## **Raw plywood grades**

The quality grade of plywood is defined by type and quantity of visible defects, measured by EN 635-5.

Riga Ply grading conditions are in compliance or stricter in comparison with requirements set by the following regulatory documents:

- EN 635-2 Plywood Classification by Surface Appearance Part 2. Hardwood;
- SFS 2413 quality requirements for appearance of plywood with outer plies of birch;
- ISO 139 Recommendations and Conditions Drawn by Work Group II of the Technical Committee (1994).

Grade	Recommended application	
S	For good quality staining and lacquering. Total number of defects ≤ 6	
BB	For finishing and coating with transparent and non- transparent thicker overlays and films, veneering and applications where a solid face is required. Total number of defects ≤ 9	



Grade	Recommended application	
WG	For use where surface appearance is not important, reverse grade. The total number of defects is unlimited	
WGE	Plywood of WG grade without open defects (repaired with filler), for overlaying with non- transparent finishing material.	

\* Plywood grade photos are made of a compilation of A5 samples





DEFECT	PLYWOOD GRADES				
DEFECT	S	BB	WG		
Closed splits and checks	Closed splits and checks				
America Second S	For an individual max length up to 200 mm and not more than 2 per meter of panel width	For an individual max length up to 200 mm and not more than 2 per meter of panel width			
Coloured streaks					
	<b>Slightly</b>	✓	<		
Coloured streaks, brown, but	not rot				
	$\bigotimes$	Vp to 30% of the surface area			
Composed face veneers					
	V If composed properly, conformable colour				



DEFECT	PLYWOOD GRADES				
DEFECT	S	BB	WG		
Curly grain					
	۲		V		
Defects at the edges caused	by the sanding or	trimming			
max 5 mm	Vp to 5 mm from the edge, not in whole length	Vp to 5 mm from the edge, not in whole length	Vp to 5 mm from the edge		
Glue penetration					
	V If occasionally	Vp to 5% of the surface area			
Imprints and bumps					
	$\bigotimes$	Slightly, up to 2 cm <sup>2</sup> per panel	<b>Slightly</b>		
Inserts					
	If properly inserted and match the plywood colour, not more than 1/m <sup>2</sup>	Up to 3% of the surface area	$\checkmark$		



DEFECT	PLYWOOD GRADES				
DEFECT	S	BB	WG		
Irregularities in the structure	e of the wood				
	$\checkmark$	$\checkmark$	$\checkmark$		
Open joints					
(and a second se	8	Up to an individual max width 2 mm and individual max length 200 mm, not more than 1 per meter of panel width, repaired with putty	Vp to an individual max width 3 mm		
Open splits and checks					
S BB WG O Maxup to 4 mm	$\bigotimes$	8	For an individual max width up to 4 mm, not more than 2 per meter of panel width		
Open splits and checks, repaired by putty					
Imax 2 mm max 200 mm S 88 WG 1 200 mm 1 200 mm per 1 m 1 200 mm 1 200 mm per 1 m 1 200 mm 1 200 mm per 1 m	For an individual max width up to 2 mm and for an individual max length up to 200 mm, not more than 1 per meter of panel width	For an individual max width up to 2 mm and for an individual max length up to 200 mm, not more than 1 per meter of panel width	For an individual max width up to 4 mm, not more than 2 per meter of panel width		



DEFECT	PLYWOOD GRADES		
DEFECT	S	BB	WG
Other knots and holes			
2 5 8 0 0 15 mm 0 15 mm	$\bigotimes$	Up to an individual max Ø 6 mm, if the cumulative Ø does not exceed 25 mm/m <sup>2</sup>	Up to an individual max Ø 15 mm, if the cumulative Ø does not exceed 100 mm/m <sup>2</sup>
Overlap			
	$\bigotimes$	8	$\bigotimes$
Pin knots			
	$\checkmark$	$\checkmark$	$\checkmark$
Roughness			
		Slightly, up to 10 cm <sup>2</sup> /m <sup>2</sup> , if repaired with putty – max 3 defects per panel	



DEFECT	PLYWOOD GRADES		
DEFECT	S	BB	WG
Sanding through			
	8	<b>∨</b> ≤ 10 cm²/m²	<b>⊘</b> ≤ 20 cm²/m²
Sound intergrown knots			
<u>5 8 WG</u> <u>max max max</u> 020 mm 025 mm 065 mm	Up to an individual max Ø 20 mm, if the cumulative Ø does not exceed 50 mm/m <sup>2</sup>	Up to an individual max Ø 25 mm, if the cumulative Ø does not exceed 60 mm/m <sup>2</sup>	Up to an individual max Ø 65 mm, if the cumulative Ø does not exceed 600 mm/m²
Unsanded areas			
	8	۲	Vp to an extent of 5% of the panel surface
Unsound adhering knots			
S BO WS max 20 mm			Up to an individual max Ø 20 mm, if the cumulative Ø does not exceed 200 mm/m <sup>2</sup>



DEFECT	PLYWOOD GRADES		
DEFECT	S	BB	WG
Wood discolouration			
	<b>Slightly</b>	Vp to 30% of the surface area	
Total number of defects			
	≤ 6	≤ 9	Unlimited

\* If the machined panel is smaller than the minimum unit defined in the table (1 m<sup>2</sup>, 1 meter of width), then from the point of view of quality assessment its size shall be equated to 1 m<sup>2</sup> or 1 meter of width.

\* The provided information is for reference only. Wood is a living material, therefore each panel is unique and differences are possible.

\* Please note that the table will be regularly updated. The latest version will always be available on <u>www.finieris.com</u> website.

