



## MEDIUM DENSITY FIBREBOARD

### Regular Density

GoldenEdge Regular Density MDF has excellent strength quality, surface smoothness and stability and superior edge profile. The surface can be painted to achieve a high quality finish and provides a uniform substrate for overlaying. GoldenEdge Regular Density MDF can be worked easily with all conventional woodworking machines and hand tools. Tungsten carbide cutters and saws are recommended.



### Applications, uses, installation & finishing

Physical Properties (Metric)  
Behaviour in use - 9 & 18mm thicknesses

Property	Unit	Min Value	Mean Value	Max Value
Density	kg/m <sup>3</sup>	690	725	-
Internal Bond	kPa	700	960	-
Modulus of Rupture	MPa	34.0	44.0	-
Modulus of Elasticity	MPa	2400	3000	-
24 Hour Thickness Swell	%			
- 18mm		-	4.7	5.6
- 9mm		-	9.0	11.1
Moisture Content	%	6.0	8.0	11.0

Physical Properties (Imperial)  
Behaviour in use - 9 & 18mm thicknesses

Property	Unit	Min Value	Mean Value	Max Value
Density	lb/ft <sup>3</sup>	43.0	45.2	-
Internal Bond	psi	102	139	-
Modulus of Rupture	psi	4930	6380	-
Modulus of Elasticity	psi x10 <sup>3</sup>	348	435	-
24 Hour Thickness Swell	%			
- 18mm	%	-	4.7	5.6
- 9mm		-	9.0	11.1
Moisture Content	%	6.0	8.0	11.0

#### Sheet Sizes (mm)

Thickness	Sheet Size
9mm	2440x1220*
12mm	2440x1220
16mm	2440x1220
18mm	2440x1220

\* 2400 x 1200 is a standard size for 9mm  
Oversize product (2465x1245) is available ex mill on request.

#### Sheet Tolerances (mm)

Thickness	±0.15
Length and Width	±1.60
Squareness (maximum difference between diagonals)	3.00
Straightness (maximum deviation from line)	1.60

### Applications, uses, installation & finishing

**Laminating:** GoldenEdge is an ideal substrate for laminating with natural wood veneer, vinyls, printed papers, foils and melamine papers. A balanced laminated panel would eliminate minor cupping or bowing. Care must be taken to avoid conditions of very high press pressure, high press temperature and long press times during laminating.

**Screw Holding:** GoldenEdge provides good screw holding strength both in the faces and edges. The best results are obtained with the parallel thread screws such as the Twinfast or particle board screws. Conventional wood screws are not recommended.

**Screw Gauge:** The choice of screw gauge should be decided in relation to board thickness. The maximum screw gauge when edge fixing into GoldenEdge is:

Board Thickness	Maximum Screw Gauge
9	5
12	6
16	7
18	8

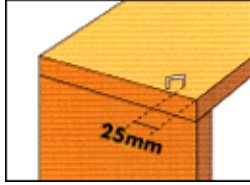
**Pilot Hole:** A pilot hole is recommended to avoid splitting during edge screw fixing.

Screw Gauge	Recommended Pilot Hole
4	2.0mm
5	2.4mm
6	2.6mm
7	2.7mm
8	3.0mm
9	3.3mm

**Screw Position:** The position of screws inserted into the faces and edges of MDF should be decided in relation to board thickness and screw size. Screws inserted into the edges should be not less than 25mm from the corners and must not be overtightened.

**Stapling:** Staples can be used effectively for joint fitting. For best results it is helpful to add adhesive to the joint prior to assembly.

When stapling into GoldenEdge MDF, it is important to have good control of air pressure to avoid excessive penetration of staples. For nailing use either annular, groove or helical nails of 13 or 14 gauge, for best results.



<b>MDF</b>	9mm	12mm	16mm	18mm
<b>Staple</b>	20mm	20-25mm	32mm	36mm

**Do not staple within 25mm of edge of board. Offset staple to edge of board.**

**Nailing:** GoldenEdge MDF can be fixed by nailing with good holding power and no split out when the following conditions are met:

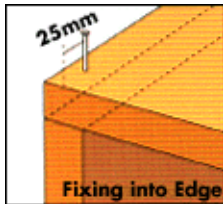
### 1. Types of Nails

Use either annular grooved or helical (spiral) nails. Annular grooved nails are manufactured by CMI Industries Limited.

### 2. Nail Sizes

Use only 13 or 14 gauge nails. These give best results with good holding power in 16mm and 18mm GoldenEdge MDF. The length of nail should not exceed 50mm.

### 3. Distance from the Corner



Nails must be at least 25mm from the corner of the MDF panel.

4. Nailing at a slight angle will further increase the holding power.
5. Nailing is not recommended to the edges of 9mm and 12mm MDF (screwing is recommended).
6. Air gun pressure should be adjusted to ensure that the nail head finishes level with the surface of the panel.

**Sanding and Finishing:** Special attention to sanding edges gives excellent results. Use 120 grit paper followed by 240 or 320 grit paper.

**Stopping:** Stop all nail and staple holes with a proprietary plastic wood putty. Match and blend colours as required to suit. Lightly sand with 320 grit paper.

**Painting:** For best results application of three coats is recommended.

First coat primer/undercoat is critical to the final finish. It is recommended that primer/undercoat is applied to paint manufacturer's recommendations. Apply second and third coats or additional coats as required. A light sand using 280 to 320 grit paper is recommended after the first coat and between subsequent coats.

