

## ECO-CORE WHITE BIRCH MULTIPLY FACE GRADES

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### ➤ B Face

#### Category of Defects

#### Permissible Amount of Defects\*

Pin knots light

Permitted with total quantity not more than 3 per m<sup>2</sup>

Sound intergrown knots light colour only

Permitted up to an individual maximum diameter of 15mm with total quantity not more than 5 per m<sup>2</sup>

Other knots

Permitted up to an individual maximum diameter of 6mm with total quantity not more than 3 per m<sup>2</sup>

Knots and knotholes repair

Not permitted

Closed splits

Permitted for an individual maximum length up to 200mm and in number up to 2 per one panel's running meter

Open splits

Not permitted

Irregularities in the structure of the wood

Permitted

Hearth and discoloration

Not more than 5% of the surface

Defects at the edges due to sanding or sawing

Permitted up to 2mm from the edge

Glue penetration

Not permitted

Sanding through

Not permitted

Inner plies veneer overlapping

Not permitted

Conforms to Formaldehyde class emission Super E0

\*TU 5512-001-447-79728-2002

## ECO-CORE WHITE BIRCH MULTIPLY FACE GRADES

### ➤ S Face

#### Category of Defects

Pin knots light

Sound intergrown knots light / dark

Partly intergrown, open knots, knotholes, worm tracks

Closed splits

Open splits

Irregularities in the structure of the wood

Hearth and discolouration

Defects at the edges due to sanding or sawing

Glue penetration

Sanding through

Inner plies veneer overlapping

#### Permissible Amount of Defects\*

Permitted (diameter to 3mm)

Allowed up to an individual maximum diameter of 20mm with total quantity not more than 2.5 per m<sup>2</sup> (or total diameter up to 50mm/m<sup>2</sup> of the panel square) 0.5

Allowed up to an individual maximum diameter of 10mm with total quantity not more than 2.5 per m<sup>2</sup> (or total diameter up to 25mm/m<sup>2</sup> of the panel square) 0.5

Allowed for an individual maximum length up to 200mm with total quantity not more than 2 per one panel's running meter

Allowed for an individual maximum length up to 200mm and width up to 2mm with total quantity not more than 1 per one panel's running meter

Allowed cross grain, curly grain and burls

Not more than 20% of the surface

Allowed up to 5mm from the edge

Allowed not more than 1% of the panel surface

Not allowed

Not allowed

Conforms to Formaldehyde class emission Super E0

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## ECO-CORE WHITE BIRCH MULTIPLY FACE GRADES

### ➤ BB Face

#### Category of Defects

Pin knots light

Sound intergrown knots light colour only

Other knots and knotholes

Repaired defects (inserts)

Double inserts

Closed splits

Open splits

Irregularities in the structure of the wood

Hearth and discoloration

Defects at the edges due to sanding or sawing

Glue penetration

Sanding through

Inner plies veneer overlapping

Conforms to Formaldehyde class emission Super E0

#### Permissible Amount of Defects\*

Permitted

Permitted up to an individual maximum diameter of 25mm with total quantity not more than 10 per m<sup>2</sup>

Permitted up to an individual maximum diameter of 6mm with total quantity not more than 6 per m<sup>2</sup>

Not more than 8 pieces per 1m<sup>2</sup> of surface

Not permitted

Permitted for an individual maximum length up to 200mm and in number up to 2 per one panel's running meter

Permitted for an individual maximum width up to 2mm and for individual maximum length up to 200mm and in number not more than 2 per one panel's running meter

Permitted

Not more than 30% of the surface

Permitted up to 4mm from the edge

Permitted up to 2% of the surface

Not permitted

Permitted for an individual maximum length up to 100mm and in number maximum 2 per one panel's running meter.

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## ECO-CORE WHITE BIRCH MULTIPLY FACE GRADES

### ➤ Light Bark

– inbark matching the surrounding wood in colour, without bark inclusions.

B(I)	Permitted
DS	
BB(II)	
SSL	
CP (III)	
C (IV)	

### ➤ Eyes

– traces of buds undeveloped into a shoot, light and dark scattered and in groups.

B(I)	Permitted
DS	
BB(II)	
SSL	
CP (III)	
C (IV)	

### ➤ False heartwood

– dark unevenly coloured heartwood which boundary does not coincide with annual growth rings, separated from sapwood with a dark outline, as firm as the surrounding wood.

B(I)	Not permitted
DS	Permitted not over 25% of the sheet surface
BB(II)	
SSL	Permitted not over 75% of the sheet surface
CP (III)	
C (IV)	Permitted

### ➤ Low Spot

– local indentation in the outer ply.

B(I)	Not permitted
DS	
BB(II)	Permitted within the limits of the thickness tolerance
SSL	
CP (III)	Permitted
C (IV)	

## ECO-CORE WHITE BIRCH MULTIPLY FACE GRADES

### ➤ Wood Insert

B(I)	Not Permitted
DS	
BB(II)	Permitted if matched in colour
SSL	Permitted
CP (III)	
C (IV)	

### ➤ Wood discolouration

B(I)	Permitted not over 5% of the sheet surface
DS	Permitted not over 50% of the sheet surface
BB(II)	
SSL	Permitted
CP (III)	
C (IV)	

### ➤ Double Insert

B(I)	Not permitted
DS	
BB(II)	Permitted if matched in colour
SSL	Permitted
CP (III)	
C (IV)	

### ➤ Dark Inbark

– inbark considerably darker than the surrounding wood, with/without bark inclusions.

B(I)	Not Permitted
DS	
BB(II)	
SSL	
CP (III)	Permitted
C (IV)	

## ECO-CORE WHITE BIRCH MULTIPLY FACE GRADES

### ➤ Torn grain

– deep spots on the surface as a result of local withdrawal of wood in the process of manufacture.

B(I)	Not permitted	
DS		
BB(II)		5
SSL	Permitted, % of the sheets surface, not over	15
CP (III)		15
C (IV)	Permitted	

### ➤ Sound intergrown knots (up to 6mm in diameter)

Light (knots matching the surrounding wood in colour)

Dark (knots considerably darker than the surrounding wood)

B(I)	Permitted
DS	
BB(II)	
SSL	
CP (III)	
C (IV)	

### ➤ Sound intergrown light and dark knots (over 6mm in diameter)

B(I)	Not Permitted
DS	
BB(II)	
SSL	
CP (III)	Permitted
C (IV)	

### ➤ Sanding through

B(I)	Not permitted
DS	
BB(II)	Permitted along the edge if slight
SSL	
CP (III)	
C (IV)	Permitted

## ECO-CORE WHITE BIRCH MULTIPLY FACE GRADES

### ➤ Splicing

B(I)	Permitted not over 4 strips per sheet matched in wood colour, without open joints
DS	
BB(II)	
SSL	Permitted without colour match, with open joints
CP (III)	
C (IV)	

### ➤ Scratches

- damage to the surface in the form of a long recess caused by a sharp object.

B(I)	Not permitted
DS	
BB(II)	Permitted
SSL	
CP (III)	
C (IV)	

### ➤ Loose knots, knot holes

- knots not intergrown with the surrounding wood, holding loose in it.

B(I)	Permitted not over 6mm in diameter up to 3 per 1 m <sup>2</sup> of the sheet surface
DS	Not permitted
BB(II)	Permitted not over 6mm in diameter up to 6 per 1 m <sup>2</sup> of the sheet surface
SSL	Not permitted
CP (III)	Permitted not over 6mm in diameter up to 10 per 1 m <sup>2</sup> of the sheet surface
C (IV)	Permitted not over 40mm in diameter not restricted in number

## ECO-CORE WHITE BIRCH MULTIPLY FACE GRADES

### ➤ Open splits

B(I)	Not permitted		
DS	Not permitted		
	BB(II)	SSL	CP (III)
	Permitted in length, mm not over		
	200	300	300
	in width, mm not over		
	2	2	2
	in quantity, pieces, not over		
	2	2	2
	Including 1 split up to 600mm in length up to 5mm in width if puttied		
C (IV)	Without restriction		

### ➤ Overlap

– local thickening as a result of veneer overlap in one ply

B(I)	Not permitted			
DS		100		1
BB(II)	Permitted in width, mm not over	100	In quantity, pcs, not over	1
SSL		200		1
CP (III)		200		2
C (IV)	Permitted			

### ➤ Veneer shortage

– the defect is characterized by lack of a part of veneer sheet in plywood.

B(I)		2
DS		2
BB(II)	Permitted in width, mm, not over	4
SSL		4
CP (III)		4
C (IV)		5



## ECO-CORE WHITE BIRCH MULTIPLY FACE GRADES

### ➤ Warpage

– curvature of a plywood sheet.

B(I)	In plywood, up to 6.5mm thick disregarded; 6.5mm thick and more permitted with the sag not over 15mm per 1m of the sheet diagonal.
DS	
BB(II)	
SSL	
CP (III)	
C (IV)	

### ➤ Glue penetration

– the defect looks like stains on the surface of plywood as a result of glue penetration from the lower ply.

B(I)	Not permitted	
DS	Not permitted	
BB(II)	Permitted not over % of sheet surface	2
SSL		5
CP (III)		5
C (IV)	Permitted	

## ECO-CORE WHITE BIRCH MULTIPLY TOLERANCES

### ➤ THICKNESSES, STRUCTURES, & TOLERANCES

Nominal Thickness mm	Thickness Tolerances	
	min, mm	max, mm
6.5	6.1	6.9
9	8.4	9.4
12	11.3	12.5
15	14.2	15.6
18	17.1	18.7
21	20.0	21.8
24	22.9	24.9
27	25.8	28
30	28.7	31.1
35	33.5	36.2

### ➤ PANEL TOLERANCES

Length/Width, mm	Tolerance, mm
<1000	± 1 mm
1000...2000	± 2 mm
>2000	± 3 mm
Squareness of panel	1 mm/m
Straightness of panel edges	1 mm/m

### ➤ QUALITY CONTROL

Quality control in factory in accordance with Russian GOST  
Norm & EN 326