

BIS Specifications: (HDF) Molded Raised high Density fibre Panel doors- Test Parametres and

Sr. No	Test	Requirements of IS :4020
1	Dimensions and Square ness	Length width: ± 5 mm Thickness: ± 1 mm Square ness: 1 mm at a length of 500 mm
2	General Flatness	< 6.0 mm
3	Local Plainness	<0.5 mm
4	Impact Indentation	<0.2 mm
5	Flexure Test	Residual deflection < 1/ 10th of max. Deflection.Max.Deflection < 1/30th of length & < 1/15th of width whichever is less.
6	Edge Loading Test	Max Deflection < 5.0mm Residual deflection <0.5mm Lateral buckling <2.0mm
7	Shock Resistance Test	Should withstand 5 impacts
8	Buckling Test	Initial deflection <50 mm Res. deflection <5.0 mm
9	Slamming Test	100 impact without any damage
10	Misuse Test	Pass
11	Varying Humidity Test	Max departure from plainness <1 mm Recovery to original size > 90 %
12	End Immersion Test	No delamination in one cycle
13	Knife Test	Pass
14	Glue Adhesion Test	Pass
15	Screw withdrawal Resistance	> 1000 N