

ACRYLIC TECHNICAL SPECIFICATIONS

SPECIFICATION	UNIT	TEST STANDARD	REQUIRED VALUE	RESULTS
RESISTANCE TO DRY HEAT	°C	DIN 68861/T7	75	75
RESISTANCE TO WET HEAT	°C	DIN 68861/T8	70	70
FORMALDEHYDE RELEASE (COATED BOARD)	mg/ m ² h	EN ISO 12460-3	≤1,75 mg/ m ² h (E0 limit)	0,42 mg/ m ² h
BEHAVIOUR TO WATER VAPOUR		AMK	No Changes Visible	No Changes Visible
CHEMICAL RESISTANCE		DIN 68861/T1	No Changes Visible	No Changes Visible
WARPING TOLERANCE	mm		Short Side (1220 mm) ≤ 4 mm Long Side (2880 mm) ≤ 10 mm	Short Side (1220 mm) ≤ 4 mm Long Side (2880 mm) ≤ 10 mm

MDF SPECIFICATIONS

SPECIFICATION	UNIT	TEST STANDARD	REQUIRED VALUE	RESULTS
DENSITY	Kg/m ³	EN 323	16,5 mm : 700 Kg/m ³ +/- 20 kg/m ³ 18 mm S: min.690 Kg/m ³ ± 20 Kg/m ³	690 Kg/m ³
THICKNESS TOLERANCE	mm	EN 324-1 EN 622-1	± 0,20 mm	± 0,20 mm
LENGTH AND WIDTH TOLERANCE	mm/m	EN 324-1 EN 622-1	± 2 mm/m, maximum ± 5 mm	± 2 mm/m, maximum ± 5 mm
SQUARENESS TOLERANCE	mm/m	EN 324-2 EN 622-1	2 mm/m	2 mm/m
TOLERANCE OF SIDE SMOOTHNESS	mm/m	EN 324-2 EN 622-1	1.5 mm/m	1.5 mm/m
INFLATION IN THICKNESS 24 HOURS	%	EN 317 EN 622-5	16-18 mm ≤ 12%	%9
BENDING RESISTANCE	N/mm ²	EN 310 EN 622-5	16-18 mm ≥ 20 N/mm ²	33 N/mm ²
FLEXURAL ELASTICITY MODULE	N/mm ²	EN 310 EN 622-5	16-18 mm ≥ 2200 N/mm ²	3100 N/mm ²
INNER ADHESION	N/mm ²	EN 319 EN 622-5	16-18 ≥ 0,55 N/mm ²	0,62 N/mm ²

MDF SPECIFICATIONS

SPECIFICATION	UNIT	TEST STANDARD	REQUIRED VALUE	RESULTS
FORMALDEHYDE CONTENT	ppm	EPA 40 CFR TSCA Title VI § 770.10 and California Code of Regulations, sections 93120-93120.12 ASTM E 1333-14 ASTM D 6007-14	≤ 0,11 ppm	0,07ppm
FORMALDEHYDE CONTENT	mg/100g	EN 12460-5	≤ 8 mg/100g	E1 CLASS
HUMID CONTENT	%	EN 322 EN 622-1	4 ÷ 11%	%5,70

FOIL SPECIFICATIONS

SPECIFICATION	UNIT	TEST STANDARD	REQUIRED VALUE	RESULTS
THICKNESS	mm	EN ISO 11833-2	HG: 0,65 ± 20% Arkalık: 0,60 ± 20%	HG White: 0,60 mm HG Cw White, Cream, Black, Vizon: 0,70 mm Back Foil White: 0,55 mm Back Foil Antrasit, Cream, Black, Vizon: 0,70 mm
GLOSSINESS (HG)	20°	EN ISO 2813	80	87
UV RESISTANCE (ΔE)	50 hours	TS EN 4892 (1-2-3)	≤ 0.80	HG: 0,23 Back Foil: 0,42
SCRATCH RESISTANCE (HG)	N	ISO 4586-2	≥ 0.5N	2,5 N
SCRATCH RESISTANCE (HG)	H	ISO 15184	≥H	HG: 6 H
SURFACE TENSION (HG, BACK SURFACE)	mN/m	ISO 8296	≥ 38 mN/m	HG: 42 Back Foil: 38
SURFACE ROUGHNESS (HG)	R _a , μm	EN ISO 4288	≤ 0,10 μm	HG: 0,01

RESISTANCE TO STAIN ACCORDING TO DIN68861 TEST METHOD

TEST MATERIAL	TEST WAITING TIME	RATING APPERANCE AFTER TEST	RESULTS
ACIDIC ACID	1 Hour	5	5
SODIUM CARBONATE	2 Minutes	5	5
LIQUID AMMONIA	2 Minutes	5	5
BEVERAGES	16 Hour	5	5
COFFEE POWDER	16 Hour	5	5
CONCENTRATED MILK	16 Hour	5	5
WATER	16 Hour	5	5
ACETONE	10 Second	5	5
OLIVE OIL	16 Hour	5	5
DINING SALT	6 Hour	5	5
CLEANING	1 Hour	5	5

RATING

5	No change
4	There is hardly noticeable change in brightness and color
3	Slight change in brightness and color, no surface deformation
2	There is change in brightness and color, slight deformation on surface
1	There is change in brightness, color and deformation