

LLL-B-800B  
August 20, 1974  
SUPERSEDING  
Fed. Spec. LLL-B-800A  
May 15, 1965

FEDERAL SPECIFICATION

BUILDING BOARD (WOOD PARTICLE BOARD)  
HARD PRESSED, VEGETABLE FIBER

This specification was approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.

1. SCOPE AND CLASSIFICATION

1.1 Scope. This specification covers mat formed particleboard for interior or exterior use as specified or as core material to be overlaid with other material.

1.2 Classification. Mat-formed particle board covered by this specification shall be of the following types as specified, (see 6.2).

- Type I - Mat-Formed particleboard (generally made with ureaformaldehyde resin binders) suitable for interior applications.
- Type II - Mat-Formed particleboard made with durable and highly moisture and heat resistant binders (generally phenolic resins) suitable for interior and certain exterior applications.

2. APPLICABLE DOCUMENTS

2.1 The following documents, of the issues in effect on the date of invitation for bids or request for proposal, form a part of the specification to the extent specified herein:

Federal Standard:

Fed. Std. No. 123 - Marking for Domestic Shipment (Civil Agencies).

(Activities outside the Federal Government may obtain copies of Federal Specifications, Standards, and Handbooks as outlined under General Information in the Index of Federal Specifications and Standards and at the prices indicated in the Index. The Index, which includes cumulative monthly supplements as issued, is for sale on a subscription basis by the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.

(Single copies of this specification and other Federal Specifications required by activities outside the Federal Government for bidding purposes are available without charge from Business Service Centers at the General Services Administration Regional Offices in Boston, New York, Washington, DC, Atlanta, Chicago, Kansas City, MO, Fort Worth, Denver, San Francisco, Los Angeles, and Seattle, Washington.

(Federal Government activities may obtain copies of Federal Specifications, Standards, and Handbooks and the Index of Federal Specifications and Standards from established distribution points in their agencies.)

Military Standards:

MIL-STD-105 - Sampling Procedures and Tables for Inspections by Attributes.  
MIL-STD-129 - Marking for Shipment and Storage.

(Copies of Military Specifications and Standards required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

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2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless a specific issue is identified, the issue in effect on date of invitation for bids or request for proposal shall apply.

U.S. Department of Commerce Commercial Standard:

CS236 - Mat-Formed Wood Particleboard.

American Society for Testing and Materials (ASTM) Standard:

D1037 - Evaluating The Properties of Wood-Base Fiber and Particle Panel Materials.

3. REQUIREMENTS

3.1 Material. Particleboards shall be manufactured from lignocellulosic materials primarily in the form of discrete pieces or particles, as distinguished from fibers, combined with a synthetic resin or other suitable binder and bonded together under heat and pressure in a hot-press by a process in which entire inter-particle bond is created by the added binder, and to which other materials may have been added during manufacturer to improve certain properties. Type I and Type II particleboard shall meet the requirements of CS236 as specified (see 4.4.1).

3.1.1 Surface finish. The surface of particleboard panels shall be furnished in a sanded (surfaced) or unsanded (unsurfaced) condition on both faces of the panels, as specified (see 6.2). When specified (see 6.2), panels shall be filled for painting, sealed for painting, or primed for additional painting on one side or both surfaces.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the supplier may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure that supplies and services conform to prescribed requirements.

4.2 Sampling.

4.2.1 Lot. Unless otherwise specified (see 6.2), a lot shall consist of all boards of the same size offered for delivery at the same time.

4.2.2 Visual and dimensional examination. Sampling for this examination shall be in accordance with level S-4 in MIL-STD-105. The acceptable quality level (AQL) for defects listed in table I shall be 2.5 percent defective for major defects, and 6.5 percent defective for minor defects.

4.2.3 Sampling for tests. Sampling for tests shall be in accordance with inspection level S-4 in MIL-STD-105, for all boards.

4.3 Examination.

4.3.1 End item. Samples selected in accordance with 4.2.2 shall be examined for defects listed in table I.

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TABLE I. Classification of defects

Defects	Major	Minor
Thickness, width or length not as specified.....	X	
Corners of panels not square.....	X	
Edge of panels not straight.....	X	
Voids greater than 1/8 inch in length.....	X	
Corners or edges of panels crushed.....	X	
Surface finish not as specified.....	X	
Marking for density and CS number illegible, incomplete or incorrect.....		X
Damage or defects not affecting function or serviceability.		X
Steel straps missing.....		X
Bulging or distortion of containers.....		X
Markings omitted, incorrect or illegible.....		X

#### 4.4 Test methods.

4.4.1 Test procedure. Particleboard physical properties shall meet the requirements of CS236 and shall be determined in accordance with ASTM D1037 as specified (see 3.1).

#### 5. PREPARATION FOR DELIVERY

5.1 Packing. The particleboard shall be packed and marked in accordance with MIL-W-3448. Level of packing shall be level A or level C in accordance with MIL-W-3448 as specified (see 6.2).

5.2 Marking. Marking shall be in accordance with 5.2.1 or 5.2.2 as specified (see 6.2).

5.2.1 Civil agencies. In addition to any special marking required by the contract or order, all markings shall be marked in accordance with Fed. Std. No. 123.

5.2.2 Military agencies. In addition to any special marking required by the contract or order, packages and shipping containers shall be marked in accordance with MIL-STD-129.

#### 6. NOTES

6.1 Intended use. Particleboard panels are intended for interior use only as a core material for the top sides, and door fronts of furniture such as desks and cabinets. It is also used for folding and other types of doors. Panels with or without over laid material are used for shelving. Particleboard may also be used as a leveling course and to provide a smooth surface under floor covering materials.

6.2 Ordering data. Purchasers should select the preferred options permitted herein, and include the following information in procurement documents:

- (a) Title, number, and date of this specification.
- (b) Surface finish (see 3.1.1).
- (c) Dimensions required (see 3.2).
- (d) Selection of applicable level of packing and marking required (see 5.1).

6.3 Size. Particleboard is usually made 4 feet wide by 8 feet long, or larger panels, and may be cut to smaller sizes. Thickness range from 1/8 to 2 inches with an allowable tolerance of plus or minus 0.010 inches from the nominal thickness.

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MILITARY INTEREST

Custodians:

Army - ME  
Navy - MD  
Air Force - 84

Review activities:

Army - ME  
Navy - SA  
Other - NSA

Military Coordinating Activity:

Army - ME

Preparing activity:

GSA-FSS

Civil Agency Coordinating Activity:

COMMERCE-NBS  
GSA-FSS  
HEW-FEC  
VA-DMS

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Orders for this publication are to be placed with General Services Administration, acting as an agent for the Superintendent of Documents. See Section 2 of this specification to obtain extra copies and other documents referenced herein. Price 25 cents each.