

Selected allowed defects of coniferous plywood according to PN EN 635-3 norm

No.	Category of specific characteristics	Grade I	Grade II	Grade III	Grade IV
1	Pin knots	Allowed 3 per m ²	Allowed	Allowed	Allowed
2	Sound tight knots	Allowed if diameters of individual knots do not exceed 15mm, while the total diameter is below 30mm/m ² Knot cracks allowed if very small	Allowed if diameters of individual knots do not exceed 50mm Knot cracks allowed if very small	Allowed if diameters of individual knots do not exceed 60mm	Allowed if they do not lower the sheet usefulness
3	Unsound and loose knots, knot holes	Allowed if diameters of individual ones do not exceed 6mm, if they are filled and not more than 2/m ²	Allowed if diameters of unrepaired individual ones do not exceed 5mm, while diameters of filled ones do not exceed 25mm, and not more than 6/m ²	Allowed if diameters of individual ones do not exceed 40mm	Allowed if they do not lower the sheet usefulness
4.1	Wide cracks	Allowed if smaller than 1/10 of the sheet length, if	Allowed if smaller than 1/3 of the sheet length, if their widths do not exceed 10mm. All cracks exceeding 2mm must be filled	Allowed if smaller than 1/2 of the sheet length, if their widths do not exceed 15mm and not more than 2/m of sheet width	Allowed if they do not lower the sheet usefulness

		their widths do not exceed 3mm and not more than 3/m of sheet width, if properly filled			
4.2	Tight cracks	Allowed	Allowed	Allowed	Allowed
5	Damage caused by insects, naval shipworm, and parasitic plants	Not allowed	Traces of parasitic plants Not allowed. Larval and naval shipworm galleries allowed if their diameter do not exceed 3mm horizontally to the sheet surface, up to 10/m ²	Traces of parasitic plants Not allowed. Larval and naval shipworm galleries allowed if their width do not exceed 15 mm and length + 60mm, up to 3/m ²	allowed if they do not lower the sheet usefulness
6	Resin pockets and ingrown bark	Not allowed	Allowed if width does not exceed 6mm	Allowed if width does not exceed 40mm	Allowed if they do not lower the sheet usefulness
7	Excessive amount of natural resin	Not allowed	Allowed if minor	Allowed	Allowed
8	Deviation in wood structure	Allowed if very small	Allowed if very small	Allowed	Allowed
9	Discolourations not causing wood damage	Minor discolouration allowed	Minor discolouration allowed	Allowed	Allowed
10	Decay caused by fungi	Not allowed	Not allowed	Not allowed	Not allowed
11	Other characteristics	Should be considered as belonging to the category it correspond	Should be considered as belonging to the category it corresponds the most to	Should be considered as belonging to the category it corresponds the most to	Should be considered as belonging to the category it corresponds the most to

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Classification according to manufacturing defects					
No	Category of specific characteristics	Grade I	Grade II	Grade III	Grade IV
1.	Open binds	Not allowed	Allowed if width does not exceed 3mm, not more than 1 per meter of sheet width, in case of filled binds, if the width exceeds 1 mm	Allowed if width does not exceed 10mm, not more than 2 per meter of sheet width, with unfilled binds	Allowed if width does not exceed 25mm. No limitations concerning width of the sheet with unfilled binds
2.	Veneer overlaps	Not allowed	Allowed if length does not exceed 10mm, not more than 1/m ²	Allowed if not more than 2/m ²	Allowed if not more than 1/m ² if length does not exceed 100mm according to the amended norm
3.	Bubbles	Not allowed	Not allowed	Not allowed	Not allowed

4.	Hollows, imprints, burls	N o t a l l o w e d	Allowed if very small	Allowed	Allowed
5.	Rough surface	N o t a l l o w e d	Allowed if minor	Allowed	Allowed
6.	Grinding	N o t a l l o w e d	Not allowed	Allowed if not exceeding 1% of the sheet surface	Allowed if not exceeding 5% of sheet surface, if it not lower the sheet usefulness
7.	Adhesive soaked through	N o t a l l o w e d	Allowed if rare and in small amounts	Allowed on up to 5% of the sheet surface	Allowed if it does not lower the sheet usefulness
8.	Foreign bodies	N o	Iron particles not allowed	Iron particles not allowed	Iron particles not allowed

		t a l l o w e d			
9.	Repairs a) patches b) wedges	A l l o w e d i f p e r f o r m e d p r o p e r l y a n d t i g h t l y	Allowed if performed properly and tightly filled, without reservations concerning their number	Allowed if performed properly and tightly filled, no limitations concerning their number	Allowed if performed properly and tightly filled, no reservations concerning their number

		filled, not more than 5 / m ²			
10.	Repairs - synthetic filling	Not allowed	Allowed in extent allowed according to categories	Allowed in extent allowed according to categories	Allowed without reservations
11.	Sheet edge damage caused by sanding or sawing	Allowed	Allowed up to 5mm from the edge	Allowed up to 5mm from the edge	Allowed if performed properly and tightly filled, no reservations concerning their number

		o 2 m m f r o m t h e e d g e			
12.	Other characteristics or defects	S h o u l d b e c o n s i d e r e d a s b	Should be considered as belonging to the category it corresponds the most to	Should be considered as belonging to the category it corresponds the most to	Should be considered as belonging to the category it corresponds the most to

		elongating to the category it corresponds to them		
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