
INTERNATIONAL STANDARD



2430

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

Plywood — Veneer plywood with rotary cut veneer for general use — Classification by appearance of panels with outer veneers of poplar

Contreplaqué — Contreplaqué à plis, avec placages déroulés, pour usage général — Classification, selon l'aspect, des panneaux à placages extérieurs de peuplier

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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 2430 was drawn up by Technical Committee ISO/TC 139, *Plywood*, and circulated to the Member Bodies in December 1971.

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

Australia
Austria
Belgium
Canada
Czechoslovakia
Egypt, Arab Rep. of
Germany
Hungary

India
Iran
Italy
Netherlands
New Zealand
Norway
Poland
Portugal

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Romania

South Africa, Rep. of

Spain

Sweden

Thailand

United Kingdom

U.S.S.R.

The Member Body of the following country expressed disapproval of the document on technical grounds :

France

Plywood — Veneer plywood with rotary cut veneer for general use — Classification by appearance of panels with outer veneers of poplar

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1 SCOPE AND FIELD OF APPLICATION

This International Standard establishes the permissible defects for the classification by appearance of surfaces of general purpose veneer plywood¹⁾ with rotary cut outer veneers of poplar.

NOTE — Species of poplar wood used for this purpose are indicated in the annex.

2 REFERENCE

ISO 2426, *Plywood — Veneer plywood with rotary cut veneer for general use — General rules for classification by appearance.*

3 CLASSIFICATION BY APPEARANCE

3.1 Classification of panels by appearance according to the combination of the grades of their two surfaces should be carried out in accordance with ISO 2426.

3.2 The surface of the panels should be classified by appearance based on the permissible defects laid down in clause 4.

4 PERMISSIBLE DEFECTS

Each surface is individually classified in one of the grades E, I, II, III or IV as defined by the permissible defects indicated in the following table.

1) Defined in ISO 2074, *Plywood — Vocabulary.*

PERMISSIBLE DEFECTS

Categories of defects			Grade					
			E	I	II	III	IV	
4.1.1	Pin knots		Practically without defects (see ISO 2426)	permitted in number up to 3 per m ²	permitted without restriction in number			Veneers shall be free from rot and must be well glued. Defects inherent in wood and manufacturing defects are permitted provided they do not impair the mechanical properties and serviceability of the panel.
4.1.2	Sound intergrown knots			permitted up to an individual maximum diameter of 15 mm 25 mm 50 mm provided their cumulative diameter does not exceed 60 mm 100 mm 300 mm per m ² . Such knots can have splits and stars provided they are very slight slight without restriction and properly filled				
4.1.3	Unsound or non-adhering knots and holes			excluded	permitted up to an individual maximum diameter of 10 mm 20 mm provided their cumulative diameter does not exceed 30 mm per m ² and they are properly filled 60 mm per m ²			
4.1.4	Irregularities in the structure of the wood			permitted if very slight if slight		permitted		
3.1.5	Splits and Checks	open		excluded	permitted, if properly filled, up to an individual maximum width of 3 mm 5 mm and up to an individual maximum length of 250 mm 350 mm and in number up to 3 3 per metre of panel width			
		closed		permitted : 1 of an individual maximum length up to 200 mm per metre of panel width	permitted			
4.1.6	Inbark			excluded			permitted	
4.1.7	Defects due to borers and parasitic plants		excluded	permitted, if properly filled, occasional small worm holes, vertical to the panel plane, of diameter up to 5 mm 5 defects of width up to 10 mm per m ²				

Veneers shall be free from rot and must be well glued. Defects inherent in wood and manufacturing defects are permitted provided they do not impair the mechanical properties and serviceability of the panel.

PERMISSIBLE DEFECTS (concluded)

Categories of defects		Grade				
		E	I	II	III	IV
4.1.8	Sound discoloration	Practically without defects (see ISO 2426)	permitted if slight up to maximum 33 % of the surface of panel without restriction provided the mechanical properties are not impaired			Veneers shall be free from rot and must be well glued. Defects inherent in wood and manufacturing defects are permitted provided they do not impair the mechanical properties and serviceability of the panel.
4.1.9	Unsound discoloration and decay		excluded			
4.1.10	Open joints		excluded	permitted, if properly filled, of maximum width up to 1 mm 4 mm and in number no more than 1 per metre of panel width		
4.1.11	Overlaps		excluded	permitted of a maximum length of 100 mm 300 mm and in number up to 1 per m ² 2 per m ²		
4.1.12	Blisters		excluded			
4.1.13	Hollows, bumps and imprints		excluded	permitted if very slight if slight		
4.1.14	Roughness		permitted if very slight	permitted if slight		
4.1.15	Sanding through		excluded		permitted up to an extent of 1 000 mm ² per m ² of panel surface	
4.1.16	Glue penetration		excluded	permitted if slight and occasional up to an extent of 5 % of the panel surface		
4.1.17	Inserts — patch — shim		excluded	permitted, if properly made, not exceeding 3 % of total panel surface without restriction		
4.1.18	Inclusions of aluminium clips		excluded	permitted		
4.1.19	Defects at the edges of the panel due to — sanding or — sawing		permitted up to — 5 mm 5 mm from the edge			
4.1.20	Other defects which are not indicated		To be considered under the heading of the category of defect most similar to it			

ANNEX

LIST OF THE DIFFERENT SPECIES OF POPLAR USED FOR THE MANUFACTURE OF PLYWOOD

No.	Botanical name	Name used in trade	Country of origin
1	<i>Populus balsamifera</i> L. (<i>Populus tacamahaca</i> Miller)	Balsam poplar	Canada and U.S.A.
2	<i>Populus deltoides</i> Marshall (Bartr ex Marshall)	Eastern cottonwood	Eastern Canada and U.S.A.
3	<i>Populus grandidentata</i> Michaux	Bigtooth aspen	Canada and U.S.A.
4	<i>Populus heterophylla</i> L.	Swamp cottonwood	Canada and U.S.A.
5	<i>Populus nigra europea</i> L. var. <i>typica</i> Schneider	Black poplar, European	Europe
6	<i>Populus tremula</i> L.	European aspen	Europe
7	<i>Populus tremuloides</i> Michaux	Quaking aspen	Canada and Eastern U.S.A.
8	<i>Populus trichocarpa</i> Torr and Gray (Hook)	Black cottonwood	Canada
9	<i>Populus nigra euroamericana</i> (Hibrids)	Black poplar, Euroamerican	Europe

Species which are not indicated in this table should be listed with those items which are of the corresponding species.

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