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**Vežan les - Klasifikacija po videzu površine - 4. del: Parametri primernosti za oplemenitenje, navodilo**

Plywood - Classification by surface appearance - Part 4: Parameters of ability for finishing - Guideline

Sperrholz - Klassifizierung nach dem Aussehen der Oberfläche - Teil 4: Einflußgrößen auf die Eignung zur Oberflächenbehandlung, Leitfaden

Contreplaqué - Classification selon l'aspect des faces - Partie 4: Parametres d'aptitude a la finition, Guide

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Plywood

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EUROPEAN PRESTANDARD

ENV 635-4

PRÉNORME EUROPÉENNE

EUROPÄISCHE VORNORM

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Descriptors: plywood, appearance, classifications, area, finishing, durability, categories

English version

**Plywood - Classification by surface appearance -  
Part 4: Parameters of ability for finishing,  
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des faces - Partie 4: Paramètres d'aptitude à  
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der Oberfläche - Teil 4: Einflußgrößen auf die  
Eignung zur Oberflächenbehandlung, Leitfaden

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**CEN**

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

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### Foreword

This European Prestandard has been prepared by Technical Committee CEN/TC 112 "Woodbased panels", the secretariat of which is held by DIN.

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

According to the CEN/CENELEC Internal Regulations, the national standards organisations of the following countries are bound to announce this European Prestandard: 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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## Introduction

Properties specific to plywood can affect the quality of surface finishes and should be taken into account for determining the surface appearance and integrity in both the long and short term together with the required durability.

The information is presented only as a guide for the end user aimed at maximising the lifespan of plywood panels. As this document covers only general situations, the end user is advised to refer to additional documentation for specific products and /or specific situations.

## 1 Scope

This Standard gives guidance for the end user on the selection of plywood for application of various finishes for use in dry, humid, or exterior end-use conditions.

## 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 314-2  
Plywood – Bonding quality – Part 2: Requirements

EN 635-1  
Plywood – Classification by surfaces appearance – Part 1: General

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

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

prEN 636-1  
Plywood – Specifications – Part 1: Plywood for use in dry conditions

prEN 636-2  
Plywood – Specifications – Part 2: Plywood for use in humid conditions

prEN 636-3  
Plywood – Specifications – Part 3: Plywood for use in exterior conditions

## 3 General

The following criteria should be considered in applying a finishing to plywood to achieve a panel of the desired appearance and durability:

- the intended end-use and service condition (dry, humid or exterior)
- the wood species and appearance class(es) of the surface(s);
- the lay-up of the panel, and the quality of the first inner ply, which could affect the quality of the finish;
- the type of finishing, e.g. varnish, paint, wood stain, or an overlay.

In some situations different criteria can apply.

Indications given in Tables 1, 2 and 3 should be considered as minimum requirements.

## 4 Definitions

For the purposes of this standard, the following definitions apply:

### 4.1 finish

A chemical formulation applied to a surface in one or more coats which turn into a solid film, either by solvent evaporation or chemical reaction. Three groups are generally considered which differ by their formulation and properties.

#### 4.1.1 varnish

A product which, when applied to a substrate, forms a solid transparent film having protective, decorative or other specific technical properties. Its appearance can be glossy, satin or matt.

#### 4.1.2 paint

A product which, when applied to a substrate, forms an opaque film having protective, decorative or other specific technical properties. Its appearance can be glossy, satin or matt.

#### 4.1.3 wood stain

A liquid product, transparent or semi-transparent for decoration of the wood surface, and optionally for protection against weathering and attack by mould and fungi.

NOTE: In some countries, the term opaque woodstain is also used for a paint applied at a thickness such that the wood surface structure remains visible.

### 4.2 finishing

The process of applying a finish to a substrate.

### 4.3 overlaying

The process of applying one or several overlay sheets, or one or several films such as:

- impregnated paper;
- plastics;
- resin fil;
- metal;
- decorative veneer.

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## 5 Selection of plywood

**Table 1: Surface finishing – Guide to the selection of plywood for use in dry conditions according to prEN 636-1**

Reference code	K	L	M	N	O
	Suitable for all finishes including varnish	Suitable for overlaying	Suitable for stain or semi transparent finish	Suitable for paint	No special requirement
Surface	Sanded or textured	Sanded or smooth	Sanded or textured	Sanded or smooth	No requirement
Minimum appearance class*)	I	III repaired	II	III	IV
Maximum thickness of face veneer	3,0 mm	3,0 mm	3,0 mm	3,0 mm	No requirement
Defects in first inner ply	No open defects or overlaps	see clause 3	see clause 3	see clause 3	No requirement
Bonding class**)	1	1	1	1	1
<p>*) According to EN 635-1, -2 and -3.</p> <p>** ) According to EN 314-2.</p>					

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**Table 2: Surface finishing – Guide to the selection of plywood for use in humid conditions according to prEN 636-2**

Reference code	F	G	H	I	J
	Suitable for all finishes including varnish	Suitable for overlaying	Suitable for stain or semi transparent finish	Suitable for paint	No special requirement
Surface	Sanded or textured	Sanded or smooth	Sanded or textured	Sanded or smooth	No requirement
Minimum appearance class *)	I	III repaired	II	III	IV
Thickness of face veneer min.	0,4 mm	0,4 mm	0,4 mm	0,4 mm	0,4 mm
Thickness of face veneer max.	3,0 mm	3,0 mm	3,0 mm	3,0 mm	No requirement
Thickness of inner plies max.	5,0 mm	5,0 mm	5,0 mm	5,0 mm	5,0 mm
Defects in first inner ply	No open defects or overlaps	see clause 3	see clause 3	see clause 3	No requirement
Bonding class **)	2	2	2	2	2
*) According to EN 635-1, -2 and -3.					
**) According to EN 314-2.					

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