

General requirements for melamine coated boards for indoor use according to EN 14322

Characteristic	Units	Test method	Requirements	
			Thickness range (nominal, mm)	
			< 15	≥15 a 20
				> 20
Tolerance on nominal dimensions: - Thickness according to the nominal value - Thickness on a single board	mm	EN 14323	± 0.3 for classes 1 and 2 ± 0.5 / -0.3 for classes 3a, 3b and 4	± 0.5
			≤0.6	
Length/width: - Trade measures - Cutted to measurement	mm	EN 14323	±5 ±2,5	
Visual Defects				
Edge damages: - Trade measures - Cutted to measurement	mm	EN 14323	≤ 10 ≤ 3	
Appearance defects. Dots	mm ² /m ²	EN 14323	≤ 2	
Appearance defects. Length	mm ² /m ²	EN 14323	≤ 20	
Coverage				
Scratching resistance	N	EN 14323	≥ 1,5	
Stain resistance	Grade	EN 14323	≥ 3	
Cracking resistance	Grade	EN 14323	≥ 3	