



National Standards Authority of Ireland

IRISH STANDARD

I.S. EN 634-2:2007

ICS 79.060.20

**CEMENT-BONDED PARTICLEBOARDS -
SPECIFICATIONS - PART 2: REQUIREMENTS
FOR OPC BONDED PARTICLEBOARDS FOR
USE IN DRY, HUMID AND EXTERNAL
CONDITIONS**

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EUROPEAN STANDARD
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EN 634-2

February 2007

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Supersedes EN 634-2:1996

English Version

**Cement-bonded particleboards - Specifications - Part 2:
Requirements for OPC bonded particleboards for use in dry,
humid and external conditions**

Panneaux de particules liées au ciment - Exigences - Partie
2 : Exigences pour les panneaux de particules liées au
ciment Portland ordinaire utilisés en milieux sec, humide et
extérieur

Zementgebundene Spanplatten - Anforderungen - Teil 2:
Anforderungen an Portlandzement (PZ) gebundene
Spanplatten zur Verwendung im Trocken-, Feucht- und
Außenbereich

This European Standard was approved by CEN on 13 January 2007.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.



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EN 634-2:2007 (E)

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Foreword

This document (EN 634-2:2007) 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 August 2007, and conflicting national standards shall be withdrawn at the latest by August 2007.

This document supersedes EN 634-2:1996.

The principal modifications introduced by this standard consist of a revision of the product marking requirements, clarification that external control in the factory is carried out according to EN 326-2, and clarification that inspection of an isolated lot of panels may be carried out according to EN 326-3.

This standard is one of a series specifying requirements for cement-bonded particleboards:

- EN 634-1, *Cement-bonded particleboards — Specification — Part 1: General requirements*;
- EN 634-2, *Cement-bonded particleboards — Specifications — Part 2: Requirements for OPC bonded particleboards for use in dry, humid and external conditions*.

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, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

EN 634-2:2007 (E)

1 Scope

This European Standard for cement-bonded particleboards specifies the requirements for particleboards bonded with Ordinary Portland Cement (OPC) for use in dry, humid¹⁾ and external²⁾ conditions. Additional information on supplementary properties for certain applications is also given.

NOTE 1 Boards made with cement other than OPC may comply with this Standard if test values are declared according to EN 13986. However, further parts of EN 634 may be developed in the future to cover other types of cement or other materials.

NOTE 2 Cement-bonded particleboard does not contain any asbestos fibre.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 310, *Wood-based panels — Determination of modulus of elasticity in bending and of bending strength*

EN 317, *Particleboards and fibreboards — Determination of swelling in thickness after immersion in water*

EN 318, *Wood based panels — Determination of dimensional changes associated with changes in relative humidity*

EN 319, *Particleboards and fibreboards — Determination of tensile strength perpendicular to the plane of the board*

EN 320, *Fibreboards — Determination of resistance to axial withdrawal of screws*

EN 321, *Wood-based panels - Determination of moisture resistance under cyclic test conditions*

EN 323, *Wood-based panels — Determination of density*

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

EN 326-2, *Wood-based panels — Sampling, cutting and inspection — Part 2: Quality control in the factory*

EN 634-1, *Cement-bonded particleboards — Specification — Part 1: General requirements*

EN 789, *Timber structures — Test methods — Determination of mechanical properties of wood based panels*

EN 1058, *Wood-based panels — Determination of characteristic values of mechanical properties and density*

EN 1128, *Cement-bonded particleboards — Determination of hard body impact resistance*

ENV 1156, *Wood-based panels — Determination of duration of load and creep factors*

1) Humid conditions are defined in terms of service class 2 of EN 1995-1-1 which is characterized by moisture content in the material corresponding to a temperature of 20 °C and a relative humidity of the surrounding air exceeding 85 % for only a few weeks per year. Boards of this type are suitable for use in biological hazard classes 1 and 2 of EN 335-3.

2) External conditions are defined in terms of service class 3 of EN 1995-1-1. Boards of this type are suitable for use in biological hazard classes 1, 2, 3 and 4 of EN 335-3.

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