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Standard Terminology Relating to Veneer and Plywood^{1, 2}

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adhesive—a substance capable of holding materials together by surface attachment.

NOTE 1—adhesive is the general term and includes, among others, cement, glue, mucilage, and paste. All of these terms are loosely used interchangeably. Various descriptive adjectives are applied to the term adhesive to indicate certain characteristics as follows:

- (1) Physical form, that is, liquid adhesive, tape adhesive
- (2) Chemical type, that is, silicate adhesive, resin adhesive
- (3) Materials bonded, that is, paper adhesive, metal-plastic adhesive, can label adhesive
- (4) Conditions of use, that is, hot-setting adhesive

back—the side reverse to the face of a panel, or the poorer side of a panel in any grade of plywood calling for a face and back.

balanced construction—See under **construction**.

banding (railing)—a portion of wood or other material extending around one or more edges of a plywood panel.

bleed through—glue or components of glue that have seeped through the outer layer or ply of a glued wood product and that show as a blemish or discoloration on the surface.

blemish—anything marring the appearance of the veneer that is not classifiable as a defect.

blister—*in plywood*, an elevation of the surface of an adherend (separation between plies), somewhat resembling in shape a blister on the human skin; its boundaries may be indefinitely outlined and it may have burst or become flattened.

bolt (veneer)—a short log cut to length suitable for peeling in a lathe; also block.

bond, *n*—the attachment at an interface between an adhesive and an adherend.

bond, *v*—to attach materials together by means of an adhesive.

borer holes—voids made by wood-boring insects.

broken grain (shelling, leafing, grain separation)—a separation on veneer surface between annual rings.

cauls, *n*—sheets of material employed singly or in pairs in hot or cold pressing of assemblies being bonded. Cauls are employed usually to protect either the faces or the press

platen or both against marring and staining, to prevent sticking, to facilitate press loading, or to impart a desired surface texture or finish, and to provide uniform pressure distribution.

NOTE 2—Cauls may be made of any material such as aluminum, stainless steel, hardboard, fiberboard, or plastic, with the length and width generally equal to the platen size of the press in which they are employed.

center—inner layers whose grain direction runs parallel to that of the outer plies; may be of parallel laminated plies. (See also **core**.)

clipper—the shearing machine used to dimension dry or green veneers to width.

compreg—synthetic resin-treated, compressed wood with reduced swelling and shrinking characteristics and increased density and strength properties.

construction—details of arrangement or thickness or both, of veneers and other components used in the fabrication of plywood.

all-veneer construction—plywood in which all plies are veneer. Ordinarily no single ply of veneer will exceed $\frac{5}{16}$ in. (7.9 mm) in thickness.

balanced construction—a construction such that the forces induced by uniformly distributed changes in moisture content will not cause warpage.

composite construction—a panel assembly consisting of veneers and other wood-based materials. Normally the non-veneer component is identified in describing the construction.

lumber core construction—plywood in which the center ply or core is of lumber rather than of veneer. Ordinarily cores that are $\frac{3}{8}$ in. (9.5 mm) or greater in thickness will be of lumber.

symmetrical construction—plywood panels in which the plies on one side of the panel center line are essentially equal in thickness, grain direction, properties, and arrangement to those on the other side of the center line.

core—(1) *in decorative or hardwood plywood*, the center most ply. It may be of lumber (either edge-glued or closely assembled) or other wood-based panel material, or of one or more thicknesses of veneer.

(2) *in construction plywood*, all plies or layers between the face and back.

¹ This terminology is under the jurisdiction of ASTM Committee D07 on Wood and is the responsibility of Subcommittee D07.03 on Panel Products.

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² These definitions are specific to veneer and plywood. Other definitions relating to timber appear in ASTM Terminology D9, Relating to Wood, *Annual Book of ASTM Standards*, Vol 04.10.