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**Plywood — Classification by surface  
appearance —**

**Part 1:  
General**

*Contreplaqué — Classification selon l'aspect des faces —*

*Partie 1: Généralités*

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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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this part of ISO 2426 may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 2426-1 was prepared by Technical Committee ISO/TC 89, *Wood-based panels*, Subcommittee SC 3, *Plywood*.

This first edition of ISO 2426-1, together with ISO 2426-2 and ISO 2426-3, cancels and replaces ISO 2426:1974, of which it constitutes a technical revision.

ISO 2426 consists of the following parts, under the general title *Plywood — Classification by surface appearance*:

- *Part 1: General*
- *Part 2: Hardwood*
- *Part 3: Softwood*

ISO 2426-1:2000

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# Plywood — Classification by surface appearance —

## Part 1: General

### 1 Scope

This part of ISO 2426 establishes general rules for the classification of plywood by its surface appearance.

It does not apply to overlaid plywood.

### 2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this part of ISO 2426. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of ISO 2426 are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

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

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

### 3 Classification by surface appearance

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#### 3.1 Classes

Classification of plywood by surface appearance is made according to the number and the extent of certain natural characteristics of wood and the defects that come from the manufacturing process.

Five appearance classes are distinguished, identified with the following codes: E, I, II, III, IV.

#### 3.2 Characteristics and defects taken into consideration

##### 3.2.1 Determination of appearance class

Determination of the appearance class, based on the appearance of the panel surfaces, shall take into account the categories of characteristics given in Table 1 and defects given in Table 2.

### 3.2.2 Characteristics inherent in wood

Categories of characteristics inherent in wood are listed in Table 1.

**Table 1**

Category		Type
3.2.2.1	Pin knots	
3.2.2.2	Sound intergrown knots	
3.2.2.3	a) Unsound knots b) Non-adhering and partially adhering c) Holes, except those due to insects, marine borers and parasitic plants	1) Dog holes 2) Knot holes
3.2.2.4	a) Splits  b) Checks	1) Open 2) Closed
3.2.2.5	Abnormalities due to insects, marine borers and parasitic plants	1) Small worm holes 2) Large worm holes 3) Marine borer holes 4) Marks from parasitic plants
3.2.2.6	a) Resin pockets b) Resin streaks c) Inbark	
3.2.2.7	Irregularities in the structure of the wood <sup>a</sup>	1) Angle grain 2) Curly grain 3) Interlocked grain 4) Spiral grain
3.2.2.8	Discoloration which is not wood-destroying	1) Blue stain, mould and fungal discoloration 2) Coloured sapstain 3) False heartwood 4) Other discoloration such as chemical stain and colour streaks
3.2.2.9	Fungal decay which is wood-destroying	Rot
3.2.2.10	Other characteristics	To be considered under the category which they most closely resemble

<sup>a</sup> When irregularities of grain result in roughness, these shall be considered as one category of characteristics.