




## UNCOATED PLYWOOD GRADES




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

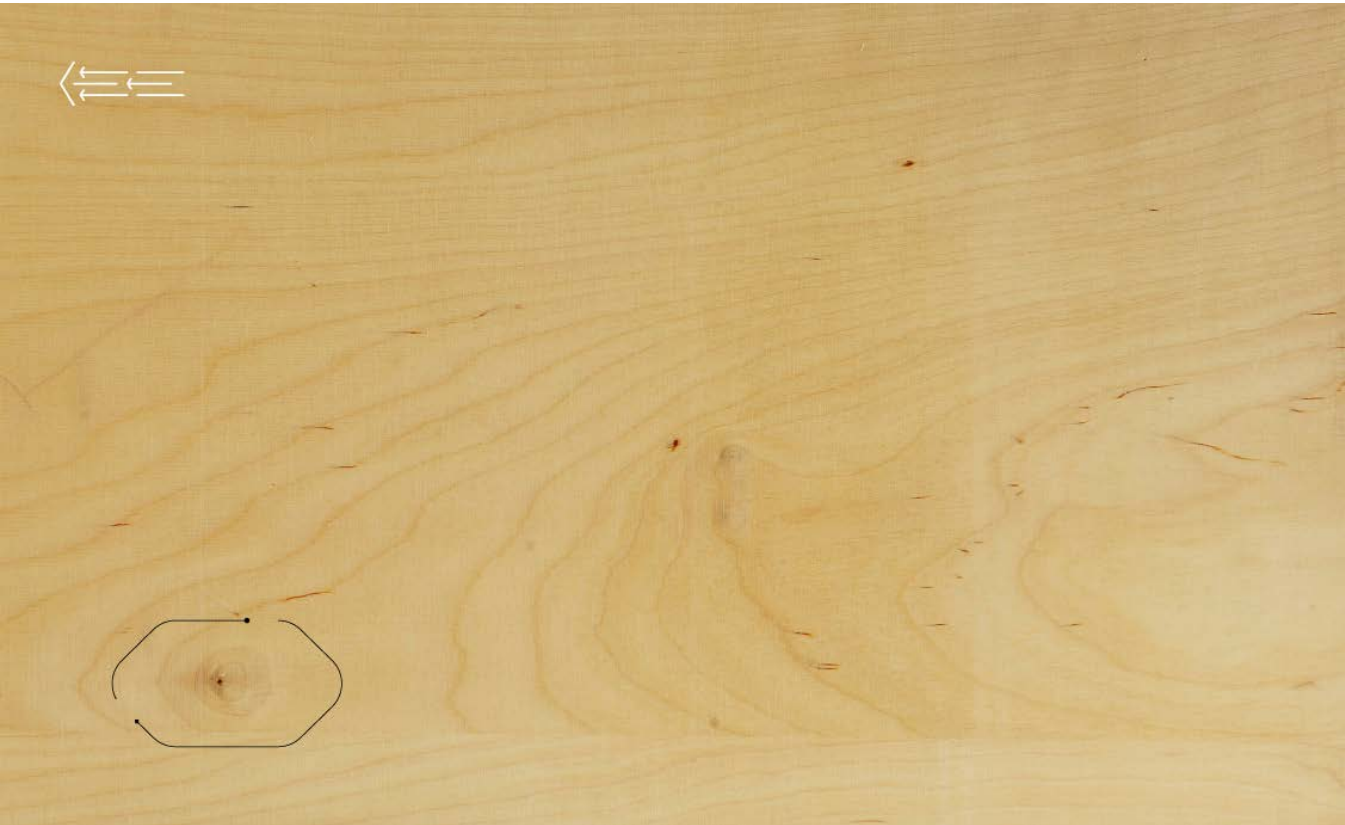
- EN 635-2 Plywood – Classification by Surface Appearance – Part 2. Hardwood;
- SFS 2413 quality requirements for appearance of plywood with outer plies of birch;
- ISO 139 Recommendations and Conditions Drawn by Work Group II of the Technical Committee (1994);
- The quality grade of plywood, evaluated based on its surface veneer, is defined by the type and quantity of visible defects.

**Recommended applications of Riga Ply, depending on grade.**

Grade	Recommended application	
S (II)	For good quality staining and lacquering	
		
BB (III)	For interior finishing and coating with transparent and non-transparent thicker overlays and films, veneering and applications where a solid face is required.	
		
WG (IV)	For use where surface appearance is not important, reverse grade.	
		

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

GRADE		
S	BB	WG
1. Pin knots		
		





Permitted

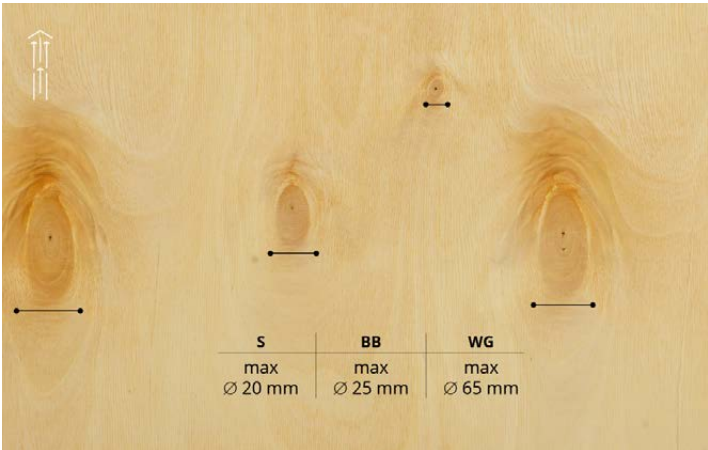
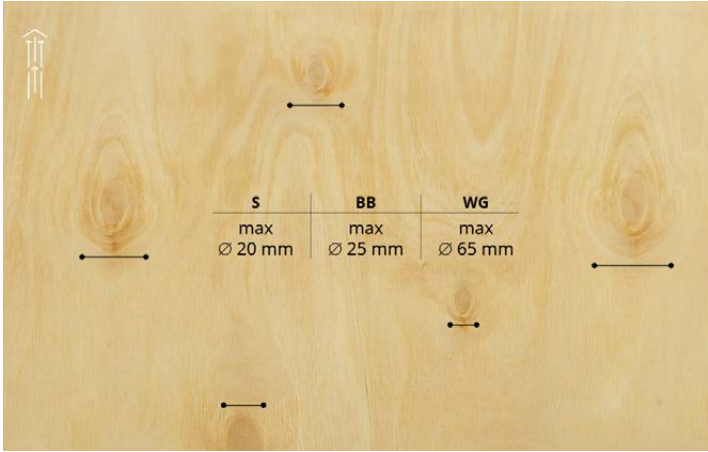
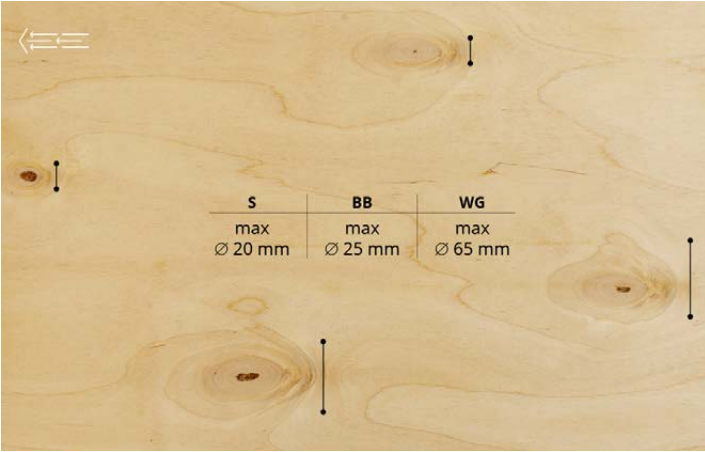


Not permitted



Not applicable

GRADE		
S	BB	WG
2. Sound intergrown knots		
<div></div> <p>Permitted up to an individual max Ø20 mm, if the cumulative Ø does not exceed 50 mm/m²</p>	<div></div> <p>Permitted up to an individual max Ø25 mm, if the cumulative Ø does not exceed 60 mm/m²</p>	<div></div> <p>Permitted up to an individual max Ø65 mm, if the cumulative Ø does not exceed 600 mm/m²</p>






Permitted

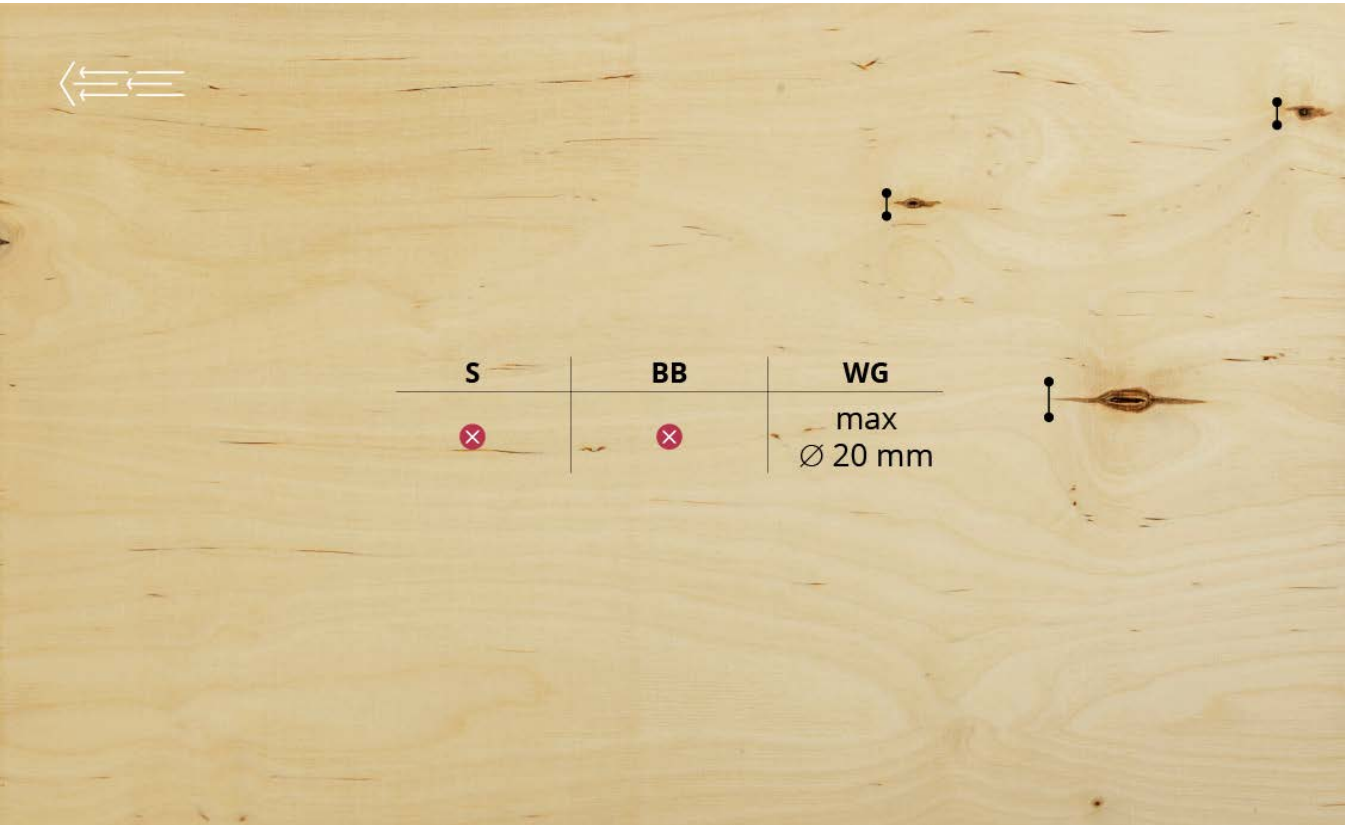


Not permitted



Not applicable

GRADE		
S	BB	WG
3. Unsound adhering knots		
		<div><p>Permitted up to an individual max Ø20 mm, if the cumulative Ø does not exceed 200 mm/m²</p></div>






Permitted



Not permitted






Not applicable

GRADE		
S	BB	WG
4. Other knots and holes		
	<div><p>Permitted up to an individual max Ø 6 mm, if the cumulative Ø does not exceed 25 mm/m²</p></div>	<div><p>Permitted up to an individual max Ø 15 mm, if the cumulative Ø does not exceed 100 mm/m²</p></div>





GRADE		
S	BB	WG
5. Irregularities in the structure of the wood		
		






Permitted



Not permitted



Not applicable

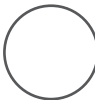
GRADE		
S	BB	WG
6. Curly grain		
		






Permitted

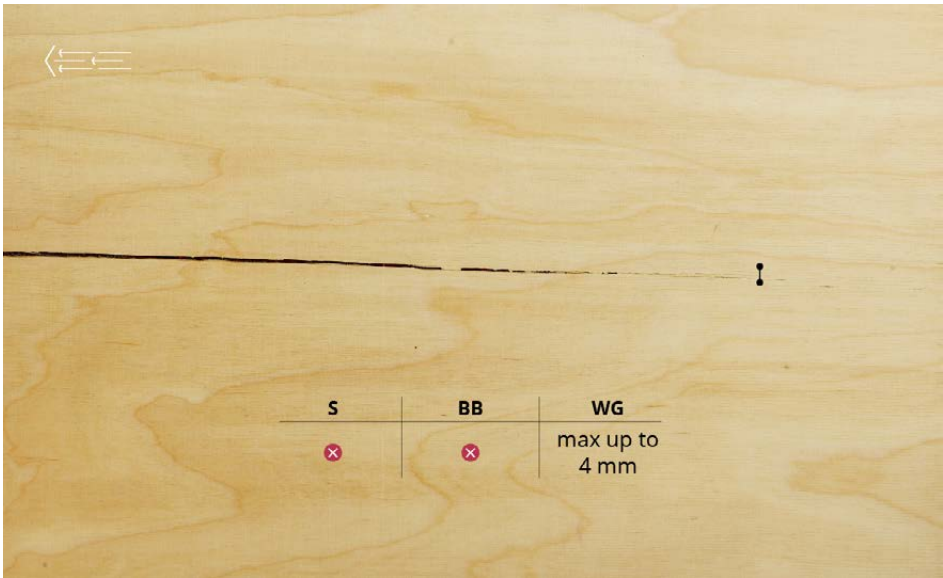
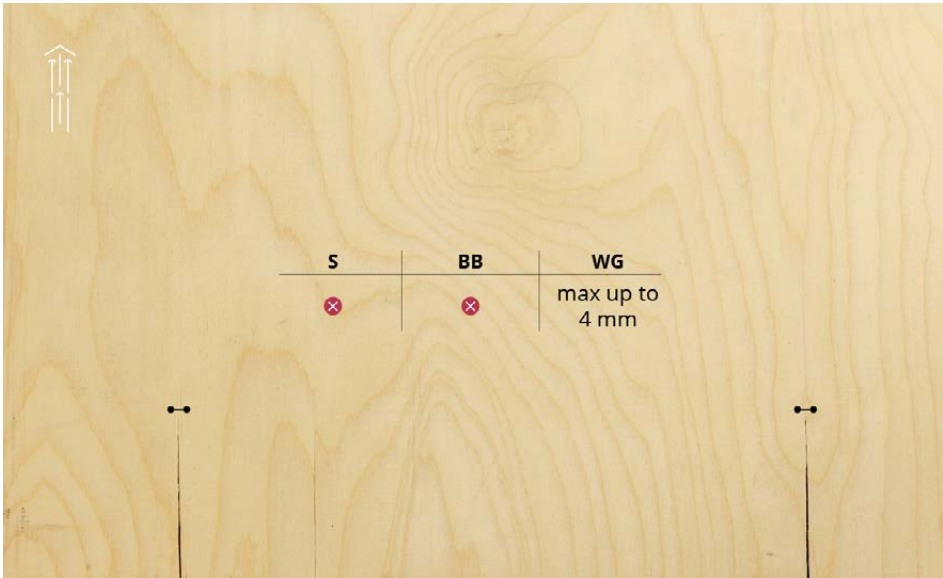


Not permitted



Not applicable

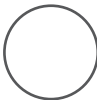
GRADE		
S	BB	WG
7. Open splits and checks		
		<div><p>Permitted for an individual max width up to 4 mm, not more than 2 per meter of panel width</p></div>



Permitted






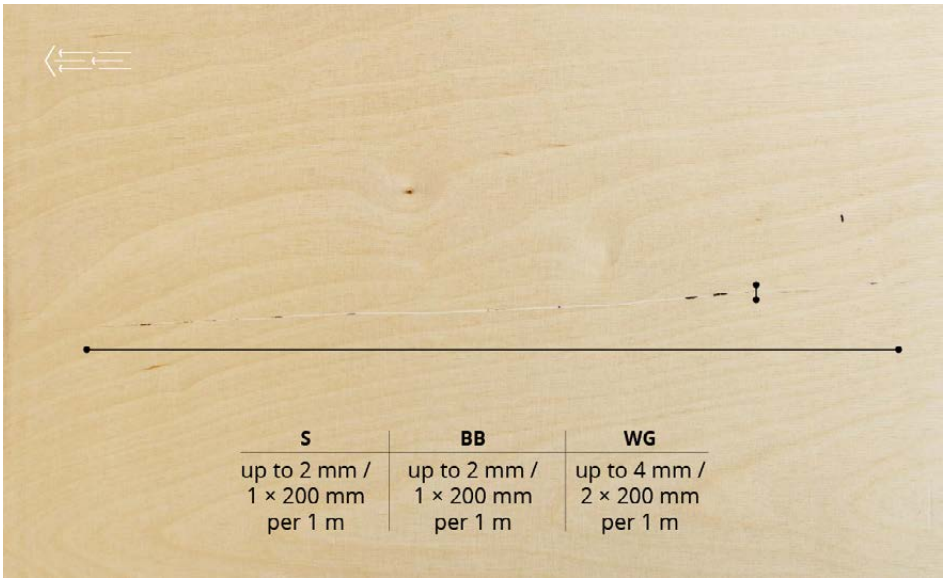
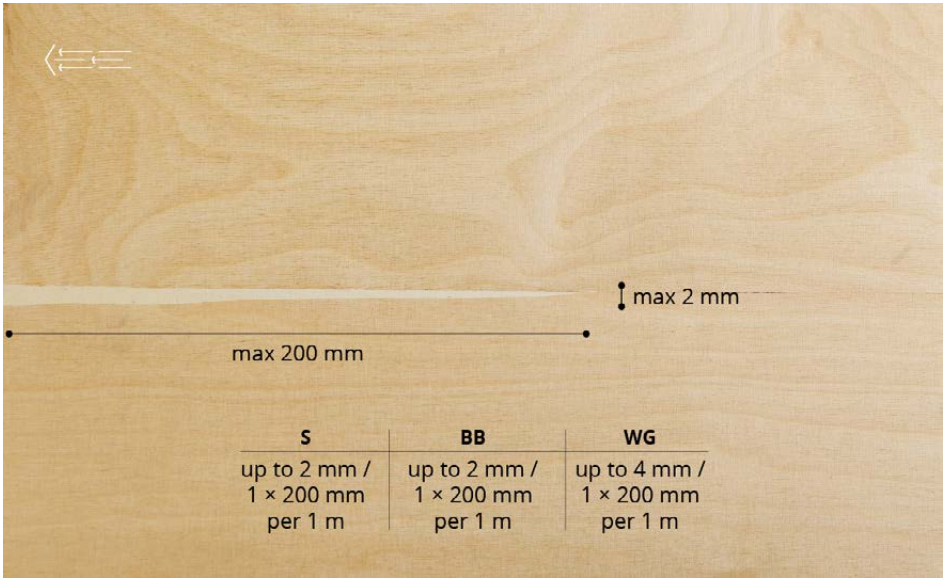
Not permitted



Not applicable



GRADE		
S	BB	WG
8. Open splits and checks, repaired by putty		
<div></div> <div>Permitted 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</div>	<div></div> <div>Permitted 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</div>	<div></div> <div>Permitted for an individual max width up to 4 mm, not more than 2 per meter of panel width</div>






Permitted






Not permitted



Not applicable

GRADE		
S	BB	WG
9. Closed splits and checks		
<div></div> <div>Permitted for an individual max length up to 200 mm and not more than 2 per meter of panel width</div>	<div></div> <div>Permitted for an individual max length up to 200 mm and not more than 2 per meter of panel width</div>	<div></div>



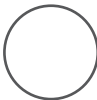
GRADE		
S	BB	WG
10. Wood discolouration		
<div></div> <div>Permitted slightly</div>	<div></div>	<div></div>






Permitted

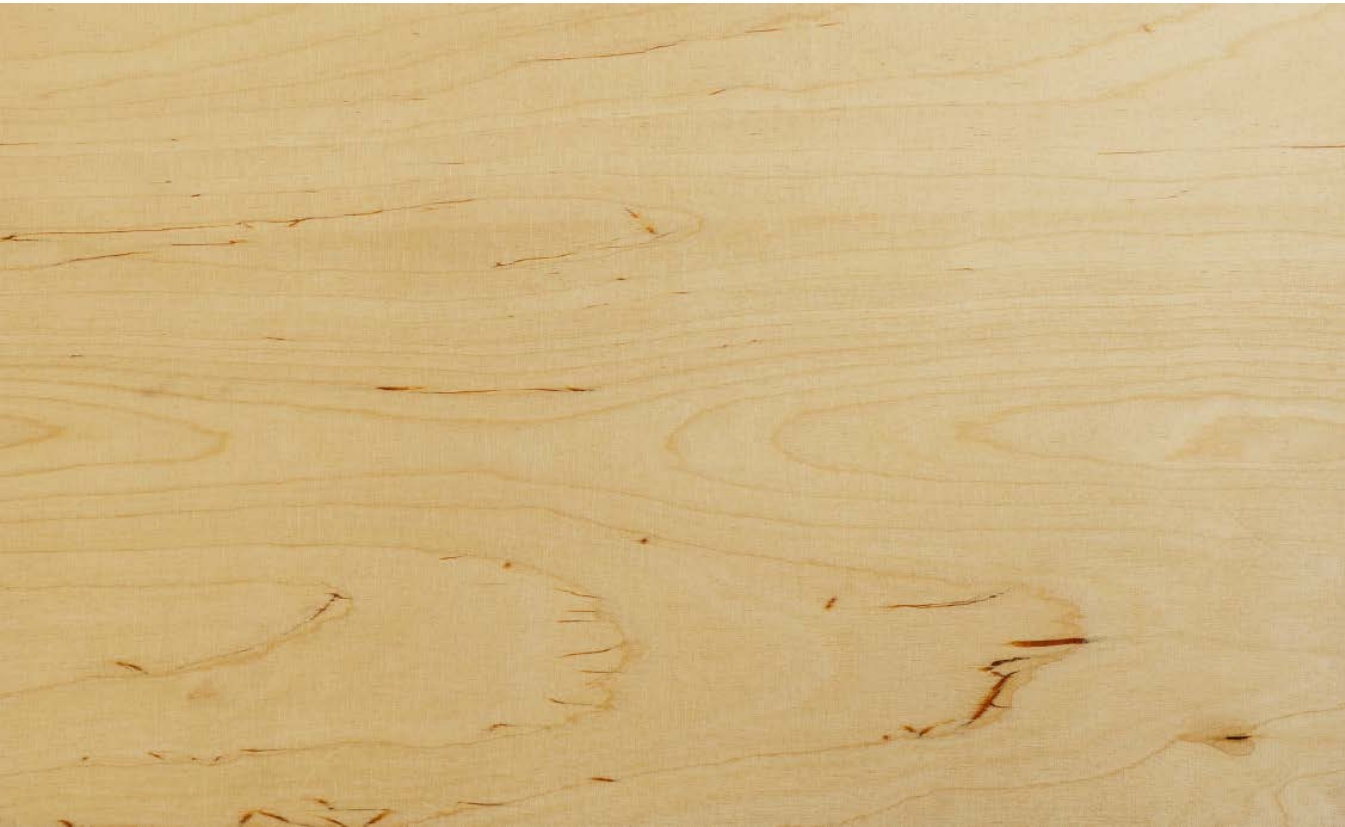


Not permitted



Not applicable

GRADE		
S	BB	WG
11. Coloured streaks		
<div></div> <div>Permitted slightly</div>	<div></div>	<div></div>



Permitted






Not permitted



Not applicable



GRADE		
S	BB	WG
12. Other discoloration, coloured streaks. Brown, but not rot.		
	 Permitted up to 30% of the surface area	



Permitted





Not permitted



Not applicable



GRADE		
S	BB	WG
13. Inserts		
<div></div> <div>Permitted, if properly inserted and match the plywood colour, not more than 1/m<sup>2</sup></div>	<div></div> <div>Permitted up to 10 pieces per square meter</div>	<div></div>






Permitted



Not permitted



Not applicable

GRADE		
S	BB	WG
14. Open joints		
	 Permitted 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	 Permitted up to an individual max width 3 mm






Permitted



Not permitted



Not applicable

GRADE		
S	BB	WG
15. Overlap		
		






Permitted



Not permitted



Not applicable

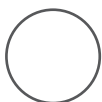
GRADE		
S	BB	WG
16. Imprints and bumps		
	<div><p>Permitted slightly, up to 2 cm² per panel</p></div>	<div><p>Permitted slightly</p></div>



Permitted






Not permitted



Not applicable



GRADE		
S	BB	WG
17. Roughness		
	<div><p>Permitted slightly, up to 10 cm²/m², if repaired with putty – max 3 defects per panel</p></div>	



Permitted






Not permitted



Not applicable



GRADE		
S	BB	WG
18. Sanding through		
	 Permitted $\leq 10\text{ cm}^2/\text{m}^2$	 Permitted $\leq 20\text{ cm}^2/\text{m}^2$






Permitted

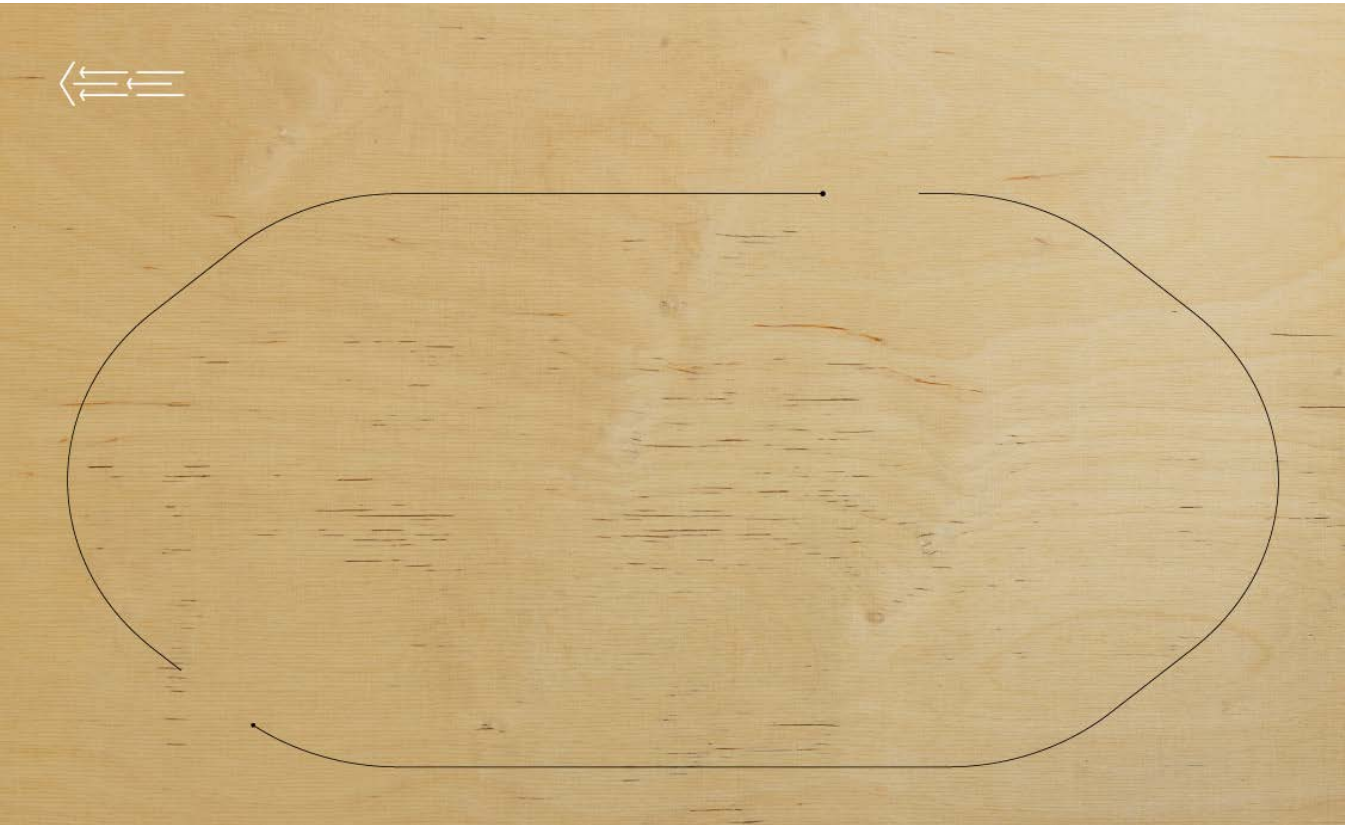


Not permitted



Not applicable

GRADE		
S	BB	WG
19. Glue penetration		
<div></div> <div>Permitted, if occasionally</div>	<div></div> <div>Permitted up to 5% of the surface area</div>	<div></div>






Permitted

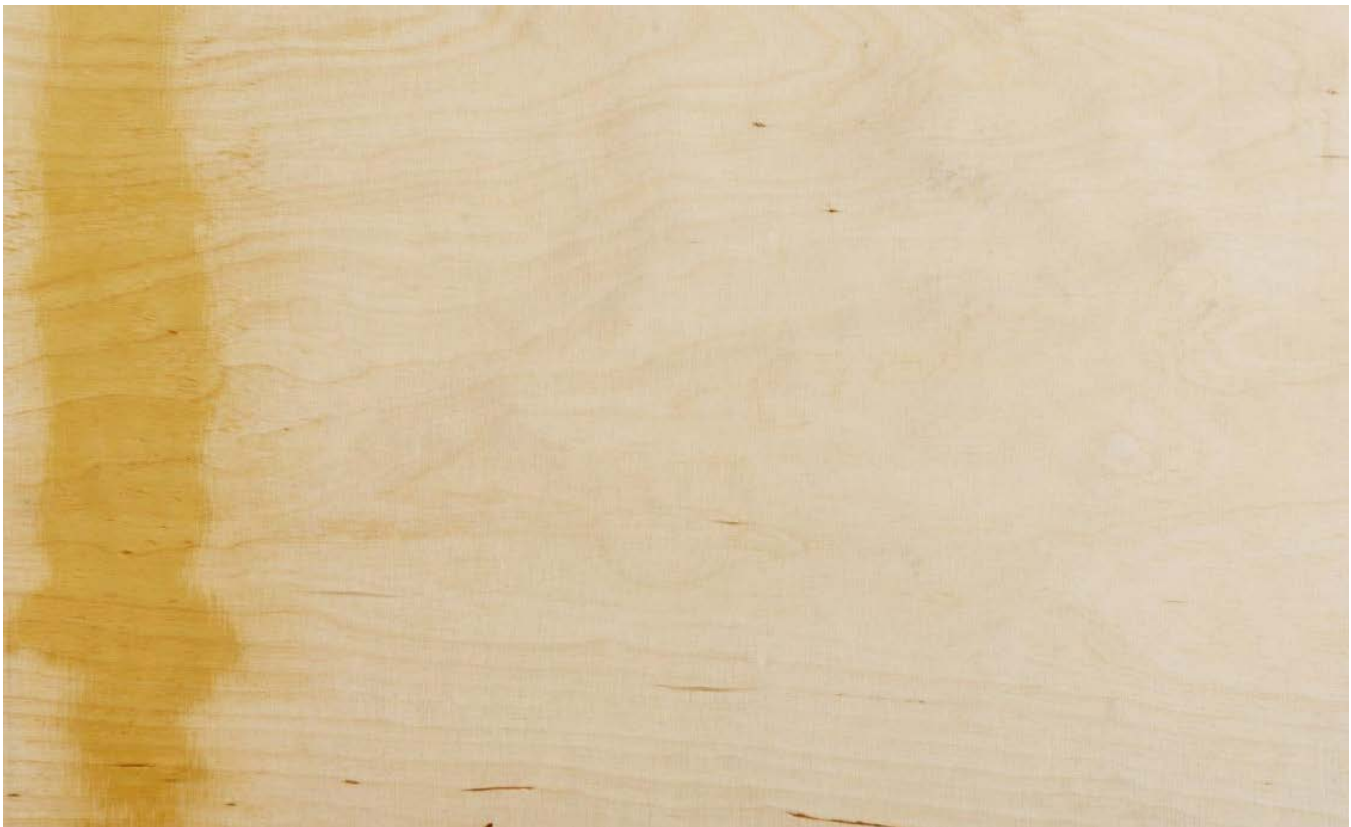


Not permitted



Not applicable

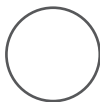
GRADE		
S	BB	WG
20. Unsanded areas		
		<div><p>Permitted up to an extent of 5% of the panel surface</p></div>






Permitted



Not permitted



Not applicable

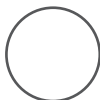
GRADE		
S	BB	WG
21. Composed face veneers		
<div></div> <div>Permitted, if composed properly, conformable colour</div>	<div></div>	<div></div>






Permitted



Not permitted



Not applicable

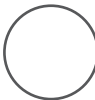
GRADE		
S	BB	WG
22. Defects at the edges caused by the sanding or trimming		
<div></div> <div>Permitted up to 5 mm from the edge, not in whole length</div>	<div></div> <div>Permitted up to 5 mm from the edge, not in whole length</div>	<div></div> <div>Permitted up to 5 mm from the edge</div>



Permitted



Not permitted



Not applicable



GRADE		
S	BB	WG
Total number of permitted categories of defects per panel		
≤6	≤9	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](http://www.finieris.com) website.



Permitted



Not permitted



Not applicable