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## Standard Terminology Relating to Veneer and Plywood<sup>1, 2</sup>

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### INTRODUCTION

The terms included in this terminology standard are intended to apply to a family of wood veneer-based panel products manufactured for use in construction and industrial applications.

#### 1. Scope

- 1.1 This standard covers a repository of terms and classifications essential needed for the business of Subcommittee D07.03.
- 1.2 The terms in this standard pertain to processing and characteristics of wood veneer and plywood products.

#### 2. Terminology

**adhesive**—a substance capable of holding materials together by surface attachment.

NOTE 1—adhesive is the general term and includes, among others, cement, glue, mucilage, and paste. All of these terms are loosely used interchangeably. Various descriptive adjectives are applied to the term adhesive to indicate certain characteristics as follows:

- (1) Physical form, that is, liquid adhesive, tape adhesive
- (2) Chemical type, that is, silicate adhesive, resin adhesive
- (3) Materials bonded, that is, paper adhesive, metal-plastic adhesive, can label adhesive
- (4) Conditions of use, that is, hot-setting adhesive

**back**—the side reverse to the face of a panel, or the poorer side of a panel in any grade of plywood calling for a face and back.

**balanced construction**—See under **construction**.

**banding (railing)**—a portion of wood or other material extending around one or more edges of a plywood panel.

**bleed through**—~~glue~~—adhesive or components of ~~glue~~adhesive that have seeped through the outer layer or ply of a ~~glue~~**bonded** wood product and that show as a blemish or discoloration on the surface.

**blemish**—anything marring the appearance of the veneer that is not classifiable as a defect.

**blister**—*in plywood*, an elevation of the surface of an adherend (separation between plies), somewhat resembling in shape a blister on the human skin; its boundaries may be indefinitely outlined and it may have burst or become flattened.

**bolt (veneer)**—a short log cut to length suitable for peeling in a lathe; also block.

**bond, n**—the attachment at an interface between an adhesive and an adherend.

**bond, v**—to attach materials together by means of an adhesive.

**borer holes**—voids made by wood-boring insects.

**broken grain (shelling, leafing, grain separation)**—a separation on veneer surface between annual rings.

**cauls, n**—sheets of material employed singly or in pairs in hot or cold pressing of assemblies being bonded. Cauls are employed usually to protect either the faces or the press platen or both against marring and staining, to prevent sticking, to facilitate press loading, or to impart a desired surface texture or finish, and to provide uniform pressure distribution.

NOTE 2—Cauls may be made of any material such as aluminum, stainless steel, hardboard, fiberboard, or plastic, with the length and width generally equal to the platen size of the press in which they are employed.

**center**—inner layers whose grain direction runs parallel to that of the outer plies; may be of parallel laminated plies. (See also **core**.)

**clipper**—the shearing machine used to dimension dry or green veneers to width.

<sup>1</sup> This terminology is under the jurisdiction of ASTM Committee D07 on Wood and is the responsibility of Subcommittee D07.03 on Panel Products.

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<sup>2</sup> These definitions are specific to veneer and plywood. Other definitions relating to timber appear in ASTM Terminology D9, Relating to Wood, *Annual Book of ASTM Standards*, Vol 04.10.

**compreg**—synthetic resin-treated, compressed wood with reduced swelling and shrinking characteristics and increased density and strength properties.

**construction**—details of arrangement or thickness or both, of veneers and other components used in the fabrication of plywood.  
*all-veneer construction*—plywood in which all plies are veneer. Ordinarily no single ply of veneer will exceed  $\frac{5}{16}$  in. (7.9 mm) in thickness.

*balanced construction*—a construction such that the forces induced by uniformly distributed changes in moisture content will not cause warpage.

*composite construction*—a panel assembly consisting of veneers and other wood-based materials. Normally the non-veneer component is identified in describing the construction.

*lumber core construction*—plywood in which the center ply or core is of lumber rather than of veneer. Ordinarily cores that are  $\frac{3}{8}$  in. (9.5 mm) or greater in thickness will be of lumber.

*symmetrical construction*—plywood panels in which the plies on one side of the panel center line are essentially equal in thickness, grain direction, properties, and arrangement to those on the other side of the center line.

**core**—(1) in decorative or hardwood plywood, the center most ply. It may be of lumber (either edgeglued or closely assembled) or other wood-based panel material, or of one or more thicknesses of veneer.

(2) in construction plywood, all plies or layers between the face and back.

**core block**—in cutting rotary veneer, the portion of the bolt remaining after available veneer has been removed.

**cross band, n**—inner layers of veneer whose grain direction is usually perpendicular to that of the face plies, applied particularly to plywood of five or more plies and lumber-core panels.

**cross band, v**—to place the grain of the inner layer of veneer at right angles to that of the face and back.

**delamination, n**—the separation of layers in a laminate because of failure of the adhesive, either in the adhesive itself or at the interface between the adhesive and the adherend.

**dryer**—a kiln or chamber, or machine through which the green veneers are passed to remove excess moisture.

**durability**—(1) as applied to wood, its lasting qualities or permanence in service with particular reference to decay.

(2) as applied to the glueadhesive bond, its resistance to deterioration related to exposure conditions. (See also **delamination**.)

**exterior type plywood**—a term applied to plywood that is capable of withstanding prolonged exposure to severe service conditions including prolonged and repeated wetting without failure in the glueadhesive bonds; the commercial classification is a function of veneer grade as well as glueadhesive durability.

**face**—the better side of a panel in any grade of plywood calling for a face and back; also either side of a panel where the grading rules draw no distinction between faces.

**flitch**—a portion of a log sawed on two or more sides and intended for remanufacture into sliced or sawn veneer. The term is also applied to the resulting sheets of veneer stacked together in sequence of cutting.

**gap**—an open joint or split in the inner plies which results when crossband or center veneers are broken or not tightly butted.

**glue, n**—See **adhesive**.

**groove**—a decorative face treatment, consisting of narrow parallel channels formed into the surface of the panel; such as machined.

*V-groove*—narrow and shallow V- or U-shaped channels machined on the plywood face to achieve a decorative effect.

**impreg**—wood impregnated with synthetic resin that is cured in place so as to reduce materially swelling and shrinking of the wood on exposure to varying environmental conditions.

**inner plies**—plies other than face or back plies in a panel construction. Subface, subback, crossband, and center are classed as inner plies.

**interior type plywood**—a term frequently applied to plywood bonded with adhesives that maintain adequate bonds under conditions usually existing in the interior of buildings; the commercial classification is a function of veneer grade as well as glueadhesive durability.

**joint**—the junction of two adjacent pieces of wood or veneer.

*butt joint*—the place where two pieces of wood are joined together end to end. adhesive joint—the place where two pieces of wood are joined together by means of adhesive.

*edge joint*—the place where two pieces of wood are joined together edge to edge. —the place where two pieces of wood are joined together edge to edge (joint running parallel to the grain).

*glue joint*—the place where two pieces of wood are joined together by means of glue. end joint—the place where two pieces of wood are joined together end to end (joint running perpendicular to the grain) which may be accomplished by a butt joint, scarf joint, or lap joint.

*open joint*—failure of bond or separation of two adjacent pieces of veneer so as to leave veneers. —a discontinuity between two adjacent veneers within a ply (gap).

*starved joint*—a glue—an adhesive joint that is poorly bonded because of an insufficient quantity of glue—adhesive.

*sunken joint*—in the case of plywood, a depression in the surface of the face ply directly above an edge joint in a lumber core or crossband. Usually the result of localized shrinkage in the edge-jointed layer.

**jointed**—veneer or other ply components that have machined edges for tightest possible layup.

**knotholes**—voids remaining after removal of knots.