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**Plywood — Decorative veneered  
plywood**

*Contreplaqué — Contreplaqué à placage décoratif*

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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established 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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: Foreword - Supplementary information

The committee responsible for this document is ISO/TC 89, *Wood based panels*, Subcommittee SC 3, *Plywood*.

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# Plywood — Decorative veneered plywood

## 1 Scope

This International Standard specifies the terms, classifications, requirements, test methods, marking, for decorative veneered plywood with natural wood veneer, coloured veneer, laminated veneer, multilaminar veneer, and other types of veneer as decorative surface and plywood as a core panel, where the surface veneer thickness is less than 0,55 mm.

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1954, *Plywood — Tolerances on dimensions*

ISO 2074:2007, *Plywood — Vocabulary*

ISO 2426-1, *Plywood — Classification by surface appearance — Part 1: General*

ISO 2426-2, *Plywood — Classification by surface appearance — Part 2: Hardwood*

ISO 2426-3, *Plywood — Classification by surface appearance — Part 3: Softwood*

ISO 9426, *Wood-based panels — Determination of dimensions of panels*

ISO 12460-1, *Wood-based panels — Determination of formaldehyde release — Part 1: Formaldehyde emission by the 1-cubic-metre chamber method*

ISO 12460-3, *Wood-based panels — Determination of formaldehyde release — Part 3: Gas analysis method*

ISO 12460-4, *Wood-based panels — Determination of formaldehyde release — Part 4: Desiccator method*

ISO 12465, *Plywood — Specifications*

ISO 12466-1, *Plywood — Bonding quality — Part 1: Test methods*

ISO 12466-2, *Plywood — Bonding quality — Part 2: Requirements*

ISO 16979, *Wood-based panels — Determination of moisture content*

ISO 18775, *Veneers — Terms and definitions, determination of physical characteristics and tolerances*

ISO/IEC 17065, *Conformity assessment requirements for bodies certifying products, processes and services*

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 2074, ISO 12465, ISO 18775, and the following apply.

### 3.1

#### **decorative veneered plywood**

plywood with natural wood veneer, coloured veneer, laminated veneer, multilaminar veneer, and any other types of veneer as decorative surface and plywood as a core panel, where the surface veneer thickness is less than 0,55 mm

### 3.2

#### **coloured veneer**

wood veneer produced from either bleaching or dyeing procedure

### 3.3

#### **laminated wood veneer**

veneer sliced from wood flitch that is assembled from small pieces of wood strips with joints parallel to grain

### 3.4

#### **colour difference**

difference between surface colour of the decorative veneer and the control colour of the sample veneer colour or uneven colour of the surface in some case

Note 1 to entry: It does not include the colour difference between early wood and later wood, as well as the natural grain colour difference on the wood surface itself.

## 4 Classifications

### 4.1 Classification according to the decorative veneer

- a) natural wood veneered plywood;
- b) coloured veneered plywood;
- c) laminated wood veneered plywood;
- d) multilaminar decorative veneered plywood.

### 4.2 Classification according to the face

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- a) single-faced decorative veneered plywood;
- b) double-faced decorative veneered plywood.

### 4.3 Classification according to exposure classes

- a) Exposure Class 1: for use in dry conditions;
- b) Exposure Class 2: for use in tropical-dry/humid conditions.

## 5 Requirements and test methods

### 5.1 Panel dimensions and tolerances

#### 5.1.1 General

Test methods and requirements as given in ISO 1954 and ISO 9426 apply to determine length, width, squareness, and edge straightness of the panel.

#### 5.1.2 Panel thickness and tolerances

Tolerance of thickness of decorative veneered plywood refers to the nominal thickness marked on the product label and shall satisfy the requirements given in [Table 1](#).

Tolerance of thickness within one panel shall satisfy the requirements given in [Table 1](#).

**Table 1 — Thickness tolerance for decorative veneered plywood**

Dimension in millimetres

| Thickness,<br>t | Thickness tolerance within one<br>panel | Tolerance on nominal thickness |
|-----------------|---|--------------------------------|
| t < 4           | 0,3                                     | ±0,20                          |
| 4 ≤ t < 7       | 0,5                                     | ±0,30                          |
| 7 ≤ t < 20      | 0,6                                     | ±0,40                          |
| t ≥ 20          | 0,6                                     | ±0,50                          |

## 5.2 Surface appearance requirements and determination of quality grade

### 5.2.1 Determination of surface appearance

#### 5.2.1.1 Apparatus

- Scale magnifier glass;
- Photoelectric integrating colour measurement instrument;
- Steel rule, to an accuracy of 0,5 mm.

#### 5.2.1.2 Test method

- Inspect visually the surface appearance for each panel tested;
- Classify the decorative veneered plywood in accordance with criteria given in [Annex C](#).

### 5.2.2 Quality grades

Decorative veneered plywood shall be classified by the surface appearance.

The list of characteristics which shall be taken into account is given in ISO 2426-1.

NOTE 1 An example of classification according to appearance classes is given in ISO 2426-2 and ISO 2426-3. The classes of the surface are chosen from classes E, I, or II. (See [Annex C](#).)

NOTE 2 The quality grades of the face and back surface appearance are usually defined by contract.

Colour difference allowance shall follow the agreement or contract. Photoelectric integrating colour measurement instrument or photo electricity integral colourimeter shall be employed for arbitration, and

- a) indiscernible refers to the total colour difference lower than 1,5,
- b) inconspicuous refers to the total colour difference between 1,5 approximately 3,0, and
- c) obvious refers to the total colour difference higher than 3,0.

## 5.3 Physical and chemical requirements, sampling, and test methods

### 5.3.1 Requirements

Unless otherwise specified, requirements and test methods given in [Table 2](#) shall be fulfilled.

Determination of the formaldehyde release shall be carried out in accordance with ISO 12460-1 as the reference method and ISO 12460-3 or ISO 12460-4 for factory production control.

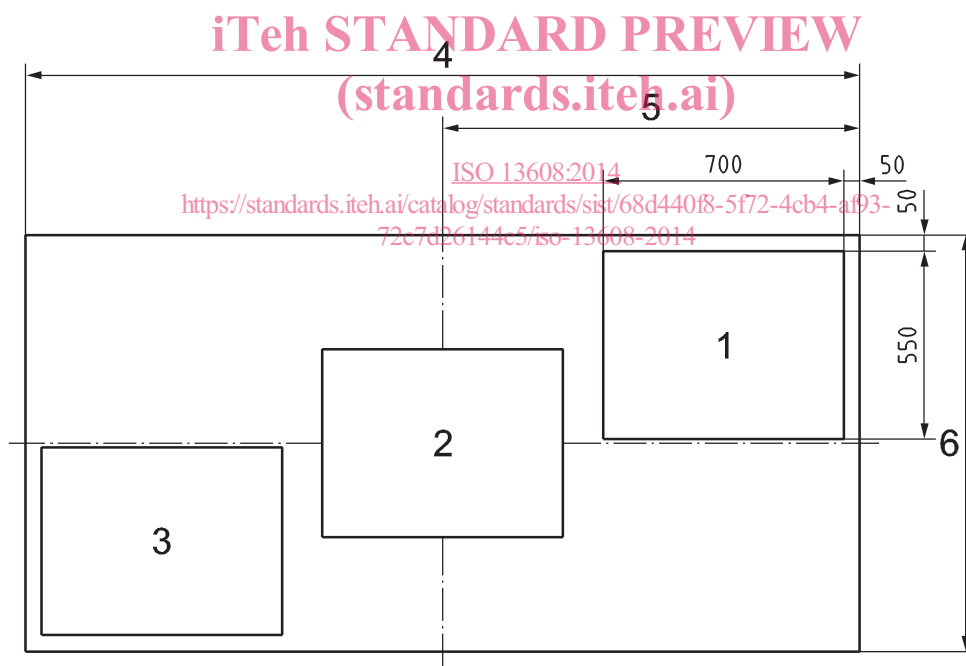
**Table 2 — Specifications**

| Characteristics   | Test method             | Requirements  |
|---|-------------------------|---|
| Moisture content (%)  | ISO 16979               | 6,0 — 14,0  |
| Immersion and delamination test   | <a href="#">Annex A</a> | Length of failure or delamination between surface veneer and plywood shall be less than 25 mm on each side. |
| High-low temperature cycle test   | <a href="#">Annex B</a> | No crack, blister, crinkle, on surface  |
| Formaldehyde release <sup>a</sup>   | ISO 12460-1             | ≤0,124 mg/m <sup>3</sup>  |
| NOTE If there is specific national or local law setting a lower limit of formaldehyde release, it applies.  |                         |   |
| <sup>a</sup> If factory production control methods are employed to determine formaldehyde release, a correlation between the utilized method and the 1-cubic-meter chamber method as in ISO 12460-1 shall be established. |                         |   |

When the faced decorative veneered plywood is manufactured in a two-stage process, the substrate plywood shall meet the requirements of ISO 12465.

**5.3.2 Sampling and preparation of test pieces**

Preparation of test pieces for properties determination is given in [Figure 1](#) and [Figure 2](#). Three samples shall be cut from one panel to be tested as shown in [Figure 1](#). Then test pieces for moisture content test, immersion and delamination test, high-low temperature cycle test, and formaldehyde release determination are cut as shown in [Figure 2](#). All the test pieces shall be coded in sequence.

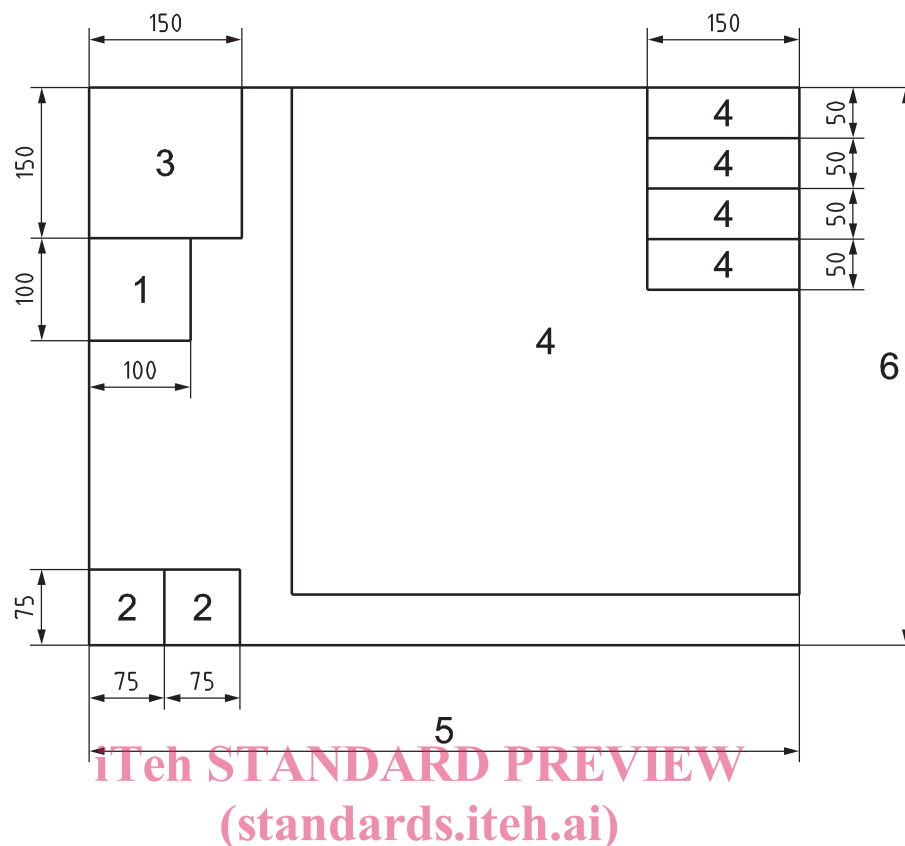


**Key**

- 1, 2, and 3 samples
- 4 length of panel
- 5 half-length of panel
- 6 width of panel

**Figure 1 — Example of cutting plan for test sample preparation**



**Key**

1, 2, 3, and 4 samples as given in Table 3

5 length of panel

6 width of panel

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**Figure 2 — Example of cutting plan for test pieces preparation**

When cutting test pieces, it is possible to change the cutting position to avoid any defect that could affect the accuracy of test results. The surface of the test pieces shall be kept clean.

The dimension and number of test pieces shall follow the requirements in [Table 3](#) with marking.

Table 3 — Dimension and number of test pieces

| Property   |                                    | Dimension<br>(length × width)<br>mm | Number | Marking of<br>samples | Note   |
|--|------------------------------------|-------------------------------------|--------|-----------------------|--|
| Moisture content   |                                    | 100 × 100 or at least<br>20 g       | 3      | ①                     | —  |
| Immersion delamination   |                                    | 75 × 75                             | 6      | ②                     | —  |
| High-low temperature cycle   |                                    | 150 × 150                           | 3      | ③                     | —  |
| Formaldehyde<br>release  | 1-Cubic-metre<br>chamber<br>method | 500 × 500                           | 2      | ④                     | Two test pieces could be taken from<br>any position from test sample as<br>shown in <a href="#">Figure 1</a> .     |
|  | Desiccator<br>method               | 150 × 50                            | 10     | ④                     | —  |
|  | Gas analysis<br>method             | 400 × 50                            | 3      | —                     | Cut from the same position as for the<br>1-Cubic-metre chamber method test<br>pieces in <a href="#">Figure 2</a> . |
| NOTE 1 For desiccator method, take 4, 3, and 3 test pieces separately from each of the three samples.  |                                    |                                     |        |                       |  |
| NOTE 2 Except the test pieces for moisture content, all test pieces shall be perpendicular to the plane of the panel, free of burns, and clean on edges. Dimension tolerance is ±0,5 mm. |                                    |                                     |        |                       |  |

## 5.4 Conformance

Decorative veneered plywood conforming to this International Standard shall be manufactured under a quality system which

- includes factory production and quality-control with internal auditing and
- includes external auditing of the factory quality control.

When the quality control system is certified, the bodies performing certification should operate in accordance with ISO/IEC 17065.

## 6 Marking, identification, and documentation

Marking and the accompanying information shall be placed on the product itself, on a label attached to it, on its packaging, or in the accompanying commercial documents with the following information:

- reference to this International Standard;
- name (or logo) or code of the manufacturer;
- nominal dimensions, in millimetres;
- species, or species group type of veneers;
- bonding class;
- formaldehyde release class;
- reference to the quality system;

and optionally

- quality label and the certification body, if any;
- batch number or producing dates.

NOTE Further documents, if requested, will be provided by the manufacturer.

## Annex A (normative)

### Immersion and delamination test

#### A.1 Principle

Bonding quality shall be determined according to whether there is delamination of the surface veneer and the degree of the delamination. Test pieces are soaked in water and dried as dry-shrinking and wet-swelling cause stress within the glue line under the face.

#### A.2 Apparatus

- **Thermostatically controlled water bath**, capable of maintaining a temperature of  $(20 \pm 3) ^\circ\text{C}$ ;
- **Boiling tank**, enabling test pieces to be immersed in boiling water;
- **Ventilated drying oven**, capable of maintaining a temperature of  $(63 \pm 3) ^\circ\text{C}$ ;
- **Vernier**, with an accuracy of 0,1 mm;
- **Steel rule**, with an accuracy of 0,5 mm.

#### A.3 Test methods

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Immersion and delamination tests shall be carried out according to the exposure classes of panels to be tested.

##### A.3.1 Pretreatment

Procedure of pretreatment shall be carried out in accordance with ISO 12466-1.

The classification given in ISO 12466-2 provides the information on the pretreatment to be carried out.

##### A.3.2 Test procedures

After being pretreated, the test pieces of different bonding quality classes of decorative veneered plywood shall be hold 3 h in a ventilated drying oven under  $(63 \pm 3) ^\circ\text{C}$ .

#### A.4 Expression of result and test report

Check if there is any failure and delamination between the surface veneer and the substrate.

Measure and record the length of each failure on the glue lines and add up when there are more than one, with an accuracy of 1 mm.