



MDF Technical Specifications



MDF

Mechanical Properties		Test Method	Unit	Range of thickness (mm)					
				≥ 2.5 - 4	≥ 4 - 6	≥ 6 - 9	≥ 9 - 12	≥ 15 - 18	25
Standard Grade Medium Density Fibreboard (E2)									
Tolerance of Dimension	Thickness	IS 2380 (Part II): 1977	mm	± 0.2					
	Length & Width	IS 2380 (Part II): 1977	mm	+ 2mm (W) / + 5mm (L)					
Squareness		IS 2380 (Part II): 1977	mm/m	< 1.5					
Squareness (diagonal)		IS 2380 (Part II): 1977	mm	< 5					
Average density		IS 2380 (Part III): 1977	kg/m ³	600 - 900	600-900	600-900	600-900	600-900	600-900
Board Moisture		IS 2380 (Part III): 1977	%	5 to 8					
Modulus of Rupture		IS 2380 (Part IV): 1977	N/mm ² (Avg)	28	28	28	28	28	25
Modulus of elasticity in bending		IS 2380 (Part IV): 1977	N/mm ² (Avg)	2800	2800	2800	2800	2800	2500
Internal bond (dry)		IS 2380 (Part V): 1977	N/mm ² (Avg)	0.8	0.8	0.8	0.8	0.8	0.7
Screw Retaining Force	Face	IS 2380 (Part XIV): 1977	N (min)	1500	1500	1500	1500	1500	1500
	Edge	IS 2380 (Part XIV): 1977		1250	1250	1250	1250	1250	1250
Thickness Swelling (2 hour)		IS 2380 (Part XVII): 1977	% (max)	7	7	7	7	7	7
Formaldehyde Emission (E2)	Perforator	BS EN 120	mg/100g	≤ 20					
HMR Grade Medium Density Fibreboard (E2)									
Modulus of Rupture		IS 2380 (Part IV): 1977	N/mm ² (Avg)	28			28	25	
Modulus of elasticity in bending		IS 2380 (Part IV): 1977	N/mm ² (Avg)	2800			2800	2500	
Internal bond (dry)		IS 2380 (Part V): 1977	N/mm ² (Avg)	0.9			0.9	0.8	
Thickness Swelling (2 hour)		IS 2380 (Part XVII): 1977	% (max)	4			4	4	
High Density Fibreboard (HD HMR)									
Average density		IS 2380 (Part III): 1977	kg/m ³	800 - 900					
Thickness Swelling (2 hour)		IS 2380 (Part XVII): 1977	% (max)	4					
Carb TSCA Title VI / E0 Grade - MDF									
Formaldehyde Emission	Small Chamber	ASTM D6007-14	ppm	> 0.11 ppm					



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