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SIST EN 315:2004

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

EN 315

July 2000

ICS

Supersedes EN 315:1993

English version

Plywood - Tolerances for dimensions

Contreplaqué - Tolérances sur dimensions

Sperrholz - Maßtoleranzen

This European Standard was approved by CEN on 7 July 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 Central Secretariat 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 Central Secretariat 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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## Foreword

This European Standard has been 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of an identical text or by endorsement, at the latest by January 2001, and conflicting national standards shall be withdrawn at the latest by January 2001.

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 European Standard supersedes EN 315:1993.

Compared to the version EN 315:1993 the following modifications have been made:

- a) Thickness tolerances for panels with a nominal thickness > 25 mm have been added.

## 1 Scope

This European Standard specifies dimensional tolerances of plywood panels (length, width, thickness) and tolerances for squareness and edge straightness.

NOTE Some uses of plywood can require narrower tolerances: see specific standards for types or performance standards.

## 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 322

Wood-based panels – Determination of moisture content

EN 324-1

Wood-based panels – Determination of dimensions of boards – Part 1: Determination of thickness, width and length

EN 324-2

Wood-based panels – Determination of dimensions of boards – Part 2: Determination of squareness and edge straightness

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## 3 Moisture content of panels (standards.iteh.ai)

Moisture content is measured according to EN 322.

Tolerances are fixed with regard to the following moisture content reference:  $(10 \pm 2) \%$ .

## 4 Tolerances for length and width

Length and width are measured according to EN 324-1.

Tolerances on nominal size:  $\pm 3,5$  mm.

## 5 Tolerances for thickness

Thickness is measured according to EN 324-1.

Table 1 - Tolerances for thickness

Nominal thickness ( <i>t</i> ) mm	Unsanded panels		Sanded panels	
	Thickness tolerance within one panel mm	Tolerances on nominal thickness mm	Thickness tolerance within one panel mm	Tolerances on nominal thickness mm
$\geq 3$	1,0	+ (0,8 + 0,03 <i>t</i> )	0,6	+ (0,2 + 0,03 <i>t</i> )
$\leq 12$		- (0,4 + 0,03 <i>t</i> )		- (0,4 + 0,03 <i>t</i> )
$> 12$	1,5	+ (0,8 + 0,03 <i>t</i> )	0,6	+ (0,2 + 0,03 <i>t</i> )
$\leq 25$		- (0,4 + 0,03 <i>t</i> )		- (0,4 + 0,03 <i>t</i> )
$> 25$	1,5	+ (0,8 + 0,03 <i>t</i> )	0,8	+ (0,0 + 0,05 <i>t</i> )
$\leq 30$		- (0,4 + 0,03 <i>t</i> )		- (0,4 + 0,05 <i>t</i> )
$> 30$	1,5	+ (0,8 + 0,03 <i>t</i> )	0,8	+ (0,0 + 0,03 <i>t</i> )
		- (0,4 + 0,03 <i>t</i> )		- (0,4 + 0,03 <i>t</i> )

## 6 Tolerance for straightness of edges

The straightness of edges is measured according to EN 324-2.

Tolerance: 1 mm/m.

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## 7 Tolerance for squareness

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Squareness is measured according to EN 324-2.

Tolerance: 1 mm/m.

**Bibliography**

EN 326-1

Wood-based panels – Sampling, cutting and inspection – Part 1: Sampling and cutting of test pieces and expression of test results

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