity with at storage or at the building site, can cause an irreversible warping of panels or elements.

*Resistance to scratching dependent on decoration and structure

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Classification according to table 2:


Characteristic	Requirement	Test standard	Unit	Mirror Gloss
Resistance to surface wear Depending on design UNI-colour	EN 14322	EN 14323	Class	3B
Resistance to surface wear Depending on design Wood and Fantasy decor	EN 14322	EN 14323	Class	1
Resistance to surface wear Depending on design Wood décor abrasion-resistant	EN 14322	EN 438-2	Class	3B

Appendix A – Further characteristics – Table A1:

Characteristic	Requirement	Test standard	Unit	Mirror Gloss
Resistance to cigarette burns	EN 14323	EN 438-2	Grad	1
Resistance to water vapour gloss	EN 14323	EN 438-2	Grad	4
Resistance to water vapour colour	EN 14323	EN 438-2	Grad	3
Resistance to impact Falling steel ball, less diameter	EN 14323	EN 438-2	N (min)	9
Resistance to impact Falling steel ball, large diameter	EN 14323	EN 438-2	mm (min) mm (max)	800* 11**
Lights fastness Xenon arc lamp; Blue wool scale	EN 14322	EN 14323	Nr.	6
Gloss level	EN 14322	EN 14323	Determination of the difference between the reference and the tested sample	
Bonding strength	EN 14322	EN 311	N / mm ²	≥ 0,9

* Drop high

** Diameter of the impression

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Further specifications:

Characteristic		Requirement	Test standard	Unit	Mirror Gloss
Right angled tolerance ; complete formats		DIN 68765 ¹⁾		mm	± 5
Right angled tolerance ; cut-to-size*		DIN 68765 ¹⁾		mm	± 2,5
Dimensional stability under change of climate with 20° C		DIN 68765 ¹⁾	DIN 53799	%	≤ 0,6
Bending strength	Thickness ≤ 13 mm	DIN 68765 ¹⁾	DIN 52362	N / mm ²	17
	Thickness ≥ 13 to 20 mm	DIN 68765 ¹⁾	DIN 52362	N / mm ²	16
	Thickness ≥ 20 to 25 mm	DIN 68765 ¹⁾	DIN 52362	N / mm ²	15
	Thickness ≥ 25 to 32 mm	DIN 68765 ¹⁾	DIN 52362	N / mm ²	13
	Thickness ≥ 32 to 40 mm	DIN 68765 ¹⁾	DIN 52362	N / mm ²	11
Transverse tensile strength	Thickness ≤ 13 mm	DIN 68765 ¹⁾	EN 319	N / mm ²	0,40
	Thickness ≥ 13 to 20 mm	DIN 68765 ¹⁾	EN 319	N / mm ²	0,35
	Thickness ≥ 20 to 25 mm	DIN 68765 ¹⁾	EN 319	N / mm ²	0,30
	Thickness ≥ 25 to 32 mm	DIN 68765 ¹⁾	EN 319	N / mm ²	0,24
	Thickness ≥ 32 to 40 mm	DIN 68765 ¹⁾	EN 319	N / mm ²	0,20
Laminate thickness Class 1**)		DIN 68765 ¹⁾	ÖNORM C 9751	mm	≤ 0,14
Laminate thickness Class 2**)		DIN 68765 ¹⁾	ÖNORM C 9751	mm	≥ 0,14
Resistance to hot pot gloss		-	EN 438-2 ²⁾	Grad	3
Resistance to hot pot colour		-	EN 438-2 ²⁾	Grad	4

¹⁾ Historical standard, data only for information without legal claim.

²⁾ Examination under the title "stability against dry heat".

* Cuts up to 2000 mm of edge (reference: Rough cuts – no final cuts!)

** Coating thickness, dependent on the gross weight of the impregnates and the structures

Modulus of Elasticity: for Standard 19 mm MFB

MFB	Thickness (mm)	Test standard	Unit	Flexural modulus of elasticity
Mirror Gloss	19,1	EN 310	N / mm ²	2840

General reference

As a consequence of the constant improvement of our products, and/or possible changes of the relevant standards and legal requirements, no legal claim can be derived from the data in this product data sheet!