

SPECIFICATIONS AND STANDARDS PLAIN MDF BOARDS - INTERIOR GRADE - I

S. No.	Properties	Unit	Interior Grade I
1	Length & Width tolerance	mm/meter	±3.0
2	Thickness tolerance	mm	±0.30
3	Squareness & Edge Straightness tolerance	mm/meter	2.0
4	Density	Kg/m ³	600-900
5	Variation from mean density	%	±10
6	Moisture content	%	5 to 10
7	Variation from mean moisture content (absolute)	%	±3
8	Water absorption (maximum)	%	
	a) After 2 Hours soaking		6.0
	b) After 24 Hours soaking		
9	Linear expansion (swelling in water) (maximum)	%	
	(a) Due to general absorption (24 Hours soaking)		
	i. Thickness		7.0
	ii. Length and Width		0.3
	(b) Due to surface absorption		
	i. Thickness after 2 Hours soaking		4.0
10	Modulus of Rapture (Minimum)	N/mm ²	
	(a) Up to 20.0 mm		
	i. Average		28.0
	ii. Minimum		25.0
	(b) Above 20.0 mm		
	i Average		25.0
	ii. Minimum		22.0
11	Modulus of elasticity (minimum)	N/mm ²	
	(a) Up to 20.0 mm		
	i. Average		2800
	ii. Minimum		2500
	(b) Above 20.0 mm		
	i. Average		2500
	ii. Minimum		2300
12	Tensile strength perpendicular to surface (IB)	N/mm ²	
	(a) Up to 20.0 mm		
	i. Average		0.90
	ii. Minimum		0.80
	(b) Above 20.0 mm		
	i. Average		0.80
	ii. Minimum		0.70
13	Tensile strength perpendicular to surface (IB)	N/mm ²	
	(a) After cyclic test		
	i. Average		0.45
	ii. Minimum		0.40
	(b) After accelerated water resistance test		
	i. Average		0.30
	ii. Minimum		0.25
14	Screw withdrawal strength	N	
	Face		1500
	Edge (for thickness>12.0 mm)		1250