










LAMINATED PLYWOOD GRADES

The quality grade of laminated plywood is defined by the type and quantity of visible defects.
The limitations described refer to the following Riga Wood laminated plywood products:

FORM	PATTERNS	COLORED
TEX		TRANSPARENT
Riga Form (dark brown, black)	Riga Heksa Plus	Riga Form (light brown, silver grey, etc.)
Riga Tex (dark brown, black)	Riga Heksa	Riga Mel
	Riga Trans	Riga Preprime
	Riga Dot	Riga Paint
	Riga Foot	
	Riga Diamond	
	Riga Rhomb	
	Riga Pattern+	
	Riga Smooth Mesh	
	Riga Superwire	
	Riga Frost	
	Riga Timber	

GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
1. Plywood delamination			
A			
I			
II	 100 cm²/m²	 100 cm²/m²	 100 cm²/m²












Permitted

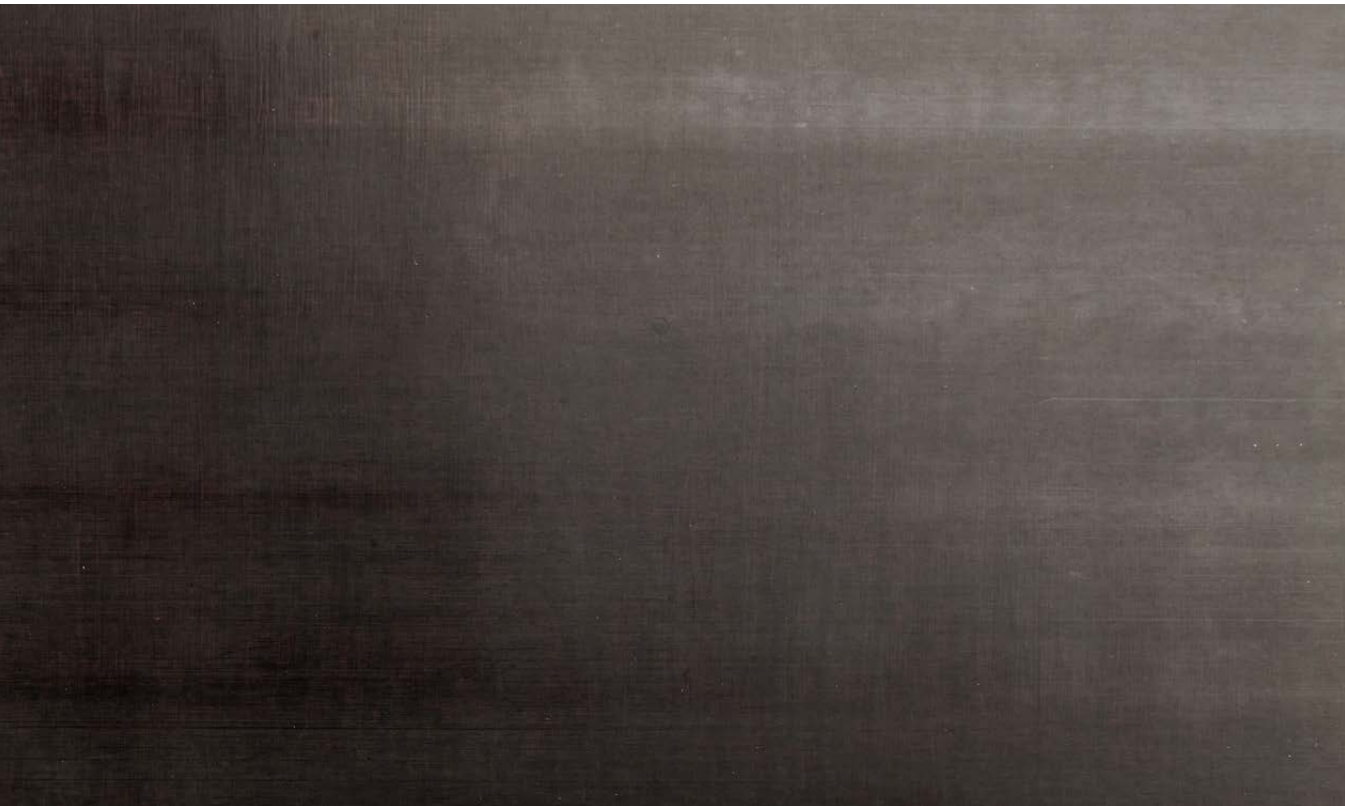


Not permitted



Not applicable

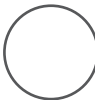
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
2. Matt surface			
A			
I	 > 50% of surface area		
II			



Permitted



Not permitted



Not applicable

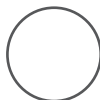
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
3. Scorched laminate as strips and spots			
A	<div></div> <p>If grade A on both faces, permitted on one face: Strips: <5 mm in width, 1 pc/width m; Spots: <Ø20 mm, 1 pc/m² or unlimited, if <Ø10 mm</p>	<div></div> <p>Not permitted on pattern face. Permitted on reverse face: Strips: <5 mm in width, 1 pc/width m; Spots: <Ø20 mm, 1 pc/m² or unlimited, if <Ø10 mm</p>	<div></div> <p>If grade A on both faces, permitted on one face: Strips: <5 mm in width, 1 pc/width m; Spots: <Ø20 mm, 1 pc/m² or unlimited, if <Ø10 mm</p>
I	<div></div> <p>Strips: <10 mm in width, 1 pc/width m; Spots: <Ø30 mm, 1 pc/m² or unlimited, if <Ø10 mm</p>	<div></div> <p>Strips: <10 mm in width, 1 pc/width m; Spots: <Ø30 mm, 1 pc/m² or unlimited, if <Ø10 mm</p>	<div></div> <p>Strips: <10 mm in width, 1 pc/width m; Spots: <Ø30 mm, 1 pc/m² or unlimited, if <Ø10 mm</p>
II	<div></div>	<div></div>	<div></div>












Permitted

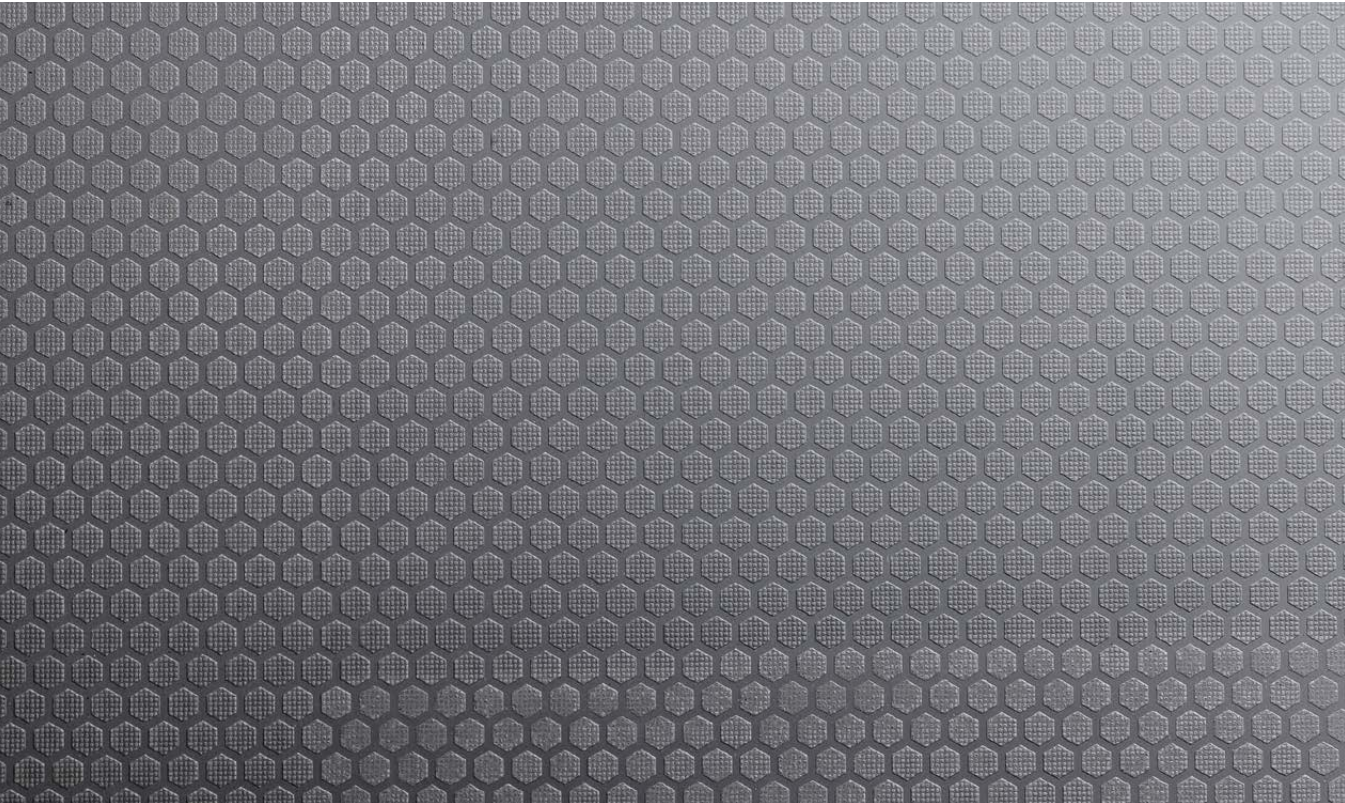


Not permitted



Not applicable

GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
4. Damaged pattern, uneven pattern			
A			
I	 Strips: <10 mm in width, 1 pc/width m; Spots: <Ø30 mm, 1 pc/m² or unlimited, if <Ø10 mm	 Strips: <5 mm in width, 1 pc/width m; Spots: <Ø20 mm, 1 pc/m² or unlimited, if <Ø10 mm	
II			












Permitted

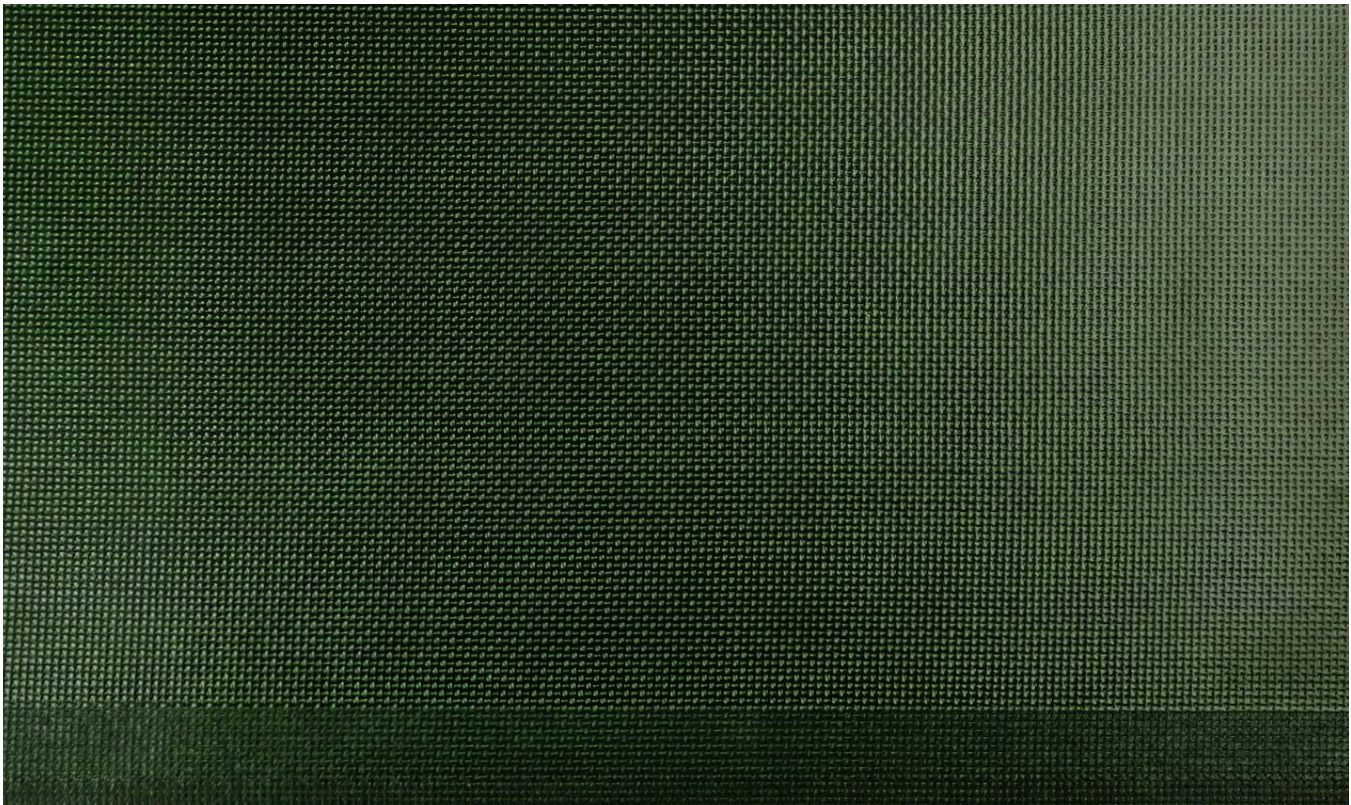


Not permitted



Not applicable

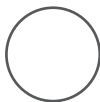
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
5. Displacement of wire mesh or pattern			
A			
I			
II			












Permitted



Not permitted



Not applicable

GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
6. Film overlaps as dark strips			
A	<div></div> <div>If grade A on both faces, permitted on one face firmly glued <10 mm in width.</div>	<div></div> <div>Not permitted on pattern face. Permitted on reverse face firmly glued <10 mm in width.</div>	<div></div> <div>If grade A on both faces, permitted on one face firmly glued <10 mm in width.</div>
I	<div></div> <div>Permitted without limitations firmly glued <20 mm in width.</div>	<div></div> <div>Not permitted on pattern face. Permitted on reverse face firmly glued <20 mm in width.</div>	<div></div> <div>If grade I on both faces, permitted on one face firmly glued <20 mm in width.</div>
II	<div></div>	<div></div>	<div></div>












Permitted

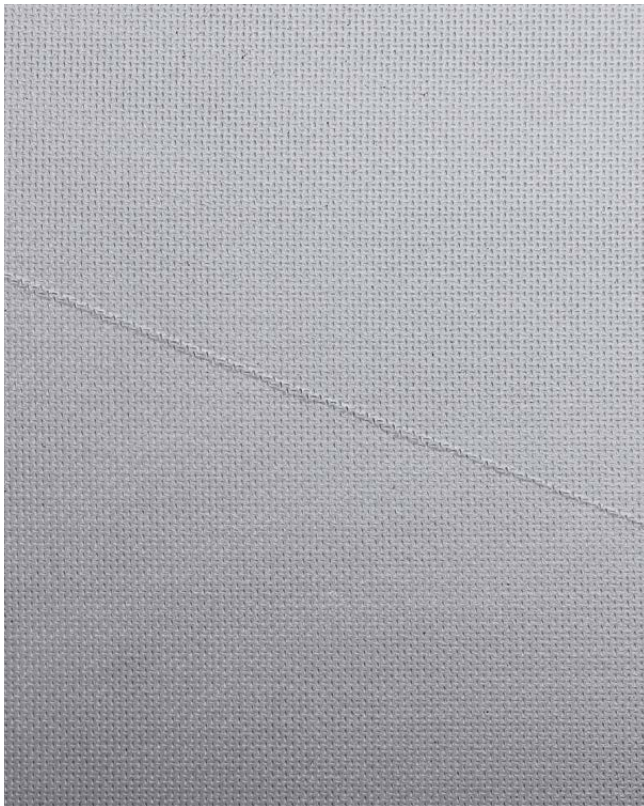


Not permitted



Not applicable

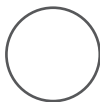
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
7. Film folds			
A			
I	 <10% of surface area		
II			












Permitted



Not permitted



Not applicable

GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
8. Lack of film or film delamination after laminating			
A			
I			
II	 On a 1/3 of the sheet on one face	 On a 1/3 of the sheet on one face	 On a 1/3 of the sheet on one face












Permitted



Not permitted



Not applicable

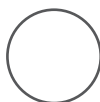
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
9. Glued laminate residues on the surface			
A	<div></div> <p>If grade A on both faces, permitted on one face: <3 pcs, if residues are (<1 cm²) in the same color as surface</p>	<div></div> <p>Not permitted on pattern face. Permitted on reverse face: <3 pcs, if residues are (<1 cm²) in the same color as surface</p>	<div></div> <p>If grade A on both faces, permitted on one face: <3 pcs, if residues are (<1 cm²) in the same color as surface.</p>
I	<div></div> <p><10 cm²/m² if residues are in the same color as surface</p>	<div></div> <p><10 cm²/m² if residues are in the same color as surface</p>	<div></div> <p><10 cm²/m² if residues are in the same color as surface</p>
II	<div></div>	<div></div>	<div></div>












Permitted



Not permitted



Not applicable

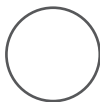
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
10. Other color dust pressed on the surface			
A	<div><p>If grade A on both faces, permitted on one face: <5% of surface area.</p></div>	<div><p>Not permitted on pattern face. Permitted on reverse face: <5% of surface area.</p></div>	<div><p>If grade A on both sides, then permitted on one side: <5% of surface area.</p></div>
I	<div><p><10% of surface area</p></div>	<div><p><10% of surface area</p></div>	<div><p><10% of surface area</p></div>
II	<div></div>	<div></div>	<div></div>












Permitted



Not permitted



Not applicable

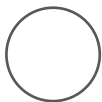
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
11. Imprints, if film is not damaged			
A	<div></div> <div>If grade A on both faces, permitted on one face: $<1\text{ cm}^2/\text{m}^2$, if the width of an imprint $<3\text{ mm}$ and the sum of the length $<30\text{ mm}/\text{m}^2$.</div>	<div></div> <div>Not permitted on pattern face. Permitted on reverse face: $<1\text{ cm}^2/\text{m}^2$ if the width of an imprint $<3\text{ mm}$ and the sum of the length $<30\text{ mm}/\text{m}^2$.</div>	<div></div> <div>If grade A on both faces, permitted on one face: $<1\text{ cm}^2/\text{m}^2$, if the width of an imprint $<3\text{ mm}$ and the sum of the length $<30\text{ mm}/\text{m}^2$.</div>
I	<div></div> <div>$<2,5\text{ cm}^2/\text{m}^2$, if the width of an imprint $<5\text{ mm}$ and the sum of the length $<50\text{ mm}/\text{m}^2$</div>	<div></div> <div>$<2,5\text{ cm}^2/\text{m}^2$, if the width of an imprint $<5\text{ mm}$ and the sum of the length $<50\text{ mm}/\text{m}^2$</div>	<div></div> <div>$<2,5\text{ cm}^2/\text{m}^2$, if the width of an imprint $<5\text{ mm}$ and the sum of the length $<50\text{ mm}/\text{m}^2$</div>
II	<div></div>	<div></div>	<div></div>












Permitted

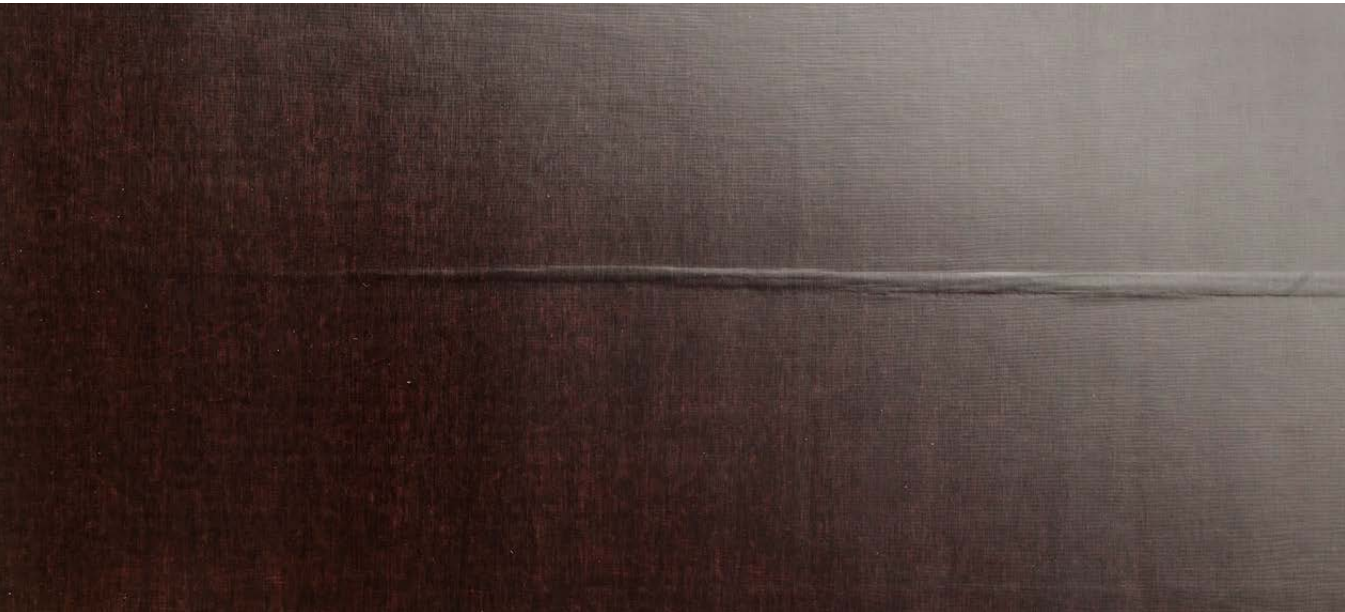


Not permitted



Not applicable

GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
12. Ridges, bumps			
A	<div></div> <p>If grade A on both faces, permitted on one face. Spots: <Ø15 mm, 1 pc/m² or unlimited, if <Ø5 mm</p>	<div></div> <p>Not permitted on pattern face. Permitted on reverse face. Spots: <Ø10 mm, 1 pc/m² or unlimited, if <Ø5 mm</p>	<div></div> <p>If grade A on both faces, permitted on one face. Spots: <Ø10 mm, 1 pc/m² or unlimited, if <Ø5 mm</p>
I	<div></div> <p>Strips: <10 mm in width, <300 mm in length and 1 pc/width m; <5 mm in width, unlimited length, <1 pc/width m. Spots: <Ø20 mm, 1 pc/m² or unlimited, if <Ø10 mm</p>	<div></div> <p>Strips: <5 mm in width, <300 mm in length and 1 pc/width m; <3 mm in width, unlimited length, <1 pc/width m. Spots: <Ø15 mm, 1 pc/m² or unlimited, if <Ø5 mm</p>	<div></div> <p>Strips: <3 mm in width, <200 mm in length and 1 pc/width m. Spots: <Ø15 mm, 1 pc/m² or unlimited, if <Ø5 mm</p>
II	<div></div>	<div></div>	<div></div>












Permitted

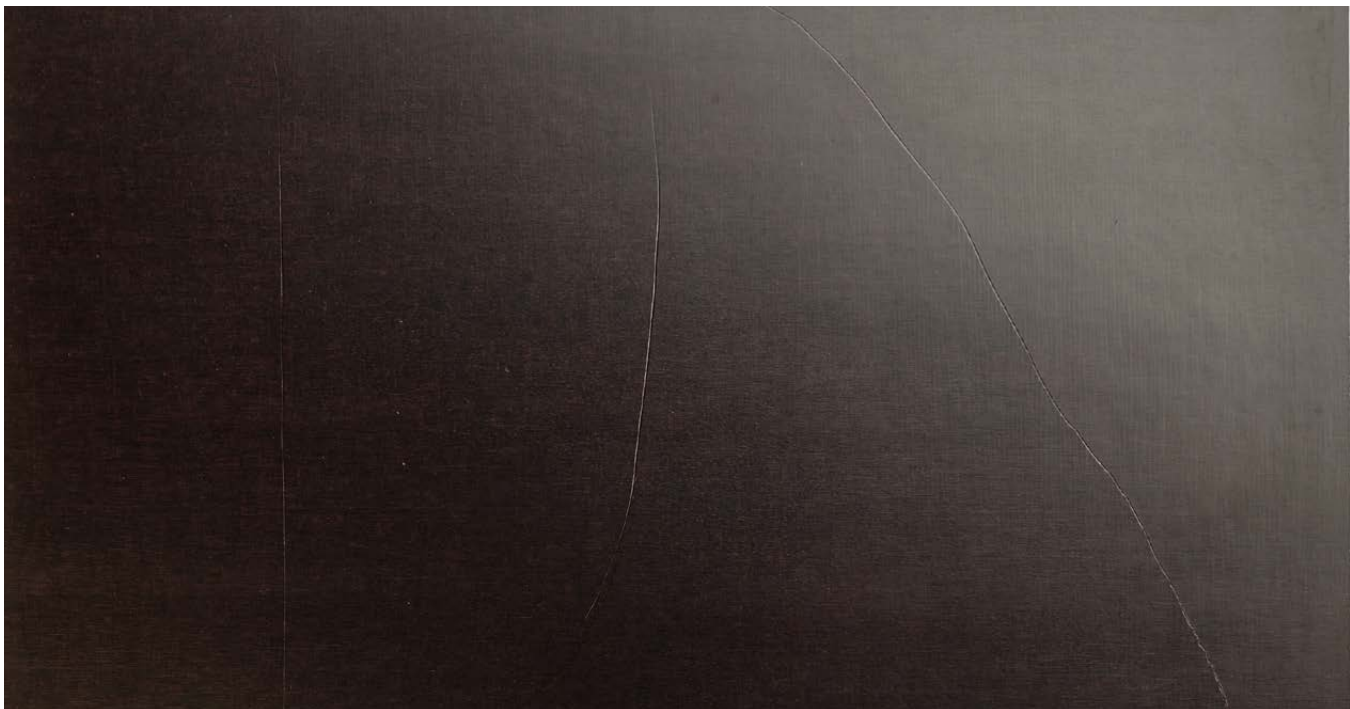











Not permitted



Not applicable

GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
13. Scratches			
A	<div></div> <div>If grade A on both faces, permitted minor scratches on one face (<2 pcs), if the laminate is not scratched through.</div>	<div></div> <div>Not permitted on pattern face. Permitted minor scratches on reverse face (<2 pcs), if the laminate is not scratched through</div>	<div></div> <div>If grade A on both faces, permitted minor scratches on one face (<2 pcs), if the laminate is not scratched through.</div>
I	<div></div> <div>Permitted, if the laminate is not scratched through</div>	<div></div> <div>Permitted, if the laminate is not scratched through</div>	<div></div> <div>Permitted, if the laminate is not scratched through</div>
II	<div></div>	<div></div>	<div></div>



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
14. Diffuse strips on surface (variations in color tone or gloss)			
A	<div></div> <div>If grade A on both faces, permitted minor on one face.</div>	<div></div> <div>Not permitted on pattern face. Permitted minor on reverse face</div>	<div></div> <div>If grade A on both faces, permitted minor on one face.</div>
I	<div></div> <div>Permitted minor</div>	<div></div> <div>Permitted minor</div>	<div></div> <div>Permitted minor</div>
II	<div></div>	<div></div>	<div></div>












Permitted



Not permitted



Not applicable

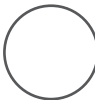
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
15. Lack of veneer on edges			
A			
I	 Permitted in one layer of veneer with a depth <3 mm. Edges shall be firm if standard size	 Permitted in one layer of veneer with a depth <3 mm. Edges shall be firm if standard size	 Permitted in one layer of veneer with a depth <3 mm. Edges shall be firm if standard size
II	 Edges shall be firm	 Edges shall be firm	 Edges shall be firm












Permitted



Not permitted



Not applicable

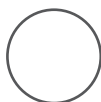
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
16. Edge sealing paint on laminated surface			
A	<div></div> <p>Permitted ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even</p>	<div></div> <p>Permitted ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even</p>	<div></div> <p>Permitted ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even</p>
I	<div></div> <p>Permitted ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even</p>	<div></div> <p>Permitted ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even</p>	<div></div> <p>Permitted ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even</p>
II	<div></div>	<div></div>	<div></div>












Permitted

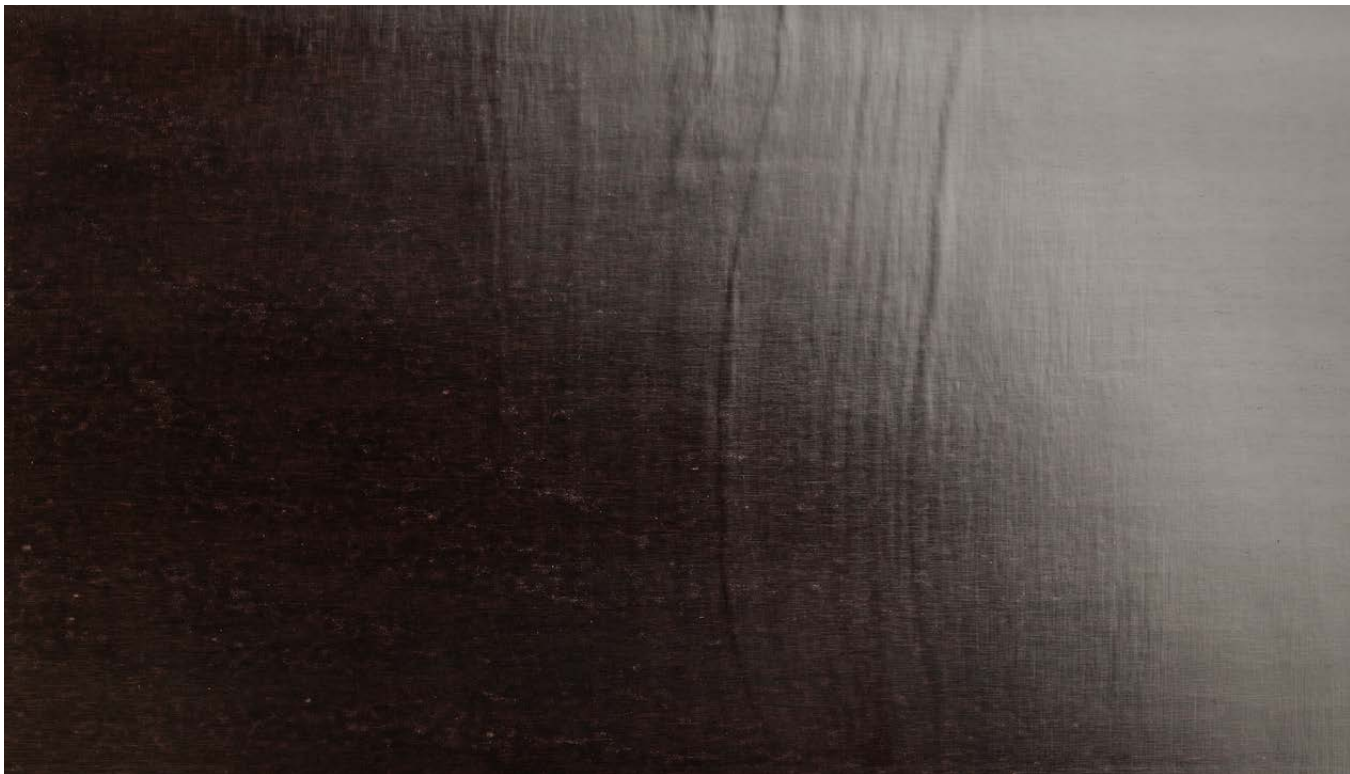


Not permitted



Not applicable

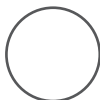
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
17. Minor rough spots			
A	<div></div> <div>If grade A on both faces, permitted on one face: $<25\text{ cm}^2$ over the surface, with separate spots $<5\text{ cm}^2$.</div>	<div></div> <div>Not permitted on pattern face. Permitted on reverse face: $<25\text{ cm}^2$ over the surface, with separate spots $<5\text{ cm}^2$.</div>	<div></div> <div>If grade A on both faces, permitted on one face: $<25\text{ cm}^2$ over the surface, with separate spots $<5\text{ cm}^2$.</div>
I	<div></div> <div>$<125\text{ cm}^2$ over the surface</div>	<div></div> <div>$<125\text{ cm}^2$ over the surface</div>	<div></div> <div>$<125\text{ cm}^2$ over the surface</div>
II	<div></div>	<div></div>	<div></div>












Permitted



Not permitted



Not applicable

GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
18. Mechanical defects			
A			
I			
II			












Permitted

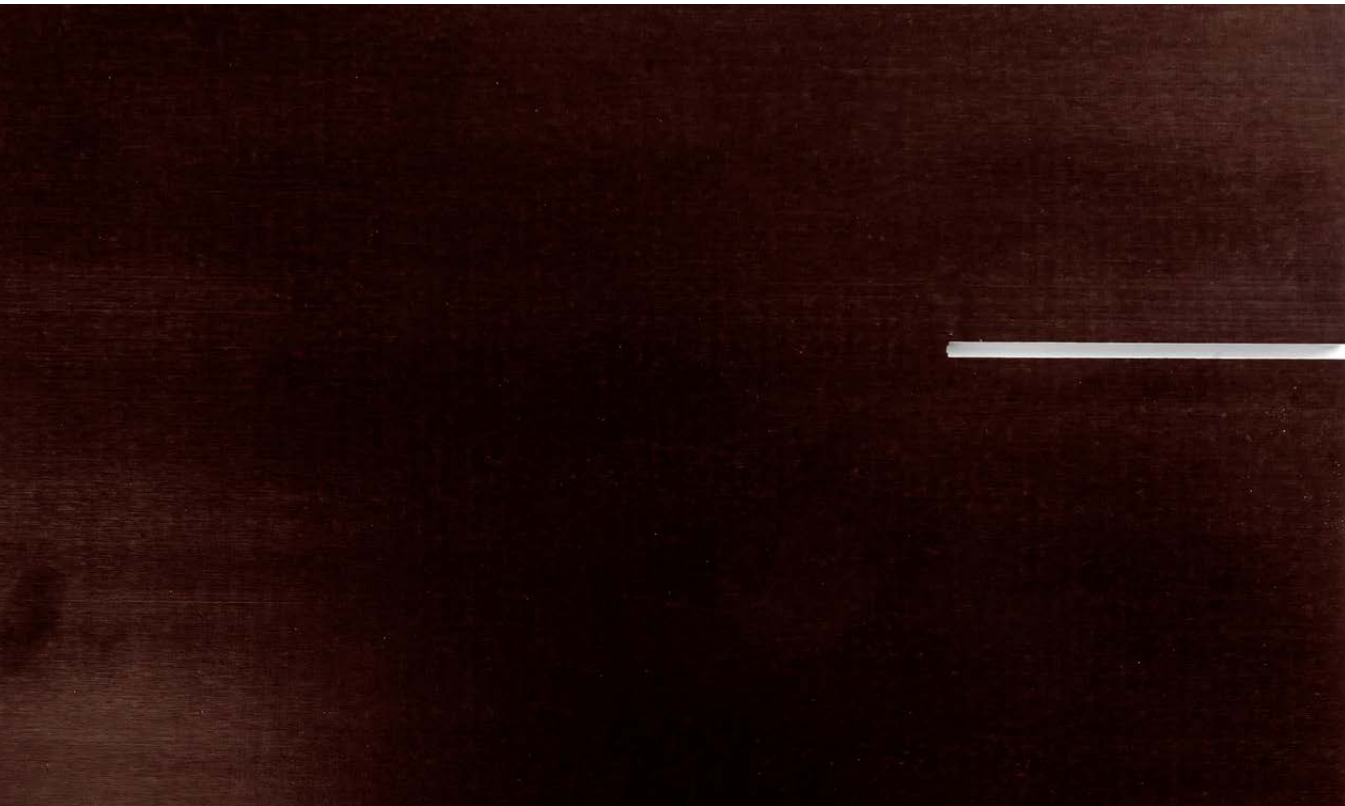


Not permitted



Not applicable

GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
19. Notches			
A			
I			
II	 One with a length <10 cm	 One with a length <10 cm	 One with a length <10 cm



Permitted



Not permitted



Not applicable

GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
Total number of defects			
A	There shall be no defects on one face. Reverse face <2 categories of defects	There shall be no defects on one face. Reverse face <2 categories of defects	There shall be no defects on one face. Reverse face <2 categories of defects
I	One face <2 categories of defects. Reverse face <5 categories of defects	One face <2 categories of defects. Reverse face <5 categories of defects	One face <2 categories of defects. Reverse face <5 categories of defects
II	Unlimited	Unlimited	Unlimited

* If the machined panel is smaller than the minimum unit defined in the table (1 m², 1 meter of width), then from the point of view of quality assessment its size shall be equated to 1 m² 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 www.finieris.com website.



Permitted



Not permitted



Not applicable