

# SLOVENSKI PREDSTANDARD

oSIST prEN 15146:2005

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Solid softwood panelling and cladding - Machined profiles without tongue and groove

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ICS 79.080

Referenčna številka  
oSIST prEN 15146:2005(en)



January 2005

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ICS

English version

## Solid softwood panelling and cladding - Machined profiles without tongue and groove

Lambris et bardages en bois massif résineux - Profilés  
usinés sans rainure et languette

Innen- und Außenbekleidungen aus massivem Nadelholz -  
Profilholz ohne Nut und Feder

This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 175.

If this draft becomes a European Standard, CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

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## Foreword

This document (prEN 15146:2005) has been prepared by Technical Committee CEN/TC 175 “Round and sawn timber”, the secretariat of which is held by AFNOR.

This document is currently submitted to the CEN Enquiry.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

This standard is one of a series of standards concerning solid wood panelling and cladding and wood flooring (including parquet).

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## Introduction

In this standard the characteristics of solid softwood panelling and cladding are described on the basis of individual elements.

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## 1 Scope

This European standard defines the characteristics of solid wood panelling and cladding without tongue and groove machined from the following most common european species of softwood: spruce/fir, pine, larch, European Douglas fir and maritime pine.

Products are intended for interior or exterior use.

NOTE products sold in the European Economic Area will have to comply with prEN 14915 under preparation.

## 2 Normative references

The following referenced documents are indispensable for the application 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.

EN 844-3 to EN 844-12, *Round and sawn timber - Terminology*.

EN 1309-1, *Round and sawn timber- Method of measurement of dimensions – part 1 : Sawn timber*

EN 1310, *Round and sawn timber - Method of measurement of features*

EN 1311, *Round and sawn timber - Method of measurement of biological degrade*

EN 13183-1, *Moisture content of a piece of sawn timber – Part 1 : Determination by oven dry method*

EN 13183-2, *Moisture content of a piece of sawn timber – Part 2 : Estimation by electrical resistance method*

prEN 13307-1, *Timber blanks and semi-finished profiles for non-structural uses – Part 1: Requirements*

EN 13556, *Round and sawn timber – Nomenclature of timbers used in Europe*

EN 13647, *Wood and parquet flooring and wood panelling and cladding – Determination of geometrical characteristics*

EN 13756, *Wood flooring – Terminology*

## 3 Terms and definitions

For the purposes of this European Standard, the terms and definitions given in EN 13756, EN 844-3 to EN 844-12, EN 1309-1 and the following apply.

### 3.1

#### **panelling and cladding without tongue and groove**

boards of solid wood without “tongue and groove” which have been *machined* on the face and two edges. The back is either machined or hit and/or missed, depending on the product. For special purposes (for instance, acoustic) the edges may have fastening slots. The ends of the boards may be endmatched

### 3.2

#### **endmatching**

any profile for connection at the end of the panelling or cladding, including tongue and groove

### 3.3

#### **panelling**

rigid or semi-rigid elements of solid wood mainly for interior use

### 3.4

#### **cladding**

rigid or semi-rigid elements of solid wood mainly for exterior use

### 3.5

#### **face**

visible surface of an element

## **4 Symbols and abbreviations**

Symbols and abbreviations used in this European Standard are given in Figure 1 and in Tables 3 and 4.

## **5 Requirements**

### **5.1 General**

The softwood species shall be selected with regard to the appearance expected, the suitability for the intended purpose and the general characteristics of the species itself. All requirements apply at the time of production, unless the manufacturer states otherwise.

### **5.2 Appearance and finishing**

#### **5.2.1 General**

Grading applies to the face only, unless otherwise specified. Machining requirements are covered in 5.4.4 and apply to all grades of all species.

The measurement of features shall be in accordance with EN 1310. Concerning knots the general method given in clause 4.1.1 in EN 1310 applies.

The boards may be finished with surface coating. The grading shall be done before coating.

#### **5.2.2 Grading classes**

Grading and the features for spruce (*Picea* spp.) / fir (*Abies* spp.), pine (*Pinus* spp.), larch (*Larix* spp.) and European Douglas Fir (*Pseudotsuga menziesii*) are given in Table 1. Grading and the features for Maritime Pine (*Pinus pinaster*) are given in Table 2.



**Table 1 — Grading classes of the wood species - Spruces (*Picea* spp.), fir (*Abies* spp.), pine (*Pinus* spp.), larch (*Larix* spp.), and European Douglas fir (*Pseudotsuga menziesii*)**

Features <sup>a b c</sup>	Grade A	Grade B
Knots	<p>permitted:</p> <ul style="list-style-type: none"> <li>- black pin knots up to 5 mm if not in clusters;</li> <li>- sound intergrown knots up to 10 % of width + 35 mm;</li> <li>- partially intergrown knots, barkringed knots, splay knots and dead knots (not loose)</li> </ul> <p>spruce/fir, and larch: up to 10 % of width +15 mm</p> <p>pine, and Douglas Fir: up to 10 % of width +30 mm;</p> <p>-occasional small missing and damaged arris knots up to 20% of the largest acceptable knot size provided coverage is not affected</p> <p>- knot-plugs of the same wood species, up to the largest allowed knot size.</p> <p>not permitted:</p> <ul style="list-style-type: none"> <li>- loose knots, knot-holes and unsound knots</li> </ul>	<p>permitted:</p> <ul style="list-style-type: none"> <li>- black pin knots up to 5 mm;</li> <li>- sound intergrown knots, partially intergrown knots, barkringed knots, splay knots, and dead knots up to 10 % of width + 50 mm;</li> <li>- occasional loose knots, knot-holes and unsound knots up to 15 mm;</li> <li>- knot plugs of the same wood species.</li> </ul>

Features <sup>a b c</sup>	Grade A	Grade B
Chipped Grain (machined damaged spots)	permitted  with knots: up to 20 % of knot area;  with other spots up to 20 % of the maximum knot size (one per m)	permitted  with knots: up to 40 % of knot area;  with other spots up to 40 % of the maximum knot size.
Compression wood	permitted	
Deformation	permitted if correct fastening is possible	
Stick marks	Not permitted	permitted
Resin pockets	permitted:  - occasionally up to the size of 2 mm x 25 mm or equal in mm <sup>2</sup>  - 1 resin pocket up to the size of 5 mm x 50 mm or equal in mm <sup>2</sup> per 1,5 m in length	permitted:  - up to the size of 2 mm x 35 mm or equal in mm <sup>2</sup>  unlimited  - 3 resin pockets up to the width of 6 mm and a total length of 150 mm or equal in mm <sup>2</sup> per 1 m in length
Fissures (shakes)	permitted:  - hair fissures (barely visible);  - end shakes not longer than width of the boards.  end shakes:  Boards with T+G at the end: Occasionally if not longer than ½ of the width of the boards  not permitted:  - fissures (shakes) going through with the exception of end shakes;  - fissures extending from face to edge;  - ring shakes;  - fissures on the reverse side, continuing for the full length of the board	permitted:  - face shakes going through (max. 1 mm wide) up to 300 mm in length;  end shakes not longer than twice the width, occasionally permitted if boards have tongue and groove at the ends.  not permitted:  - ring shakes;

Features <sup>a b c</sup>	Grade A	Grade B
Pith	permitted at 1/3 of length not more than 5 mm in width	permitted
Colour	face side: without any discolouration (discolouration on the reverse side <i>is permitted</i> )	permitted: slight discolouration as red and blue stain (discolouration on the reverse side <i>is permitted</i> )
Fungal attack	not permitted	not permitted (exception: discolouration - see „colour“)
Insect damages	not permitted	
Wane	not permitted on face, permitted on the back side not longer than the width of the board.	not permitted on face, permitted on back side up to 1/4 of the length
Ingrown bark	permitted: occasional up to the size of 5 mm x 50 mm or equal in mm <sup>2</sup>	permitted

a Not more than 5 % of the quantity of the consignment is allowed to be in the next lower grade. Pieces not achieving the requirements of the B grade must fulfil the principles of panelling and cladding end use.

b The classification for appearance does not take into account features which may impair the element when installed.

c The face comprises the whole visible surface of the strip when assembled. It therefore extends to the edges and in particular to the chamfers.

**Table 2 — Grading classes - Maritime Pine (Pinus pinaster)**

Features <sup>a b c</sup>	Grade 0 (SN)	Grade A (PN)	Grade B
Knots	<p>permitted:</p> <p>(not considered)</p> <p>knots <math>\leq 2</math> mm if not grouped together</p> <p>not permitted:</p> <p>other knots and loose knots</p> <p>knot plugs</p>	<p>permitted:</p> <p>sound and intergrown knots even slightly checked with a diameter <math>\leq 35</math> mm but not grouped together</p> <p>black knots (except loose knots) or having lack of material on the face of a diameter <math>\leq 15</math> mm</p> <p>knot plugs of the same wood species, up to the largest allowed knot size</p> <p>not admitted: loose knots, unsound knots, knots over limits permitted</p>	<p>permitted:</p> <p>knots without limitation in diameter</p> <p>knot plugs of the same wood species</p> <p>not admitted: loose knots, unsound knots</p>