

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