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**BS EN 326-2:2010+A1:2014**



**BSI Standards Publication**

## **Wood-based panels — Sampling, cutting and inspection**

Part 2: Initial type testing and factory  
production control

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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 - Echantillonnage, 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

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**CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels**

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## 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of an identical text or by endorsement, at the latest by February 2015, and conflicting national standards shall be withdrawn at the latest by February 2015.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 <sup>A1</sup> EN 326-2:2010 <sup>A1</sup>.

The start and finish of text introduced or altered by amendment is indicated in the text by tags <sup>A1</sup> <sup>A1</sup>.

<sup>A1</sup> This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association. <sup>A1</sup>

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.

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## 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