

**Puitplaadid. Proovivõtt, lõikamine ja kontroll. Osa 2:
Esmane tüübikatsetus ja ettevõtte tootmisohje**

**Wood-based panels - Sampling, cutting and inspection -
Part 2: Initial type testing and factory production control**

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN 326-2:2010+A1:2014 sisaldab Euroopa standardi EN 326-2:2010+A1:2014 inglisekeelset teksti.	This Estonian standard EVS-EN 326-2:2010+A1:2014 consists of the English text of the European standard EN 326-2:2010+A1:2014.
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English Version

**Wood-based panels - Sampling, cutting and inspection - Part 2:
Initial type testing and factory production control**

Panneaux à base de bois - Échantillonnage, découpe et
contrôle - Partie 2 : Essai de type initial et contrôle de la
production en usine

Holzwerkstoffe - Probenahme, Zuschnitt und Überwachung
- Teil 2: Erstprüfung des Produktes und werkseigene
Produktionskontrolle

This European Standard was approved by CEN on 7 August 2010 and includes Amendment 1 approved by CEN on 17 July 2014.

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Contents

Page

Foreword.....	4
1 Scope	5
2 Normative references	5
3 Terms and definitions	5
4 Symbols and indices	7
4.1 Letter symbols (see also EN 326-1:1994)	7
4.2 Indices (see also EN 326-1:1994)	8
5 Initial type testing (ITT)	9
5.1 General.....	9
5.2 Initial type testing by variables	9
5.2.1 General.....	9
5.2.2 Sampling of panels	9
5.2.3 Evaluation.....	10
5.3 Initial type testing by attributes.....	11
5.3.1 Sampling	11
5.3.2 Evaluation.....	12
6 Factory production control.....	12
6.1 General.....	12
6.2 Sampling	13
6.2.1 General.....	13
6.2.2 Dimensional tolerances, squareness and edge straightness	13
6.2.3 Other properties assessed as attributes and not included in 6.2.1 or 6.2.2	13
6.2.4 Sampling and cutting of test pieces	13
6.3 Factory production control by variables	13
6.3.1 Characteristics	13
6.3.2 Product types	14
6.4 Control of production	14
6.4.1 General.....	14
6.4.2 Factory production control by variables for batch production	15
6.4.3 Factory production control by attributes for batch production.....	17
6.4.4 Internal records of an established product.....	18
6.5 Initial inspection of factory and factory production control (FPC).....	19
6.6 Continuous surveillance, assessment and approval of the factory production control.....	20
Annex A (informative) Example of initial type testing by variables – Evaluation of bending strength of particleboards (see 5.2).....	21
A.1 Example	21
A.2 Sampling (see 5.1.2)	21
A.3 Test results, records and evaluation (see 5.2.3 and EN 326-1:1994, Clause 7).....	22
Annex B (informative) Factory production control by variables – Example: Batch production (see 6.4.2).....	23
B.1 General.....	23
B.2 Sampling	23
B.3 Testing	23
B.4 Calculation and recording of test results of the first sample	23
B.4.1 Example for the case that the first sample of one panel fulfils the panel characteristic requirement	23

B.4.2	Example for the case that the first sample of one panel does not fulfil the panel characteristic requirement	24
Annex C	(informative) Example of initial type testing attributes - Evaluation of bonding quality of plywood (see 6.4.3.1).....	27
C.1	Example.....	27
C.2	Sampling plan.....	27
C.3	Sampling (see 5.3.1).....	27
C.4	Test data and evaluation of bond shear strength and apparent cohesive wood fibre failure percentage	27
C.4.1	General	27
C.4.2	First sample	27
C.4.3	Second sample	29
C.5	Single sampling plan.....	29
Annex D	(informative) Control of factory production control records - Examples of the determination of differences between factory testing and external testing (see 6.6).....	30
D.1	General	30
D.1.1	Use of unconditioned test pieces	30
D.1.2	Paired testing.....	30
D.2	Example (1): Swelling in thickness tested according to EN 317	31
D.2.1	Sample of example (1).....	31
D.2.2	Control of variability.....	31
D.3	Example (2): Internal bond tested according to EN 319.....	33
D.3.1	General	33
D.3.2	Sample of Example (2)	33
D.3.3	Control of variability.....	33
D.4	Determination of a significant difference between the results from the alternative test procedure and from the standard reference test method.....	34
Annex E	(informative) Example of the calculation of a linear correlation (see 6.6)	36
Annex F	(informative) Example of the determination of a significant difference between the results from the alternative test procedure and from the standard reference test method (see 6.6) in accordance with EN 13986.....	40
F.1	General	40
F.2	Control of variability (see Annex D)	41
F.3	Determination of a significant difference (see Annex D)	42
	Bibliography.....	43

Foreword

This document (EN 326-2:2010+A1:2014) has been prepared by Technical Committee CEN/TC 112 “Wood-based panels”, the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by February 2015, and conflicting national standards shall be withdrawn at the latest by February 2015.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document includes Amendment 1 approved by CEN on 17 July 2014.

This document supersedes ^{A1} EN 326-2:2010 ^{A1}.

The start and finish of text introduced or altered by amendment is indicated in the text by tags ^{A1} ^{A1}.

^{A1} This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association. ^{A1}

A revision of EN 326-2:2000 was necessary in order to adapt this standard to the harmonized European Standard EN 13986:2004.

Compared to EN 326-2:2000 the following main changes have been made:

- a) the procedures of initial type testing as well as of factory production control have been adapted to those specified in EN 13986;
- b) the terminology has been adapted to EN 13986;
- c) the specification requirement of the lower 5 % value or the upper 95 % value, respectively, is also fulfilled, if all single 30 mean values comply with the specification limit;
- d) the procedure of evaluation of linear correlations between test results has been improved.

This standard is one of a series of European Standards dealing with sampling, cutting and inspection of wood-based panels. The other parts of this series are listed in Clause 2 and in the Bibliography.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

1 Scope

This European Standard specifies methods for internal initial type testing (ITT) and internal factory production control (FPC) as well as external control of wood-based panels for their compliance with EN 13986 and other relevant product specifications. However, it may also apply, at the option of the manufacturer, to wood-based panels applied for non-construction purposes.

This European Standard is not applicable for the assessment of compliance with specifications of panels comprised in consignments. In such cases, EN 326-3 applies.

For internal factory production control, if required, methods for the assessment of conformity of batches and of production over longer periods are given.

For external control, if required, methods for the initial inspection of a factory and initial type testing of a product, and for the surveillance of the factory production control, are given.

In the factory production control small test pieces are used. The statistics of evaluation is based on normal distribution.

2 Normative references

A1 The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies. **A1**

EN 326-1:1994, *Wood-based panels — Sampling, cutting and inspection — Part 1: Sampling and cutting of test pieces and expression of test results*

EN 13986, *Wood-based panels for use in construction — Characteristics, evaluation of conformity and marking*

ISO 8258, *Shewhart control charts*

3 Terms and definitions

For the purpose of this document, the terms and definitions given in EN 326-1:1994 and the following apply.

3.1

acceptable quality level

AQL

maximum percentage of non-conforming panels that for the purpose of sampling inspection can be considered satisfactory as a process average

3.2

at random

sampling of panels in such a way that each panel of the inspection lot has an equal chance of being selected, and cutting of test pieces from a single panel in such a way that each part of the panel has an equal chance of being selected as a test piece

3.3

attribute

qualitative panel characteristic which can be taken for a yes or no decision about the conformity of a panel characteristic with the specification requirements