



# SLOVENSKI STANDARD

## SIST EN 635-3:1996

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### Vežan les - Klasifikacija po videzu površine - 3. del: Iglavci

Plywood - Classification by surface appearance - Part 3: Softwood

Sperrholz - Klassifizierung nach dem Aussehen der Oberfläche - Teil 3: Nadelholz

Contreplaqué - Classification selon l'aspect des faces - Partie 3: Bois résineux

Ta slovenski standard je istoveten z: **EN 635-3:1995**

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#### **ICS:**

79.060.10      Vežan les                                      Plywood

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EUROPEAN STANDARD

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EUROPÄISCHE NORM

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English version

**Plywood - Classification by surface appearance -  
Part 3: Softwood**

Contreplaqué - Classification selon l'aspect des faces - Partie 3: Bois résineux Sperrholz - Klassifizierung nach dem Aussehen der Oberfläche - Teil 3: Nadelholz

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## Foreword

This European Standard has been prepared by the Technical Committee CEN/TC 112 "Wood-based panels", of which the secretariat is held by DIN.

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

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of an identical text or by endorsement, at the latest by November 1995, and conflicting national standards shall be withdrawn at the latest by November 1995.

According to the CEN/CENELEC Internal Regulations, the following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

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## 1 Scope

This European Standard specifies the nature and limits of characteristics inherent in wood and manufacturing defects enabling the visual assessment of the plywood for allocation to an appearance class. This classification is a contribution to assessing the finishing suitability of plywood.

This part of EN 635 applies to plywood, the surface veneers of which are made from softwood species. It does not apply to overlaid panels.

## 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 635-1 Plywood - Classification by surface appearance - Part 1: General

## 3 Classification by surface appearance

### 3.1 Appearance-classes

Assessment of characteristics and defects for determination of appearance class shall be carried out in accordance with EN 635-1. Surface classification shall be based on the permissible characteristics and defects within each of the appearance classes as specified in 3.2

NOTE: Guidance on selection of finishing for each appearance class is given in ENV 635-4.

### 3.2 Permissible characteristics and defects

Each surface shall be individually assigned to one of the appearance classes E, I, II, III, IV, as defined by the permissible characteristics and defects indicated in Table 1 and Table 2.

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## 3.2.1 Classification according to characteristics inherent in wood

Table 1: Classification according to characteristics inherent in wood

Categories of characteristics	Appearance class			
	E	I	II	III
3.2.1.1 Pin knots *)		3/m <sup>2</sup> permitted	Permitted	IV
3.2.1.2 Sound intergrown knots		15 mm provided their cumulative diameter does not exceed 30 mm/m <sup>2</sup> Such knots may have splits provided they are very slight	Permitted up to an individual diameter of: 50 mm	Permitted but see note.
3.2.1.3 Unsound or non-adhering knots and knot holes	Practically absent	6 mm if filled and up to a number of 2/m <sup>2</sup>	Permitted up to an individual diameter of: 5 mm if unrepaired, 25 mm if filled and up to a number of 6/m <sup>2</sup>	Permitted but see note.
3.2.1.4 Splits		1/10 3 mm 3/m if properly filled	Permitted if less than: 1/3 of panel length up to an individual width of: 10 mm and up to a number of: 3/m of panel width All splits greater than 2 mm in width to be filled	Length unlimited 25 mm unlimited
			Permitted	

\*) Pin knots: sound intergrown knots of no more than 3 mm diameter

NOTE: Characteristics inherent to wood are permitted provided that they do not impair the serviceability of the panel.

Table 1 (concluded): Classification according to characteristics inherent in wood

Categories of characteristics	Appearance class			
	E	I	II	III
3.2.1.5 Anomalies due to insects, marine borers, and parasite plants	Not permitted	Not permitted	Marks of parasitic plants not permitted. Insects and marine borer holes permitted up to a: diameter of 3 mm vertically to the plane of the panel up to a number of 10/m <sup>2</sup>	Permitted, but see Note
3.2.1.6 Resin pockets and inbark		Not permitted	Permitted up to a width of 6 mm if properly filled	Permitted but see Note
Resin streaks	Practically absent	Not permitted	Permitted if slight	Permitted
3.2.1.7 Irregularities in the structure of the wood		Permitted if very slight	Permitted if slight	Permitted
3.2.1.8 Discoloration which is not wood destroying	Not permitted	Permitted if low contrast	Permitted	Permitted
3.2.1.9 Fungal decay, wood destroying		Not permitted	Not permitted	Not permitted
3.2.1.10 Other characteristics	Practically absent	To be considered under the category which they most closely resemble		
NOTE: Characteristics inherent to wood are permitted provided that they do not impair the serviceability of the panel.				

## 3.2.2 Classification according to manufacturing defects

Table 2: Classification according to manufacturing defects

Categories of defects	Appearance class				
	E	I	II	III	IV
3.2.2.1 Open joints		Not permitted	3 mm and up to a number of 1/m of panel width with joints filled if more than 1 mm in width	Permitted up to a width of: 10 mm and up to a number of 2/m unfilled	25 mm unlimited unfilled
3.2.2.2 Overlaps		Not permitted	Permitted up to a number of 1/m <sup>2</sup> and up to 100 mm length		Permitted, but see Note
3.2.2.3 Blisters	Not permitted				
3.2.2.4 Hollows, imprints and bumps		Not permitted	Permitted if slight		Permitted
3.2.2.5 Roughness		Not permitted	Permitted if slight		Permitted
3.2.2.6 Sanding through		Not permitted			Permitted up to an extent of: 1 % of panel surface but see Note
3.2.2.7 Glue penetration		Not permitted	if slight and occasional	Permitted up to an extent of 5 % of the panel surface	Permitted, but see Note

NOTE: Manufacturing defects are permitted provided that they do not impair the serviceability of the panel.



Table 2 (concluded): Classification according to manufacturing defects

Categories of defects	Class			
	E	I	II	III
3.2.2.8 Foreign particles	Not permitted	Not permitted	III	IV
3.2.2.9 Repairs a) Patches b) Shims c) Synthetic fillers	Practically without defects	Permitted if properly made and tightly filled up to a number of: 5/m <sup>2</sup> unlimited		
	Not permitted	is permitted with limits of the category which it most closely resembles unlimited		
3.2.2.10 Defects at the edges of the panel due to sanding or sawing	Practically without defects	2 mm	Permitted up to 5 mm from the edge	5 mm
	Other defects	To be considered under the category which they most closely resemble		
NOTE: Manufacturing defects are permitted provided that they do not impair the serviceability of the panel.				

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