



SLOVENSKI STANDARD

SIST EN 635-1:1996

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Vežan les - Klasifikacija po videzu površine - 1. del: Splošno

Plywood - Classification by surface appearance - Part 1: General

Sperrholz - Klassifizierung nach dem Aussehen der Oberfläche - Teil 1: Allgemeines

Contreplaqué - Classification selon l'aspect des faces - Partie 1: Généralités

Ta slovenski standard je istoveten z: **EN 635-1:1994**

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ICS:

79.060.10 Vežan les Plywood

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EUROPEAN STANDARD

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English version

**Plywood - Classification by surface appearance -
Part 1: General**Contreplaqué - Classification selon l'aspect
des faces - Partie 1: GénéralitésSperrholz - Klassifizierung nach dem Aussehen
der Oberfläche - Teil 1: Allgemeines**(standards.iteh.ai)**[SIST EN 635-1:1996](https://standards.iteh.ai/catalog/standards/sist/4f89d5b3-819f-4a4b-b08e-f5d1ccb34cb7/sist-en-635-1-1996)<https://standards.iteh.ai/catalog/standards/sist/4f89d5b3-819f-4a4b-b08e-f5d1ccb34cb7/sist-en-635-1-1996>

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CENEuropean Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

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Foreword

This European Standard was prepared by Working Group 2 "Plywood" (Secretariat: France) of Technical Committee CEN/TC 112 "Wood-based panels" (Secretariat: Germany).

This standard is one of a series of standards for the classifications of plywood by surface appearance. The other parts of this series are listed in clause 2 and annex A.

The text is based on ISO 2426 which has been elaborated with European participation.

No existing European Standard is superseded.

This European Standard shall be given the status of a National Standard, either by publication of an identical text or by endorsement, at the latest by June 1995, and conflicting national standards shall be withdrawn at the latest by June 1995.

In accordance with the common CEN/CENELEC Rules, the following countries are bound to implement European Standard:

Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, United Kingdom.

1 Scope

This part of EN 635 establishes general rules for the classification of plywood by its surface appearance. It does not apply to overlaid plywood.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard, only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 635-2 Plywood - Classification by surface appearance - Part 2: Hardwood

EN 635-3 Plywood - Classification by surface appearance - Part 3: Softwood

3 Classification by surface appearance

3.1 Classes

Classification of plywood by surface appearance is made according to both the number and the extent of certain natural characteristics of wood and the defects that come from the manufacturing process.

Five appearance classes are distinguished, identified with the following codes: E, I, II, III, IV.

3.2 Characteristics and defects taken into consideration

Determination of the appearance class, based on the appearance of the panel surfaces, shall take into account the categories of characteristics given in 3.2.1 and defects given in 3.2.2.

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3.2.1 Characteristics inherent in wood

Category	Type
3.2.1.1 Pin knots	
3.2.1.2 Sound intergrown knots	
3.2.1.3 a) Unsound knots b) Non-adhering and partially adhering knots c) Holes, except those due to insects, borers and parasitic plants	1 Dog holes 2 Knot holes
3.2.1.4 a) Splits b) Checks	1 Open 2 Closed
3.2.1.5 Abnormalities due to insects, marine borers and parasitic plants	1 Small worm holes 2 Large worm holes 3 Marine borer holes 4 Marks from parasitic plants
3.2.1.6 a) Resin pockets b) Resin streaks c) Inbark	
3.2.1.7 Irregularities in the structure of the wood ¹⁾	1 Angle grain 2 Curly grain 3 Interlocked grain 4 Spiral grain
3.2.1.8 Discoloration which is not wood destroying	1 Blue stain, mould and fungal discoloration 2 Coloured sapstain 3 False heartwood 4 Other discoloration such as chemical stain and colour streaks
3.2.1.9 Fungal decay which is wood destroying	Rot
3.2.1.10 Other characteristics	To be considered under the category which they most closely resemble
1) When irregularities of grain result in roughness, these shall be considered as one category of characteristics.	

3.2.2 Manufacturing defects

Category	Type
3.2.2.1 Open joints	
3.2.2.2 Overlaps	
3.2.2.3 Blisters	
3.2.2.4 a) Hollows b) Imprints c) Bumps	
3.2.2.5 Roughness, other than that due to irregularities in the structure of the wood	
3.2.2.6 Sanding through	
3.2.2.7 Glue penetration	
3.2.2.8 Foreign particles	Metal, mineral, ...
3.2.2.9 Repairs	1 Patches 2 Shims 3 Synthetic fillers
3.2.2.10 Defects at the edges of the panel	1 Sanding defects 2 Sawing defects 3 Missing wood
3.2.2.11 Other defects	to be considered under the category which they most closely resemble

3.3 Classification by appearance of panels

The appearance class of plywood is determined by the classes of its surfaces.

The class of the plywood first describes the class of the face followed by the class of the back.

4 Rules for classification

4.1 Classification for hardwood and softwood

The permissible characteristics and defects for each of these appearance classes of this European Standard are specified in Part 2 for hardwood and in Part 3 for softwood.

4.2 Conditions of admissibility for inherent characteristics of wood, and manufacturing defects

4.2.1 General

Characteristics and defects which are limited in number, size, or extent, are either enumerated, or evaluated over the total surface of the panel. This number or extent is expressed per square metre of panel, with the exception of checks, splits and open joints which are related to one metre of panel width.

The number and the extent of characteristics and defects shall be defined as follows and rounded off to the nearest unit.

a) For knots and holes

- 1) individual diameter;
- 2) cumulative diameters expressed per square metre of panel surface.

NOTE: The diameter of a knot or hole is conventionally defined as the diameter across the general direction of the grain of the veneer.

b) For checks, splits and open joints

- 1) individual length;
- 2) individual width;
- 3) number per metre of panel width.

4.2.2 Joints

In appearance class I to IV, the number and the width of veneers which form the outer plies of a panel is not restricted provided the joints are well made.

The veneers forming the outer plies of class I shall be well matched for colour and have similar grain.

The outer plies shall be laid with the joints approximately parallel to the edges of the panel.

In class E, the outer ply using rotary cut veneer may be of one or two veneers provided that the joint is well made, approximately at the centre of the panel, approximately parallel to the edges of the panel and that the veneers are well matched for colour and of similar grain.

4.2.3 Inclusions

The inclusion of foreign particles likely to damage the machining equipment is not permitted.

4.2.4 Repairs

Patches and shims used for the repairs shall fit and be properly fixed. The matching for colour and grain shall be in accordance with the requirements for the appropriate appearance class.

Synthetic filling is permitted subject to the appearance class requirement.