



SLOVENSKI STANDARD
SIST EN 13017-1:2004

01-januar-2004

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Solid wood panels - Classification by surface appearance - Part 1: Softwood

Massivholzplatten - Klassifizierung nach dem Aussehen der Oberfläche - Teil 1: Nadelholz

Bois panneautés - Classification selon l'aspect des faces -Partie 1: Bois résineux

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Ta slovenski standard je istoveten z: EN 13017-1:2000

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ICS:

79.060.99 Ö!` * ^Á^•} ^Á [| z ^ Other wood-based panels

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 13017-1

November 2000

ICS 79.060.99

English version

**Solid wood panels - Classification by surface appearance - Part
1: Softwood**

Bois panneautés - Classification selon l'aspect des faces -
Partie 1: Bois résineux

Massivholzplatten - Klassifizierung nach dem Aussehen der
Oberfläche - Teil 1: Nadelholz

This European Standard was approved by CEN on 8 September 2000.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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Foreword

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

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 May 2001, and conflicting national standards shall be withdrawn at the latest by May 2001.

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

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This standard is one of two of standards for the classification of solid wood panels by surface appearance, the other is:

EN 13017-2, *Solid wood panels — Classification by surface appearance — Part 2: Hardwood.*

1 Scope

This European Standard specifies general requirements and appearance classes for both single-layer and multi-layer solid wood panels, the latter with a minimum thickness of the outer layers of 3,5 mm, manufactured from softwood species (e.g. spruce, pine, larch).

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 (including amendments).

EN 844-1, *Round and sawn timber — Terminology — Part 1: General terms common to round timber and sawn timber.*

EN 844-3, *Round and sawn timber — Terminology — Part 3: General terms relating to sawn timber.*

EN 844-4, *Round and sawn timber — Terminology — Part 4: Terms relating to moisture content.*

EN 844-6, *Round and sawn timber — Terminology — Part 6: Terms relating to dimensions of sawn timber.*

EN 844-7, *Round and sawn timber — Terminology — Part 7: Terms relating to anatomical structure of timber.*

EN 844-9, *Round and sawn timber — Terminology — Part 9: Terms relating to features of sawn timber.*

EN 844-10, *Round and sawn timber — Terminology — Part 10: Terms relating to stain and fungal attack.*

EN 844-11, *Round and sawn timber — Terminology — Part 11: Terms relating to degrade by insects.*

EN 1310, *Round and sawn timber — Method of measurement of features.*

prEN 12775:2000, *Solid wood panels — Classification and terminology.*

prEN 13353:1998, *Solid wood panels — Requirements.*

3 Terms and definitions

For the purposes of this standard the terms and definitions given in prEN 12775:2000 apply, together with some common terms referring to timber which are given in those parts of EN 844 listed in clause 2.

4 General requirements

4.1 General requirements for multi-layer solid wood panels

All types of panels shall have a symmetrical construction throughout their thickness.

The outer layers of panels for structural use (see grade S), shall have a minimum thickness of 5 mm.

All pieces of a the outer layers (face and back) shall normally be made of the same wood species; exceptions are given in table 1.

The surfaces of the panel shall be finished according to their intended use (e.g. sanded, planed, coated).

Inner layers shall not have open joints (whatever they are glued or not). Discolouration, slight rot and single small wormholes are permitted.

4.2 General requirements for single-layer solid wood panels

All joints shall be glued properly; open joints are not permitted.

The minimum length for pieces for type SC is given in table 2.

Panels with pieces of timber cut in length may have pieces finger-jointed, butt jointed or have any other type of end joint.

5 Appearance classes

5.1 General

Classification for appearance classes shall be in accordance with the requirements given in table 1.

The measurements of features shall be made according to EN 1310. For knots the general method according to EN 1310 : 1997, 4.1.1 shall be used.

5.2 Appearance classes of multi-layer solid wood panels

Assessment of appearance classes shall be made for both the face and the back of the panel. In marking and specification the symbols of the classes of both face and back shall be given separated by a slash as face class/back class. (Examples: A/B, B/B, B/C, A/C, S/S).

Class S is intended for structural use (e.g. formwork and construction panels). The combination of class S with another class within the same panel is unusual.

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Table 1 — Appearance classes for surfaces of multi-layer solid wood panels

Features	Appearance class				
	0	A	B	C	S
Glueing	No open glue lines		Open joints \leq 100 mm/1 m glue line permitted		
Mixture of species	Not permitted		Not permitted; with spruce, however, a proportion of 10 % fir, is permitted if evenly distributed	Permitted	
Appearance and colour	Well balanced in colour and texture		Largely balanced in colour and texture	No requirements	
Texture	Coarse texture not permitted	Coarse texture permitted		No requirements	
Knots	Sound intergrown knots: with spruce up to a diameter of 30 mm with pine and larch up to a diameter of 50 mm	up to a diameter of 40 mm up to a diameter of 60 mm; single black knots permitted	Sound intergrown knots and single black knots permitted	Permitted	Sound intergrown knots up to a diameter of 60 mm and single knot holes up to a diameter of 10 mm permitted
Plugs ^a	Single natural plugs permitted	Natural plugs permitted	Permitted		Up to a diameter of 40 mm permitted
Resin pockets	Single up to 2 mm \times 30 mm permitted	Single up to 3 mm \times 40 mm permitted	Single up to 5 mm \times 50 mm permitted	Permitted	Up to 5 mm \times 50 mm permitted
Repaired resin pockets	Single plugs permitted	Permitted			
Bark pockets	Not permitted		Single permitted	Permitted	Single permitted
Fissures	Single surface checks permitted		Single surface checks and end shakes up to 50 mm in length permitted	Permitted	per 1 m ² : 1 check up to 1 mm width and 500 mm in length permitted (slope up to 1 : 10)

^a Measurement of oval plugs as for knots

Table 1 (continued)

Features	Appearance class				
	0	A	B	C	S
Pith	Not permitted	Occasionally up to 400 mm in length permitted	Permitted		
Compression wood	Not permitted	Occasionally permitted	Permitted		Up to 40 % of width of panel permitted
Insect attack	Not permitted			Single small worm holes permitted provided worms are inactive	Not permitted
Dis-colouration	Not permitted		Slight discolouration permitted	Permitted	
Rot	Not permitted				
Sapwood	Permitted with pine, small stripes up to 20 % of width of lamella permitted with larch		Permitted		
Thickness of glue line	max. 0,2 mm		max. 0,3 mm		No requirement max. 0,3 mm
Machining quality of surface	Free from blemishes	Single small blemishes permitted	Single blemishes permitted	No requirement	Single small blemishes permitted
Quality of edge and ends of panel (wane, knocked out spots)	Free from blemishes	Single small blemishes permitted	Single blemishes permitted	No requirement	Free from blemishes
Singular width of lamella	min. 60 mm (not valid for edge lamella)		No requirement		min. 30 mm max. 180 mm (not valid for edge lamella)
Edging of lamella	Parallel edged			Parallel or conical edged	
End joints in lamella	Not permitted		Finger or equivalent joints permitted	Permitted	Finger or equivalent joints permitted

5.3 Appearance classes of single-layer solid wood panels

Classification in an appearance class shall be made according to the requirements of table 2. Only the class of the better surface shall be given in the specification of the panel.

Features shall be measured according to EN 1310.

Table 2 — Appearance classes for single layer solid wood panels

Features	Appearance classes			
	0	A	B	C
Glueing	No open glue lines			Open joints ≤ 100 mm/1 m glue line permitted
Mixture of species	Not permitted			
Texture, grain	Fine texture and straight grain		Coarse texture and slope of grain permitted	No requirement
Pin knots	Not more than 4 per m ² permitted	Permitted		
Sound intergrown knots	With spruce up to a diameter of 20 mm		up to a diameter of 30 mm	Permitted
	With pine and larch up to a diameter of 35 mm		up to a diameter of 50 mm	
Black knots	Not permitted	Single black knots permitted		Permitted
Plugs ^a	Not permitted	Single natural plugs permitted	Natural plugs permitted	Permitted
Resin pockets	Not permitted	Single up to 3 mm × 50 mm permitted	Permitted up to 5 mm × 50 mm	Permitted
Repaired resin pockets	Not permitted	Single permitted		
Bark pockets	Not permitted	Single permitted	Single permitted	Permitted
Pith	Not permitted	Single up to 200 mm in length permitted	Permitted	
Compression wood	Not permitted	Single stripes permitted	Permitted	
Insect attack	Not permitted			Single worm holes permitted provided worms are inactive
Discolouration	Not permitted		Slight discolouration permitted	Permitted
Rot	Not permitted			
Sapwood	Permitted with pine, small stripes permitted with larch		Permitted	
Thickness of glue line	max. 0,2 mm		max. 0,3 mm	No requirement
Machining quality of surface	Free from blemishes		Single blemishes permitted	No requirement
Quality of edge and ends of panel (wane, knocked out spots)	Free from blemishes	Single small defects up to 5 mm from the edge permitted	Defects permitted up to 10 mm from the edge	Single defects up to 50 mm from the edge permitted
Width of single piece	min. 18 mm (not valid for margin area)			No requirement
Length of pieces of panel type SC	Pieces of timber cut in length not permitted	min. 150 mm		No requirement

^a Measurement of oval plugs as for knots