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**INTERNATIONAL STANDARD**



**5321**

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INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

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## **Coniferous wood raw parquet blocks — General characteristics**

*Frises brutes en bois résineux pour parquets — Caractéristiques générales*

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**Descriptors :** wood products, wood floors, parquet blocks, coniferous timber, specifications, dimensions, sampling, quality control, designation, delivery, marking.

Price based on 3 pages

## FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 5321 was developed by Technical Committee ISO/TC 99, *Semi-manufactures of timber*, and was circulated to the member bodies in July 1976.

It has been approved by the member bodies of the following countries :

Brazil	Hungary	Romania
Bulgaria	India	South Africa, Rep. of
Canada	Ireland	Spain
Czechoslovakia	Korea, Rep. of	Yugoslavia
France	Mexico	
Germany	Norway	

No member body expressed disapproval of the document.

# Coniferous wood raw parquet blocks – General characteristics

## 1 SCOPE

This International Standard specifies the manufacturing characteristics and the dimensions, the tolerances, the methods for quality control and the delivery conditions, the measurement and the marking of coniferous wood raw parquet blocks.

The classification of raw parquet blocks according to specific characteristics and wood defects is established, for the different species of wood, in the relevant International Standards.

## 2 FIELD OF APPLICATION

This International Standard applies to raw parquet blocks intended for the manufacture of strips for different types of parquet flooring.

## 3 REFERENCES

ISO 2036, *Wood for manufacture of wood flooring – Symbols for marking according to species.*

ISO 3130, *Wood – Determination of moisture content for physical and mechanical tests.*

ISO 5323, *Solid wood parquet and raw parquet blocks – Vocabulary*<sup>1)</sup>.

## 4 MATERIALS, DESIGN AND MANUFACTURE

4.1 Raw parquet blocks shall have the faces and the edges flat and parallel two by two.

Adjacent faces and edges shall form parallel sharp arrises.

4.2 The arrises of the ends shall be perpendicular to the lateral arrises of the parquet block faces.

## 5 REQUIRED CHARACTERISTICS

### 5.1 Dimensions

TABLE 1

Values in millimetres

Designation	Nominal dimensions at 20 % moisture content <sup>1)</sup>	Safety oversize <sup>2)</sup>	Tolerances
Thickness	25 (24)	–	+ 2 0
Width	40 to 140 varying by steps of 10	2	+ 2 0
Length	250 to 850 varying by steps of 50 900 to 1 400 varying by steps of 100 1 500 and more varying by steps of 300 (250)	20	+ 10 0

1) For higher moisture contents, these dimensions will be appropriately increased.

2) In addition to the increments resulting from excess of moisture.

### 5.2 Squareness of ends

A minimum slope of 2 % shall be allowed for the squareness of ends.

### 5.3 Moisture

Unless otherwise agreed upon between the interested parties, the moisture content of raw parquet blocks at delivery shall be not more than 23 % on dry mass.

1) In preparation.

**6 SAMPLING**

**6.1** The inspection of the characteristics of raw parquet blocks shall be carried out in compliance with the requirements set down below, on pieces of which the representative sample is composed, taken from the batch.

**6.2** Unless otherwise agreed upon between the interested parties, a batch of raw parquet blocks is an assembly of raw parquet blocks of the same wood species, nominal thickness and grade, presented in a single delivery for inspection.

A sample shall be taken from each batch.

**6.3** The sample consists of a number of raw parquet blocks, taken at random from the batch; the number of raw parquet blocks in a sample shall be at least that specified in table 2.

TABLE 2

Number of pieces in the batch	Number of pieces in the sample	Permitted number of rejected pieces in the sample
up to 300	35	2
from 301 to 500	50	3
from 501 to 800	75	4
from 801 to 1 300	110	6
from 1 301 to 3 200	150	8
from 3 201 to 8 000	225	11
from 8 001 to 22 000	300	14
from 22 001 to 110 000	450	20
from 110 001 to 550 000	750	31
over 550 000	1 500	56

**6.4** When the number of rejected raw parquet blocks does not exceed the number specified in table 2, the batch is accepted. Otherwise, the batch shall be regrouped and presented for a new inspection.

**7 INSPECTION METHODS**

**7.1** All the raw parquet blocks making up a sample shall be inspected individually.

**7.2** The dimensions and the squareness of ends to the lateral arrises of faces shall be checked with measuring instruments capable of recording to the prescribed degree of accuracy, the measurements being carried out at least at two points.

No dimension shall lie outside the tolerances specified in clause 5.

**7.3** The flatness shall be checked by the application of one of the raw parquet block faces on a perfectly flat surface and by measuring the deviations with appropriate measuring instruments.

**7.4** The dimensions of defects shall be measured with appropriate measuring instruments.

**7.5** Non-measurable defects and the appearance shall be visually examined.

**7.6** The moisture content should be determined by an electrometric method.

NOTE — In the case of disagreement, the moisture content shall be determined by the gravimetric method specified in ISO 3130.

**8 DESIGNATION**

Raw parquet blocks shall be designated by stating successively :

- the symbol of wood species according to ISO 2036;
- the dimensions (thickness x width x length) expressed in millimetres;
- the grade;
- the number of the International Standard referring to the respective species of wood.

Example of designation of fir raw parquet blocks, 24 mm thick, 50 mm wide and 400 mm long, first grade :

ISO 5321:1978 ABIA — 24 x 50 x 400 — I ISO 5333

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**9 DELIVERY**

**9.1 Packaging**

**9.1.1** When the raw parquet blocks are delivered in bundles, they shall, unless otherwise agreed upon between the interested parties, be of the same wood species, dimensions (thickness, width, length), and grade, and be bound in bundles of 10 or more, by multiples of 10.

**9.1.2** The bundles shall be tightly bound at their ends with strong and durable bonds (metal wire or strip, plastics or other similar materials).

**9.1.3** The bundles of raw parquet blocks may be transported on pallets or in containers.

**9.2 Moisture**

The moisture content of raw parquet blocks at delivery shall correspond to the provisions of 5.3.

**9.3 Measurement**

The volume shall be calculated on the basis of the nominal dimensions and shall be expressed in cubic metres, to three decimal places. The oversizes for dimensions specified in 5.1 shall not be taken into account.

**10 MARKING**

**10.1** Unless otherwise agreed upon between the interested parties, the marking of raw parquet blocks at delivery from the works is obligatory.

**10.2** The marking shall be carried out legibly by applying a stamp with a water-proof and slightly penetrating product to one of the sides of the bundle or to each unit of the load.

It is obligatory that the stamp contain the items in clause 8.

**10.3** On the purchaser's request, the indication of the country of origin and the trade mark may be inscribed in addition to the indications specified in clause 8.

**10.4 Example** of marking of fir raw parquet blocks, 24 mm thick, 50 mm wide and 400 mm long, first grade, manufactured in Romania, by CPL :

**ABIA**  
**24 × 50 × 400**  
**I**  
**RO – CPL**  
**ISO 5333**

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