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# INTERNATIONAL STANDARD



# 631

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INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

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## Mosaic parquet panels — General characteristics

*Panneaux de parquet mosaïque — Caractéristiques générales*

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**Descriptors** : wood products, floor coverings, parquet panels, specifications, dimensions.

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## FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO Member Bodies). The work of developing International Standards is carried out through ISO Technical Committees. Every Member Body interested in a subject for which a Technical Committee has been set up has the right to be represented on that Committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the Technical Committees are circulated to the Member Bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 631 was drawn up by Technical Committee ISO/TC 99, *Semi-manufactures of timber*, and circulated to the Member Bodies in October 1973.

It has been approved by the Member Bodies of the following countries :

Austria	Mexico	Thailand
Czechoslovakia	Netherlands	Turkey
Egypt, Arab Rep. of	Poland	U.S.S.R.
Germany	Romania	Yugoslavia
Hungary	South Africa, Rep. of	
Italy	Spain	

The Member Bodies of the following countries expressed disapproval of the document on technical grounds :

France  
Norway

This International Standard cancels and replaces ISO Recommendation R 631-1967, of which it constitutes a technical revision.

## Mosaic parquet panels – General characteristics

### 1 SCOPE AND FIELD OF APPLICATION

1.1 This International Standard specifies the general manufacturing characteristics (dimensions, permissible deviations, etc.), the inspection and delivery conditions and the marking of mosaic parquet panels of any species of wood.

1.2 Mosaic parquet panels are assemblies made from wood fingers of a parallelepiped rectangular shape, forming component squares laid in a chequered pattern; they are intended to be bonded (or sealed) to a supporting base, either directly, or over an interlayer of adequate material.

1.3 The classification according to specific characteristics, wood defects and possible exceptions is laid down, for the different species of wood, in the relevant International Standards.

### 2 REFERENCES

ISO/R 2036, *Marking of the different species of wood utilized in the manufacture of wood flooring – Code of symbols.*

ISO . . ., *Wood parquet and raw parquet blocks – Terms and definitions.*<sup>1)</sup>

### 3 MANUFACTURE

3.1 Mosaic parquet panels are made up from wood fingers of the same species or of different species, laid on a single layer and pre-assembled by juxtaposition, either by means of a material temporarily fixed (paper glued on the face, for example) or of a sufficiently flexible material, permanently fixed. The panels are made up from component squares (see figure 1), laid in a chequered pattern (see figure 2). Other patterns may also be formed.

3.2 The fingers may be quarter, half-quarter or plain sawn provided that the amount of plain sawn fingers does not exceed 30 % of each panel.

3.3 Finished fingers shall have the dimensions specified in 4.1.

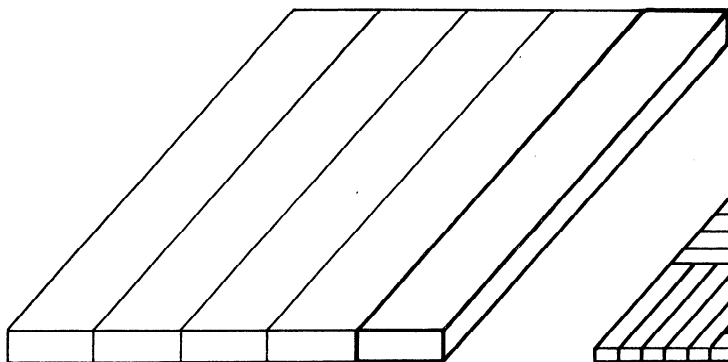


FIGURE 1 – Component square and fingers

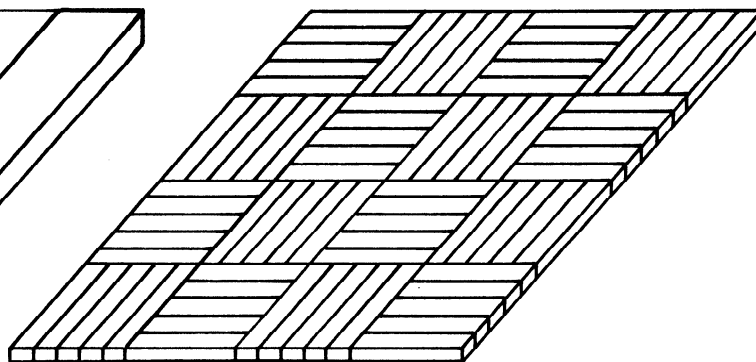


FIGURE 2 – Mosaic parquet panel

1) In preparation.

The finger edges shall be machine planed; the faces and ends shall be finely sawn.

Adjacent faces, edges and ends shall form parallel sharp edges.

The ends shall be perpendicular to the edges within a tolerance of 0,4 %.

The manufacturing faults are limited according to the relevant International Standards for the classification of mosaic parquet panels of different wood species.

#### 4 REQUIRED CHARACTERISTICS

##### 4.1 Nominal dimensions of fingers

The fingers shall have the following nominal dimensions :

- thickness : 6 – 8 and 10 mm; the 6 mm thickness is not suitable for softwood and for the softer grades of hardwood;
- width : 18 to 25 mm inclusive, with preferred widths of 20 – 22,4 – 24 and 25 mm;
- length : 100 to 165 mm, including preferred lengths of 100 – 112 – 120 and 125 mm.

TABLE 1 – Examples of nominal dimensions of fingers, component squares and mosaic parquet panels

Dimensions in millimetres

Fingers			Component squares			Panels		
Thick-ness	Width	Length	Thick-ness	Width × Length	Number of fin-gers	Thick-ness	Width × Length	Num-ber of com-ponent squares
6	20	100	6	100 × 100	5	6	400 × 400	16
8	22,4	112	8	112 × 112	5	8	448 × 448	16
10	22,4	112	10	112 × 112	5	10	448 × 448	16
10	25	125	10	125 × 125	5	10	500 × 500	16

NOTE – On agreement between the interested parties, fingers, component squares and panels having other dimensions may be produced.

##### 4.2 Permissible deviations

The maximum permissible deviations from the nominal dimensions indicated in 4.1 are given in table 2.

TABLE 2 – Permissible deviations

Values in millimetres

Dimensions	On a single panel	On each com-ponent square of the panel	On any point of any finger making up the panel
Thickness	± 0,2	± 0,2	± 0,2
Width	± 0,5	± 0,2	+ 0,1 – 0,2
Length	± 0,5	± 0,2	± 0,2
Diagonal <sup>1)</sup>	± 0,8	–	–

1) With respect to the nominal theoretical diagonal.

A panel, however, is considered to be acceptable if not more than 5 % of the fingers have dimensions with deviations not exceeding twice the deviations indicated above.

##### ISO 6439-1975 Moisture

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4.3.1 Unless otherwise agreed on the order, or specified in the relevant International Standards for classification of mosaic parquet panels of different species of wood, the moisture at delivery from the manufacturing works shall be between 8 and 13 %, on dry mass.

4.3.2 The reference moisture for the dimensions is 11 % on dry mass.

NOTE – This reference moisture is not inconsistent with the moisture limits laid down above. It is intended only to let the manufacturers provide for the increase or the reduction of panel dimensions during machining operations and depending upon the moisture content of wood at the time of manufacture, so that, for a moisture content of 11 %, the panel dimensions shall be within the permitted tolerances.

#### 5 DESIGNATION

The mosaic parquet panel shall be designated by stating successively :

- the words “mosaic parquet”;
- the symbol of the wood species according to ISO/R 2036;
- the nominal dimensions (thickness × width × length, expressed in millimetres);
- the number of fingers per component square;

- the grade, in the form of the appropriate symbol appearing in the relative International Standards for the classification of mosaic parquet panels;
- the number of the International Standard referring to the respective species of wood.

**Example :**

Oak mosaic parquet, 8 mm thick, the panel having the length of 448 mm and the width of 448 mm and 5 fingers per component square, of the first grade :

Mosaic parquet  
QUER 8 × 448 × 448 × 5 ★★ ★ ISO 3247

**6 INSPECTION CONDITIONS**

**6.1 Inspection rules**

The inspection of the characteristics of mosaic parquet panels shall be carried out under the conditions established below, on panels of a representative sample taken from the batch.

**6.2 Batch**

Unless otherwise agreed, a batch is made up of mosaic parquet panels of the same wood species, dimensions of fingers (thickness, width, length) and grade, presented in a single delivery.

**6.3 Sample**

A sample is made up of a number of panels taken at random from different parts of the batch; the number of panels in a sample shall be at least that specified in table 3.

**6.4 Nature of inspections**

All mosaic parquet panels making up a sample shall be inspected individually in respect of the wood species, the nominal dimensions, the defects and the appearance. The defects permitted for each grade shall be inspected according to the relevant International Standards for the classification of mosaic parquet panels of different species of wood.

The moisture content shall be checked according to 6.5.1.

**6.5 Inspections**

**6.5.1 Moisture**

The moisture content shall be checked on a test specimen cut from the middle of a finger taken at random from every third panel, but at least on three fingers, each taken from a different panel. Unless otherwise agreed, the moisture content shall be determined with an electrical contact device.

In case of disagreement, the gravimetric method shall be binding.

**6.5.2 Dimensions**

All inspections other than those for moisture content shall be carried out on all panels of the sample.

The dimensions shall be checked with measuring instruments capable of recording to the prescribed degree of accuracy.

The width and the length shall be checked on the face, parallel and perpendicular to the longitudinal axis of the finger.

**6.5.3 Defects and appearance**

The dimensions of measurable defects shall be measured with adequate measuring instruments.

Non-measurable defects and appearance shall be examined with the naked eye.

**6.6 Acceptance and rejection**

If, after checking the characteristics other than the moisture content, the number of rejected panels in the sample examined does not exceed the number shown in the third column of table 3 for the size of this sample, the batch shall be regarded as complying with the requirements of this International Standard.

In other cases, the batch shall be rejected; a rejected batch may be presented, after reclassification, to a new check.

If the moisture content is not according to the specifications of 4.3.1, the batch shall be rejected.

TABLE 3 – Number of panels in a sample

Size of batch	Number of panels initially subjected to inspection (first sample)	Number of rejected panels in the first sample that decides			Size of additional batch	Number of rejected panels in two samples considered together that decides	
		acceptance of batch	rejection of batch	additional sampling		acceptance of batch	rejection of batch
1	2	3	4	5	6	7	8
300 to 500	35	2	7	3 to 6	70	6	7
501 to 800	50	3	10	4 to 9	100	9	10
801 to 1 300	75	5	12	6 to 11	150	11	12
1 301 to 3 200	100	6	17	7 to 16	200	16	17
3 201 to 8 000	150	9	24	10 to 23	300	23	24

## 7 DELIVERY

### 7.1 Packaging

Unless otherwise agreed between the parties, mosaic parquet panels shall be put in packages that protect them against damage during transport and maintain the prescribed moisture content of the wood under normal transport and storage conditions.

### 7.2 Moisture content of panels

The moisture content of mosaic parquet panels shall comply, at delivery from the manufacturing works, with the specifications laid down in 4.3.1.

## 8 MARKING

8.1 Unless otherwise agreed between the parties, the marking of packages of mosaic parquet panels, at delivery from the manufacturing works, is compulsory.

8.2 The marking shall be carried out legibly by applying a stamp with a water-proof and slightly penetrating product to one of the sides of each package. The stamp must contain the items given in clause 5, except for the words "mosaic parquet", but adding the number of panels in the package.

*Example :*

For a package containing 100 oak mosaic parquet panels, 8 mm thick, 448 mm long and wide, and 5 fingers per component square, of the first grade, the marking shall be the following :

QUER  
8 × 448 × 448 – 5 ★★★  
100 panels  
ISO 3247

8.3 At the purchaser's request, the indications of the country of origin and the trade mark may be inscribed in addition to the indications specified in clause 5.

*Example :*

For a package containing 100 oak mosaic parquet panels 8 mm thick, 448 mm long and wide, and 5 fingers per component square, of the first grade, manufactured in Romania, by CEIL, the marking shall be the following :

QUER  
8 × 448 × 448 – 5 ★★★  
100 panels  
ISO 3247  
R  
CPL

ISO 631:1975

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