

**SURFACE QUALITY - according to EN13017-1**

Surface quality grade and product characteristics				
No.	CHARACTERISTICS	V (visible)	I (industrial)	N (non-visible)
1	Appearance grade	A/B	B/B; B/C	C/C
2	Mixture of species	not permitted	not permitted with spruce; or 10% of fir, is permitted if evenly distributed	permitted
3	Bonding	occasional open joints up to max. 1 mm width permitted	occasional open joints up to max. 2 mm width permitted	occasional open joints up to max. 3 mm width permitted
4	Blue stains	not permitted	slight discolouration permitted	permitted
5	Discolorations (brown stains, etc.)	slight discolouration permitted	slight discolouration permitted	permitted
6	Texture	coarse texture permitted	coarse texture permitted	permitted
7	Resin galls	A/B single up to 3 x 50 mm permitted	single up to 5 x 50 mm permitted	permitted
8	Bark ingrowth	A/B occasional occurrences permitted	occasional occurrences permitted	permitted
9	Dry cracks / Fissures	occasional surface cracks permitted	50 mm in length permitted	permitted
10	Core – pith	occasional, up to 400 mm long permitted	permitted	permitted
11	Insect damage	not permitted	not permitted	some small worm holes permitted if worms are inactive
12	Knots – sound	no knot clusters; permitted spruce up to 20-40 mm Ø, pine up to 35-60 mm Ø	permitted	permitted
13	Knots – black	single max. 15 mm Ø	single max. 30 mm Ø	permitted
14	Knots – hole	max. 10 mm Ø	max. 20 mm Ø	permitted
15	Quality of edges and ends of panel	blemishes not permitted	single blemishes up to 5 mm permitted	max. 2 mm x 50 mm
16	Surface	100% sanded	100% sanded	no requirements
17	Quality of surface finish	occasional small faults permitted	occasional small faults permitted	small faults permitted
18	Quality of narrow side bonding and face ends	occasional small faults permitted	occasional faults permitted	occasional faults permitted
19	Rework edge with sandpaper	yes	no	no
20	Machining – chainsaw	not permitted	permitted	permitted
21	Lamella width	min. 100mm	min. 100mm	min. 100mm
22	End joints	finger joints	finger joints	finger joints
23	Wood moisture	max. 14%	max. 14%	max. 14%

  

<b>V - Visible quality</b> 	<b>I - Industrial Visible quality</b> 	<b>N - Non-Visible quality</b> 
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