



Standard E1

Product class

P2

Standard reference

EN 312

Producer

SPANO

Solution



Scope

High quality board for interior and furniture industry

Description

Standard chipboard with fine sanded surface and particularly screwable core. Suitable for industrial processing for interior decoration and furniture production. Can be refined with paper, melamine, laminate or lacquer. The board is easy to mill and has low formaldehyde emission (E1 class).

Use of the product

The board must be applied in service class 1 (restrictions in temperature and ambient humidity) and can only be used in biological hazard class 1 of EN 335-3. The boards must be protected from any direct contact with water. They must be stacked flat, on a pallet or using a sufficient number of cross members. Boards should not be stored vertically, unless ground contact can be avoided. The board will expand or shrink under variable humidity conditions. Use suitable sawing, milling and drilling tools.

Dimensions and stock range

Thickness: 6 to 38 mm. Width and length: 2030 - 2100 to 5700 length and 2440 - 2620 to 6300 length. Spano has high-capacity saws that support all sawing dimensions. In principle, all thicknesses and lengths/widths are available within the press capabilities. Contact our agent or mail to sales@spano.be

Stock range

Dimensions Standard	Quantities per pack
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E1													
Thickness	8	10	12	13	14	15	16	18	19	22	25	28	38
125x255	100	90	70		60	60	50	50	45	40	35	30	
125x305	100	90	70		60	60	50	50	45	40	35	30	
131x306							50	50					
207x411								25	25				
122x305,6													12
207x280	50	50		40			30		25	20	20	15	12

Technical specifications

General characteristics + standard	Unit	Average values											
Thickness EN 324-1	mm	8	10	12	15	18	19	22	25	28	38		
Density EN 323	Kg/m ³	730	710	690	660	660	650	650	650	640	640		
Moisture content EN 322	%	6-10	6-10	6-10	6-10	6-10	6-10	6-10	6-10	6-10	6-10	6-10	6-10
Technical characteristics + standard		5/95 Percentile values											
Bending strength EN 310	N/mm ²	13	13	13	13	13	13	11,5	11,5	10	8,5		
Internal bond EN 319	N/mm ²	0,40	0,40	0,40	0,35	0,35	0,35	0,30	0,30	0,25	0,20		
Modulus of elasticity EN 310	N/mm ²	1800	1800	1800	1600	1600	1600	1500	1500	1350	1200		
Surface soundness EN 311	N/mm ²	0,8	0,8	0,8	0,8	0,8	0,8	0,8	0,8	0,8	0,8	0,8	0,8

General specifications

Nº	Property	Test method	Requirement
1a	Tolerances on nominal dimensions	EN 324-1	
	- Thickness (sanded) within and between boards		± 0,3 mm
	- Thickness (unsanded) within and between boards		- 0,3 mm + 1,7 mm
	- Length and width		± 5 mm
2a	Edge straightness tolerance	EN 324-2	1,5 mm per m
3a	Squareness tolerance	EN 324-2	2 mm per m
4	Moisture content	EN 322	5% to 13%
5a	Tolerance on the mean density within a board	EN 323	± 10 %
6b	Formaldehyde release according to EN 13986		
	- Class E 1		
	Perforator value	EN 120	Content ≤ 8mg/100g oven dry board (d)
	Steady state emission value (c)	ENV 717-1	Release ≤ 0,124 mg/m ³ air

(a) These values are characterized by a moisture content in the material corresponding to a relative humidity of 65% and a temperature of 20 °C.

(b) The perforator values apply to boards with moisture contents H of 6,5 %. In the case of particleboards with different moisture content (in the range of 3 % ≤ H ≤ 10 %) the perforator value shall be multiplied by a factor F which can be calculated from the following equation:

$$F = - 0,133 H + 1,86$$

(c) Required for initial type testing other than for established products where initial type testing may also be done on the basis of existing data with EN 120 or ENV 717-1 testing, either from factory production control or from external inspection.

(d) Experience has shown that to ensure compliance with these limits, the rolling average of the EN 120 values found from the internal factory production control over a period of ½ year should not exceed 6,5 mg HCHO/100 g panel mass.

The Standard E1 is, upon request, produced with increased density and low swelling 24 hours under P4.



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