

## *Simplified grading rules for plywood. Quality of face veneer.*

Grades acc. PN-EN 635-2	I	II	III	IV
Pin knots	Not more than 3 per square meter	Allowed	Allowed	Allowed
Sound intergrown knots	Allowed with diameter not more than 15 mm	Allowed with diameter not more than 35mm - knots may have cracks as long as they are small.	Allowed with cracks not wider than 1,5 mm	Allowed
Other knots	Allowed with maximum diameter 6 mm	Allowed with maximum diameter 6 mm	Allowed with maximum diameter 6 mm	Allowed with maximum diameter 40 mm
Closed splits	Maximum length 200 mm	Allowed	Allowed	Allowed
Open splits	Not allowed	It is allowed if they are smaller than 1/5 of the board's length, up to a unit width of 5mm in the number up to 3pcs / m of the board width if they are well filled (eg with putty)	Allowed with maximum size 300*2 mm	Allowed with maximum width 10 mm
Light discoloration	Allowed not more than 5% of the surface	<b>Allowed</b>	Allowed	Allowed
Heavy discoloration	Not allowed	Not allowed	Not allowed	Allowed
Glue penetration (through faces)	Not allowed	<b>Allowed not more than 3% of the surface of the panel</b>	Allowed not more than 5% of the surface of the panel	Allowed
Veneer overlapping	Not allowed	Allowed with max 1 overlapping/m2 max length 100 mm	Allowed with max length 200 mm	Allowed
Repairing by plugs	Not allowed	Allowed with max 6 plugs on /m2 if they are made properly and tightly filled	Allowed with double plugs	Allowed with double plugs
Sanding through faces	Not allowed	Not allowed	Not allowed	Allowed

*In practice plugs are the main difference between B and BB grade – there are plugs on BB faces and there are no plugs on B faces. Grades B, BB, CP are usually sanded Grade C is unsanded unless specified as an option*

