

**AMENDMENT NO. 1 AUGUST 2024**

**TO**

**IS 2191 (PART 2) : 2022 WOODEN FLUSH DOOR SHUTTERS (CELLULAR,  
HOLLOW AND TUBULAR CORE TYPE) — SPECIFICATION**

**PART 2 PARTICLE BOARD, HIGH DENSITY FIBRE BOARD, MEDIUM DENSITY  
FIBRE BOARD AND FIBRE HARDBOARD FACE PANELS**

*( Fourth Revision )*

*(Page 1, clause 1)* — Insert the following at the end:

‘NOTES

**1** This standard also covers hollow core flush door shutters having paper and/or metal honeycomb panels in between stiles and rails.

**2** The requirements given in this standard are in addition or alternate to IS 2191 (Part 1).’

*(Page 2, Table 1)* — Substitute the following for the existing:

**‘Table 1 Designation of Wooden Flush Door Shutters, (Cellular, Hollow and Tubular Core Type) with  
Particleboard, HDF, MDF, and Fibre Hardboard Face Panels**

*[Clauses 4.2 and 13.1(c)]*

<b>Sl No.</b>	<b>Core</b>	<b>Type</b>	<b>Abbreviation</b>
(1)	(2)	(3)	(4)
i)	Cellular	Decorative with skins of any type of face panels mentioned in <b>6.3.3</b> .	C D P V
		Non-decorative with skins of particle board/MDF/HDF/fibre hardboard unveneered.	C N P
		Non-decorative with skins of particle board/HDF/MDF/fibre hardboard veneered with commercial veneers.	C N P V
ii)	Hollow	Decorative with skins of any type of face panels mentioned in <b>6.3.3</b> .	H D P V
		Non-decorative with skins of particle board/MDF/HDF/fibre hardboard unveneered.	H N P
		Non-decorative with skins of particle board/HDF/MDF/fibre hardboard veneered with commercial veneers.	H N P V
iii)	Tubular	Decorative with skins of any type of face panels mentioned in <b>6.3.3</b> .	T D P V
		Non-decorative with skins of particle board/MDF/HDF/fibre hardboard unveneered.	T N P
		Non-decorative with skins of particle board/HDF/MDF/fibre hardboard veneered with commercial veneers.	T N P V

**Price Group 1**

## Amendment No. 1 to IS 2191 (Part 2) : 2022

(Page 4, clause 6.3.3) — Substitute the following for the existing:

‘For C D P V, H D P V and T D P V types of flush door shutters, face panel of particle board, MDF board, HDF board and fibre hardboard with decorative faces of PVC (poly vinyl chloride) foils or other type of foils (as agreed between the manufacturer and the purchaser) or ABS (acrylonitrile butadiene styrene) sheets, shall pass 1H of pencil hardness test as per Annex C to IS 17637. Face panel of prelaminated MDF or HDF shall meet the requirement of abrasion resistance Type IV of IS 14587. Face panels with any decorative laminates (as agreed between the manufacturer and the purchaser) and CPL (continuous pressed laminates) shall meet the requirements of type VLS of IS 2046.’

(Page 4, clause 6.4, line 1) — Substitute ‘infill board/core’ for ‘core’.

(Page 4, clause 6.5) — Substitute the following for the existing:

### ‘6.5 Infill Board

The swelling in thickness in 2 h of the particle board, MDF board and HDF board for core when tested in accordance with IS 2380 (Part 17) shall not exceed 5 percent.’

(Page 4, clause 7.2) — Substitute the following for the existing:

‘The face panel shall be formed by gluing by hot or cold or high frequency press process on faces of the particle board or HDF board or MDF board or fibre hardboard with/without decorative laminate or PVC (poly vinyl chloride) or other type of foils (as agreed between the manufacturer and the purchaser) or CPL (continuous pressed laminates) or ABS (acrylonitrile butadiene styrene) sheet. The combined thickness of the face panels shall not be less than 3 mm in the case of cellular or tubular core flush doors and not less than 6 mm thick in the case of hollow core flush doors.’

(Page 6, Annex A) — Insert the following at proper place in ascending order:

<i>‘IS No.</i>	<i>Title</i>
IS 2046 : 1995	Decorative thermosetting synthetic resin bonded laminated sheets specification ( <i>second revision</i> )
IS 17637 : 2021	Performance requirements of surface finishes for furniture applications’.