

SLOVENSKI STANDARD

SIST EN 13017-2:2004

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Solid wood panels - Classification by surface appearance - Part 2: Hardwood

Massivholzplatten - Klassifizierung nach dem Aussehen der Oberfläche - Teil 2: Laubholz

Bois panneautés - Classification selon l'aspect des faces -Partie 2: Bois feuillus

STANDARD PREVIEW
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Ta slovenski standard je istoveten z: **EN 13017-2:2000**

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ICS:

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

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 13017-2

November 2000

ICS 79.060.99

English version

Solid wood panels - Classification by surface appearance - Part
2: Hardwood

Bois panneautés - Classification selon l'aspect des faces -
Partie 2: Bois feuillus

Massivholzplatten - Klassifizierung nach dem Aussehen der
Oberfläche - Teil 2: Laubholz

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.

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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of an identical text or by endorsement, at the latest by May 2001, and conflicting national standards shall be withdrawn at the latest by May 2001.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.

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

EN 13017-1, *Solid wood panels — Classification by surface appearance — Part 1: Softwood.*

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 hardwood species.

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.*

EN 1311, *Round and sawn timber — Method of measurement of biological degrade.*

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.

Joints in the outer layer shall be glued; open glue lines, with the exception in grades B and C (see table 1) are not permitted.

Unglued joints are permitted in the inner layers. Butt joints and finger joints in the individual pieces of the inner layers are also permitted.

The width of lamellas in the outer layers should be at least 75 mm. All layers and lamellas of a panel shall be made of the same wood species.

The surfaces of the panel shall be fine sanded. Some surface blemishes are only permitted in grade C.

4.2 General requirements for single-layer solid wood panels

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

Mixing of wood species within one panel is not permitted.

The surfaces of the panel shall be planed or sanded. Cuttermarks are not permitted. Some sanding blemishes in the surface are only permitted in grade C.

Panels with pieces of timber cut in length may have pieces finger-jointed as well as 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 measurement 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 face and 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 (e.g. A/C)

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5.3 Appearance classes of single-layer solid wood panels

Assessment of appearance classes shall be made on the better surface on the panel. Only the appearance class of the better surface shall be given in the specification of the panel.

Table 1 — Appearance classes for multi-layer and single-layer solid wood panels

Features	Appearance class		
	A	B	C
Glueing	Outer layer perfectly glued, with closed joints on edges and faces		Outer layer perfectly glued on faces, no requirements on edge glueing
Appearance and colour	Composed appearance, balanced in colour	Pronounced as well as rustic appearance permitted	No requirements
Texture	Texture, typical for the species permitted, uniform texture required	Coarse texture permitted	No requirements
Brown, wet, irregular heart	Not permitted	Not permitted ^a	Permitted
Rays	Permitted		
Sapwood	Permitted ^b	Permitted ^c	Permitted
Fiddle back grain	Permitted		
Dormant shoots	Permitted		
Pin knots	Permitted		
Sound intergrown knots	Permitted up to a diameter of 10 mm, single up to diameter of 25 mm	Up to a diameter of 30 mm	Permitted
Loose knots, patches	Not permitted	Loose knots and patches or plugs in rows not permitted; fine patch-work or plugs up to a diameter of 30 mm permitted	Permitted, with or without patches
Fissures	Not permitted	Single shakes up to 2 mm × 50 mm permitted; shakes near the edges permitted up to 1 mm × 100 mm	Permitted
Ingrown bark	Not permitted		Permitted
Insect attack, small worm holes	Not permitted		
Discolouration, fungal attack ^d	Not permitted	Slight discolouration permitted; rot not permitted	Rot not permitted
Open joints	Not permitted	Near the edges permitted up to 1 mm × 200 mm	Permitted
Thickness of glue line	max. 0,2 mm	max. 0,2 mm	No requirement
Length of pieces of panel type SC	min. 150 mm		

^a Brown heart in class B permitted with ash and red heart with steamed or unsteamed beech.

^b Sapwood not permitted in class A with oak, cherry, elm, sweet chestnut or false acacia.

^c Sapwood not permitted in class B with oak or sweet chestnut.

^d Can be measured according to EN 1311.

6 Marking

Marking shall be made in accordance with the panel type suitable for certain climatic conditions in service. For full marking of panels see prEN 13353:1998.