
INTERNATIONAL STANDARD



3397

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Broadleaved wood raw parquet blocks — General characteristics

Frises brutes en bois feuillus pour parquets — Caractéristiques générales

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Descriptors : construction materials, wood products, floor coverings, wood floors, parquet blocks, broadleaved timber, specifications, dimensions, sampling, quality control, designation, delivery, marking.

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 3397 was drawn up by Technical Committee ISO/TC 99, *Semi-manufactures of timber*, and was circulated to the member bodies in May 1974.

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It has been approved by the member bodies of the following countries :

Austria	Ireland	South Africa, Rep. of
Bulgaria	Netherlands	Spain
France	Norway	Thailand
Germany	Poland	Turkey
Hungary	Romania	Yugoslavia

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The member bodies of the following countries expressed disapproval of the document on technical grounds :

Czechoslovakia
Italy
U.S.S.R.

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1 SCOPE

1.1 This International Standard lays down the manufacturing characteristics and the dimensions, the permissible deviations, the methods for quality control and the delivery conditions, the measurement and the marking of broadleaved wood raw parquet blocks.

1.2 The classification of raw parquet blocks according to specific characteristics and wood defects are laid down, for the different species of wood, in separate International Standards intended for grades.

2 FIELD OF APPLICATION

This International Standard applies to raw parquet blocks used for the manufacture of solid wood parquets and mosaic parquets.

3 REFERENCES

ISO 2036, *Marking of different species of wood utilized in the manufacture of wood flooring — Code of symbols.*

ISO 3130, *Wood — Determination of moisture content in physical and mechanical tests.*

4 DEFINITIONS

For the purpose of this International Standard, the following definitions apply:

4.1 raw parquet block : Piece of edged timber having a maximum thickness of 26 mm, a width between 35 and 120 mm and a minimum length of 150 mm, intended for the manufacture of parquet flooring.

4.2 face of raw parquet block : Wide side of parquet block having the smallest possible number of defects and used as reference side.

4.3 back of raw parquet block : Wide side of parquet block opposite to the face.

5 MANUFACTURE

5.1 Raw parquet blocks shall have the faces and the edges flat and parallel.

Contiguous edges and faces shall form parallel sharp arrises.

5.2 The arrises of the ends shall be perpendicular to the lateral arrises of the parquet block faces.

6 REQUIRED CHARACTERISTICS

6.1 Dimensions

See table 1.

6.2 Squareness of ends

A slope of 2 % is allowed for the squareness of ends.

6.3 Moisture

Unless otherwise agreed upon between the interested parties, the moisture of raw parquet blocks at delivery shall be not more than 20 % on dry mass.

7 SAMPLING

7.1 The inspection of the characteristics of raw parquet blocks shall be carried out in compliance with the requirements set out below, on pieces of which the representative sample is composed, taken from the batch.

7.2 Unless otherwise agreed upon between the interested parties, a batch of raw parquet blocks is an assembly of raw parquet blocks of the same wood species, nominal thicknesses and grade, presented in a single delivery for inspection.

A sample shall be taken from each batch.

7.3 The sample consists of a number of raw parquet blocks, taken at random from the batch; the number of raw parquet blocks in a sample shall be at least that specified in table 2.

7.4 When the number of rejected raw parquet blocks does not exceed the values specified in table 2, the batch is accepted. Otherwise, the batch shall be regrouped and presented for a new inspection.

8 INSPECTION METHODS

8.1 All the raw parquet blocks making up a sample shall be inspected individually.

8.2 The dimensions and the squareness of the arrises of ends to the lateral arrises of faces shall be checked with measuring instruments capable of recording to the prescribed degree of accuracy. The measurements shall be carried out at least at two points.

No dimensions shall lie outside the tolerances specified in clause 6.

8.3 The flatness shall be checked by the application of one of the raw parquet block faces on a perfectly flat surface and by measuring the deviations with appropriate measuring instruments.

8.4 The dimensions of defects shall be measured with the appropriate measuring instruments.

8.5 Non-measurable defects and the appearance shall be visually examined.

8.6 The moisture content should be determined by means of an electrical device.

NOTE — In case of disagreement, the moisture content shall be determined by the gravimetric method specified in ISO 3130.

9 DESIGNATION

The raw parquet blocks shall be designated by stating successively :

- the symbol of the wood species according to ISO 2036;
- the dimensions (thickness × width × length), expressed in millimetres;
- the grade;
- the number of the International Standard referring to the respective species of wood.

Example of designation of oak raw parquet blocks, 22 mm thick, 50 mm wide, 400 mm long, of the first grade :

ISO 3397:1977

QUER 22 × 50 × 400 — I

ISO 3398

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10 DELIVERY

10.1 Packaging

10.1.1 When the raw parquet blocks are delivered in bundles, they shall, unless otherwise agreed upon, be of the same species, dimensions (thickness, width, length) and grade, and be bound in bundles of 10 or more, by multiples of 10.

10.1.2 The bundles shall be tightly bound at their ends with strong and durable bonds (metal wire or strip, plastics or other similar materials).

10.1.3 The bundles or the raw parquet blocks may be transported on pallets or in containers.

10.2 Moisture

The moisture content of raw parquet blocks at delivery shall correspond to the provisions of 6.3.

10.3 Measurement

The volume shall be calculated on the basis of the nominal dimensions and shall be expressed in cubic metres, to three decimal places. In order to determine the volume, during the measurement of dimensions the increments specified in 6.1 shall not be taken into account.

TABLE 1

Values in millimetres

	Dimension		Minimum dimension at 15 % moisture content ²⁾	Minimum sawing dimension in green condition ³⁾
	nominal	tolerance ¹⁾		
Thickness	19	+ 2 0	19	21
	22		22	24
	25		25	27
	26		26	28
Width	40 to 120 varying by steps of 10	+ 2 0	42 to 122 varying by steps of 10	45 to 75 for widths from 40 to 70 87 to 127 for widths from 80 to 120
	150 to 850 varying by steps of 50 900 and more varying by steps of 100		+ 10 0	170 to 870 varying by steps of 50 920 and more varying by steps of 100

1) Exclusive of the tolerances on flatness and parallelism that are defined by separate International Standards on the classification of parquet blocks.

2) These minimum dimensions have a safety oversize of 2 mm for the width and of 20 mm for the length in relation to the nominal dimensions, beside the increments due to the excess of moisture.

3) It will be necessary to adapt these dimensions depending upon the sawing direction and the shrinkage coefficient of the species.

TABLE 2

Number of pieces in the batch	Number of pieces in the sample	Permitted number of rejected pieces in the sample
up to 300	35	2
from 301 to 500	50	3
from 501 to 800	75	4
from 801 to 1 300	110	6
from 1 301 to 3 200	150	8
from 3 201 to 8 000	225	11
from 8 001 to 22 000	300	14
from 22 001 to 110 000	450	20
from 110 001 to 550 000	750	31
over 550 000	1 500	56

11 MARKING

11.1 Unless otherwise agreed upon between the interested parties, the marking of raw parquet blocks at delivery from the works is compulsory.

11.2 The marking shall be carried out legibly by applying a stamp with a water-proof and slightly penetrating product to one of the sides of the bundle or to each unit of the load.

The stamp shall contain compulsorily the items given in clause 9.

Example of marking

For oak raw parquet blocks, first grade, 22 mm thick,

70 mm wide and having different lengths totalling 8,00 m, the marking shall be the following :

QUER
22 × 70 × 8,00
I
ISO 3398

11.3 On the purchaser's request, the indication of the country of origin and the trade mark may be inscribed in addition to the indications specified in clause 9.

Example of marking

For oak raw parquet blocks, first grade, 22 mm thick, 50 mm wide and 400 mm long, manufactured in Romania by CPL :

QUER
22 × 50 × 400
I
ISO 3398
RO
CPL

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