

MELAMINE FACED BOARDS

Melamine faced board

1. Product description

Melamine faced board (SWISS KRONO Laminated particleboard and SWISS KRONO Laminated MDF) is a core board (particleboard or MDF) with surface upgraded by coating with decorative paper impregnated with thermosetting urea and melamine-formaldehyde resins at high temperature and pressure.

Melamine faced board (of type "K") show rather a low abrasion resistance and are unsuitable as work-surfaces.

Types of surface of MFC:

BS – office surface

MX – matrix

OW – one wood

OV – one vision

PE - pearl surface (orange peel)

SM - smooth surface

SE - ash wood surface

VL – mat

CL – synchro lambrusco

SW – synchro elm

SD – synchro oak

2. Application

Melamine faced board is basic material for the production of furniture. It may also be used as structural and decorative material in interior finishing or partition wall construction, in dry rooms.

3. Technical data

	Laminated particleboard	Laminated MDF
Size (mm)	2800x2070* , 5600x2070	2800 x 2070*
Thickness (mm)	8**, 10**, 12**, 15, 16, 18* , 19, 22, 25, 28, 38	6**(HDF), 8**(HDF), 10**, 12**, 16* , 18, 19* , 22, 25, 30***

* standard size and thickness (for MDF only pattern K 110 SM single-sided faced)

** double-sided faced only (other thickness as double-sided and single-sided)

*** single-sided faced only

Physical and mechanical parameters: Standard EN 14322

Property	Unit	Requirement		Test method
		thickness ≤ 20 mm	thickness > 20 mm	
Thickness tolerance	mm	+/- 0,3	+/- 0,5	EN 14323
Length and width tolerance	mm	+/- 5		EN 14323
Flatness	mm/m	≤ 2 (for flat surfaces only)		EN 14323
Surface defects	mm ² /m ²	spot ≤ 2		EN 14323
	mm/m ²	at length ≤ 20		EN 14323
Scratch resistance	N	≥ 1,5		EN 14323
Abrasion resistance	rotations	Class 1 (IP < 50, IP+FP/2 < 150)		EN 14323
Stain resistance	Scales	≥ 3		EN 14323
Crack resistance	Scales	≥ 3		EN 14323
Formaldehyde emission		E1 Class = ED2020		

Important note:

Use a soft, dry or moist cloth for the care and maintenance of laminated boards. Larger dirt can be removed using a solution of washing-up liquid. Then, wipe it with a damp, soft cloth, and keep wiping until it dries. Do NOT use any aggressive cleaning agents (eg solvents) or polishing agents on the laminated surface finish.

4. Certificates

- Hygienic certificate (E1)
- Certificate WKI (ED2020)
- Certification concerning reaction to fire class D-s2,d0
- Certificate confirming antibacterial properties

5. Packaging, storage and transport

Packaging materials:

- lower spacers nailed or glued (of chipboards), 72 mm high
- upper spacers unnailed, thickness 10-20 mm - single
- polyester tape, 16 mm wide
- casing cardboard (overlapping the boards for 100mm)
- lower casing board (made of chipboard or MDF)
- info label.

Warning: The boards should be stored and transported in horizontal position, on a dry and flat surface, in a way preventing them from getting wet or mechanically damaged.

Laminated particleboard:

Thickness	Size 2800 x 2070 mm			
	Number of pieces per pallet	Package height	Pallet gross weight*	Number of pallets per truck
mm	pcs.	mm	kg	pcs.
10	20 / 15	200 / 150	1077 / 800	22 / 30
12	40	480	2037	11
15	30 / 32	450 / 480	1868 / 1982	12 / 12
16	30	480	1954	12
18	27 / 15	486 / 270	1960 / 1139	12 / 21
19	25	475	1906	12
22	25	550	2161	11
25	20	500	1975	12
28	20	560	2134	11
38	15	570	2100	11

* weight tolerance +/-5%

Laminated MDF:

Thickness	Size 2800 x 2070 mm			
	Number of pieces per pallet	Package height	Pallet gross weight*	Number of pallets per truck
mm	pcs.	mm	kg	pcs.
12	40	480	2233	10
16	30	480	2206	10
18	25	450	2075	11
19	25	475	2184	11
22	25	550	2446	9
25	20	500	2235	10
28	20	560	2488	9
30	15	450	2050	11

* weight tolerance +/-5%

6. Laminated board flameproof Stop Fire

A. Name of the product: **SWISS KRONO Laminated particleboard flameproof Stop Fire**

- Application: in public utility buildings as schools, kindergartens, sport halls, shopping centers or hospitals

- Size of board: 2800 x 2070 x **18 mm**

Fire Classification: Euroclass **B-s2,d0** (flameproof)

- The physical and mechanical parameters are the same like for the standard chipboard P2

- Packaging: 15 pc / pallet

B. Name of the product: **SWISS KRONO Laminated MDF flameproof Stop Fire**

- Application: in public utility buildings as schools, kindergartens, sport halls, shopping centers or hospitals

- Size of board: 2800 x 2070 x **16 and 19 mm**

- Fire Classification: Euroclass **B-s1,d0** (flameproof)

- The physical and mechanical parameters are the same like for the standard MDF

- Packaging: 15 pc / pallet

Certificates:

- Hygienic Certificate (E1)
- Certificate WKI (ED2020)
- Classification concerning reaction to fire
- Declaration of Performance – DoP
- Certificate of Conformity CE – HFB
- Certificate confirming antibacterial properties