
**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.

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).

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).

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

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 89, *Wood-based panels*, Subcommittee SC 3, *Plywood*.

This second edition cancels and replaces the first edition (ISO 2426-1:2000), which has been technically revised.

The main changes compared to the previous edition are as follows:

- In the scope it is precised that, this document concerns plywood made of hardwood including tropical and temperate hardwood, softwood and plywood derived from other lignocellulosic materials.

A list of all parts in the ISO 2426 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Plywood — Classification by surface appearance —

Part 1: General

1 Scope

This document establishes general rules for the classification of plywood by its surface appearance. It concerns plywood made of hardwood including tropical and temperate hardwood, softwood and plywood derived from other lignocellulosic materials.

It does not apply to overlaid plywood.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

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

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

3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

4 Classification by surface appearance

4.1 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.

4.2 Characteristics and defects taken into consideration

4.2.1 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](#).

4.2.2 Characteristics inherent in wood

Categories of characteristics inherent in wood are listed in [Table 1](#).

Table 1 — Surface appearance classification of veneer

Category	Type
Pin knots	
Sound intergrown knots	
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
a) Splits b) Checks	1) Open 2) Closed
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
a) Resin pockets b) Resin streaks c) Inbark	
Irregularities in the structure of the wood ^a	1) Angle grain 2) Curly grain 3) Interlocked grain 4) Spiral grain
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
Fungal decay which is wood-destroying	Rot
Other characteristics	To be considered under the category which they most closely resemble
^a When irregularities of grain result in roughness, these shall be considered as one category of characteristics.	

4.2.3 Manufacturing defects

Categories of manufacturing defects are listed in [Table 2](#).