Inspections

Once a production plant passed the requirements of the classification test, periodical supervision is necessary to confirm and report the accordance of the requirements of the above-mentioned guideline. For this, the review of all quality ensuring methods is necessary.

Frequency and procedure

These inspections will occur twice a year. Cooperation by the producer in all aspects of this inspection is necessary, including:

- Reviewing quality control test records
- Reviewing quality control manual
- Selection of sample panels for emission testing according to existing contract
- Inspection of quality control test method regarding formaldehyde
- Testing of qualified quality control employees

Plant qualification

Main topics:

- Acceptable quality control facilities and personnel (e.g., quality control manual)
- Establishing a quality control test method and facilities (factory production control FPC) including data record
- Classification test (to confirm adherence to the reference method)
Establishing quality control facilities and personnel

- Equipment and facilities shall be calibrated in accordance with the quality control manual
- Equipment calibration records shall be maintained

Establishing a quality control test method for factory production control

The following test methods are permitted for tests under the producers own laboratory for factory production control:

**Reference method**
- Chamber method EN 717-1

**Derived test methods**
- Perforator method EN 120
- Gas analysis method EN 717-2
- Flask method EN 717-3*

* (if an adequate correlation to the reference method is confirmed)

**Classification test**

The material must fulfil the requirements of “Richtlinie über die Klassifizierung und Überwachung von Holzwerkstoffplatten bezüglich der Formaldehydabgabe (DIBt-Richtlinie 100)*, the limit values are represented in table 1.

According to clause 3 “Classification” of DIBt-Guideline 100 in connection with the federal health paper “Bundesgesundheitsblatt” 34, 10 (1991) p. 488-489 the following mentioned methods are required for the classification of wood-based panels: for unfaced particle- and fibreboard classification take place through perforator values specified in EN 120, in addition to the reference method in a chamber. In case of unfaced plywood and faced particleboard classification take place through the gas analysis method according to EN 717-2.

Variant of the above mentioned test methods of classification the wood-based panels, other test methods may applied in accordance with clause 4.6 “Correlation of test methods”. For this tests are required to establish a factor to convert the value (correlation to the reference method).

It is at the manufacturer’s discretion to distinguish the following thickness ranges for the definition of test and assessment groups:
- up to 12 mm,
- more than 12 mm up to 25 mm,
- more than 25 mm up to 40 mm,
- more than 40 mm up to 60 mm,
- more than 60 mm.

1 Chips and chipboard.
2 Fibers and fiber board.
3 Strands and OSB board.