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).

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		
✓	✓	✓

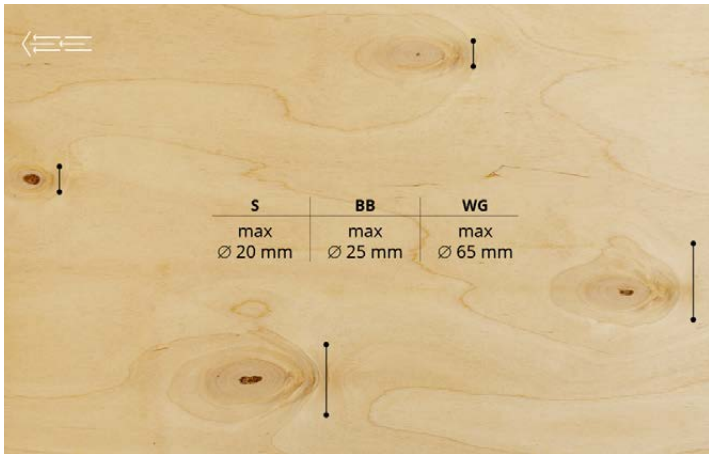
✓ Permitted

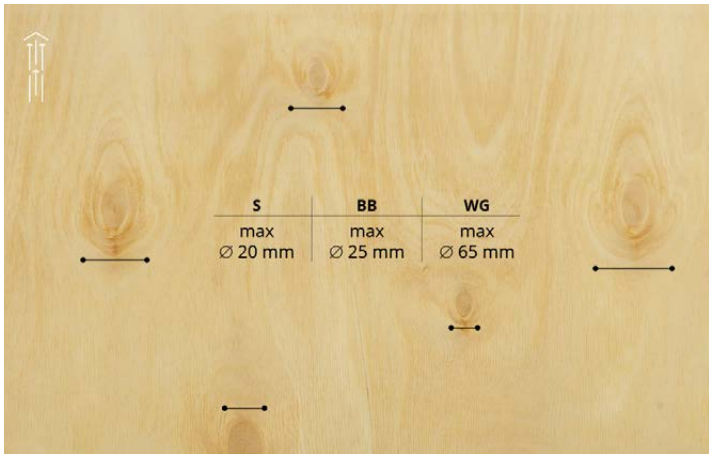
✗ Not permitted

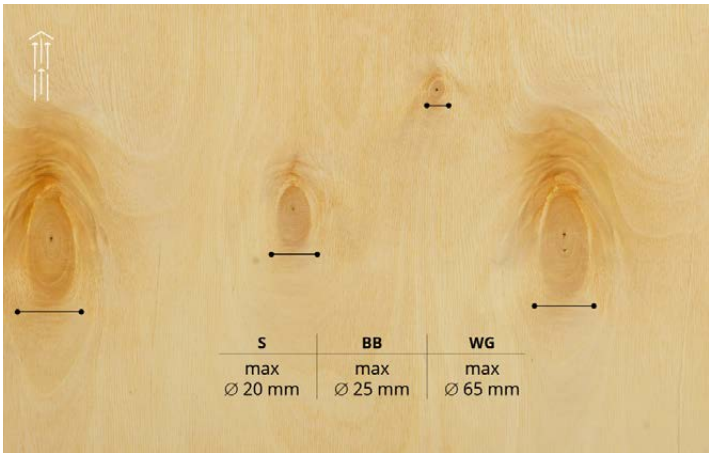
○ Not applicable

RigaWood

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







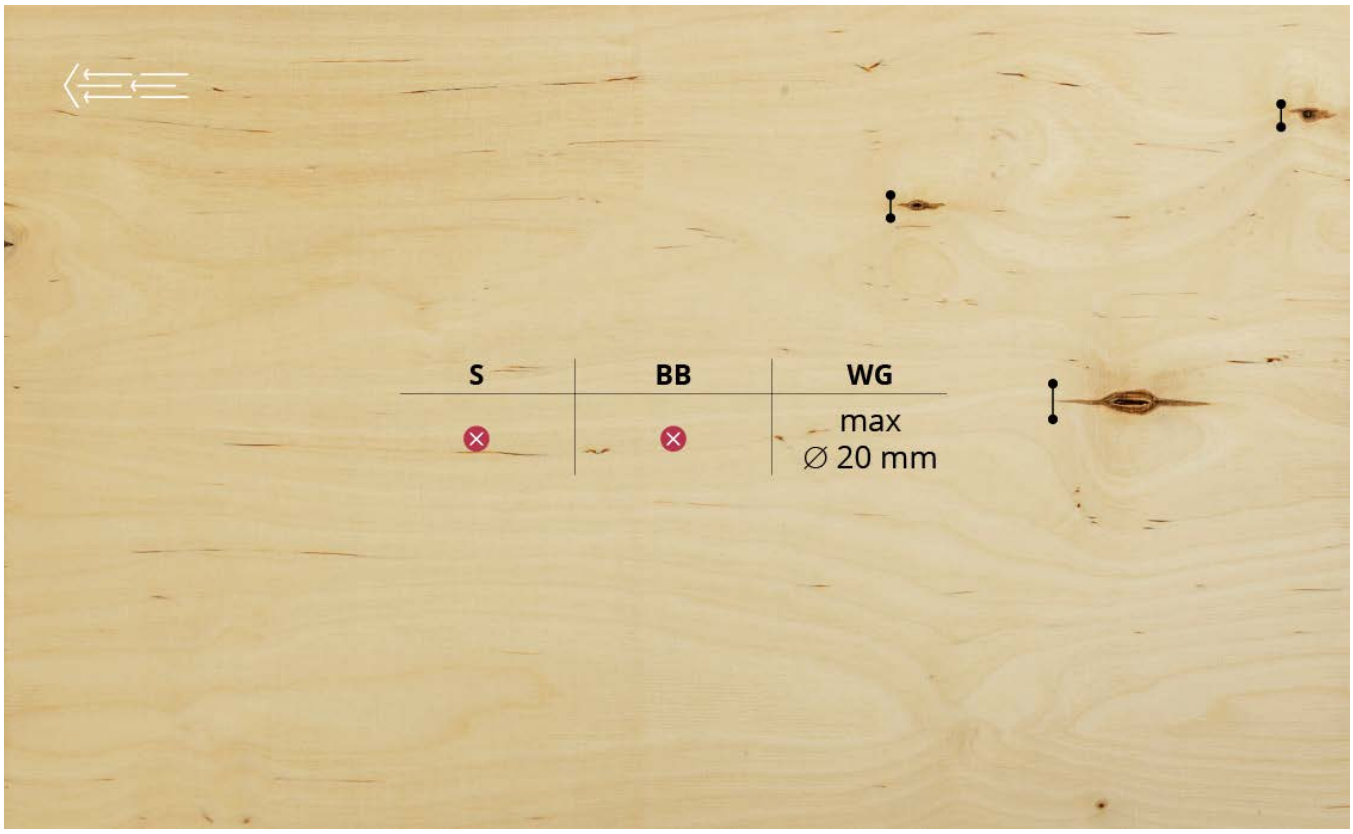
Permitted

Not permitted

Not applicable

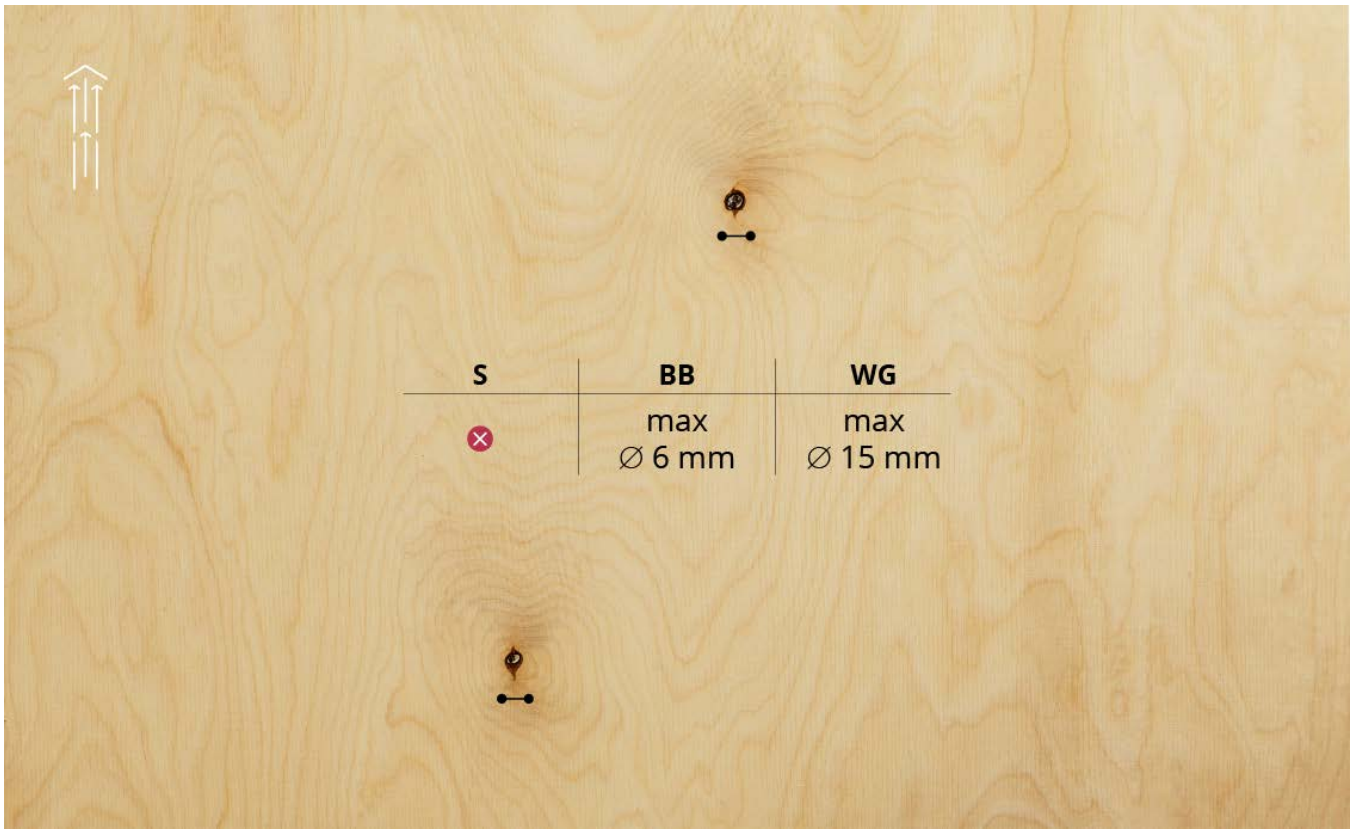
RigaWood

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



✓ Permitted ✗ Not permitted ○ Not applicable

GRADE		
S	BB	WG
4. Other knots and holes		
✗	✓ Permitted up to an individual max Ø6 mm, if the cumulative Ø does not exceed 25 mm/m²	✓ Permitted up to an individual max Ø15 mm, if the cumulative Ø does not exceed 100 mm/m²



✓ Permitted ✗ Not permitted ○ Not applicable

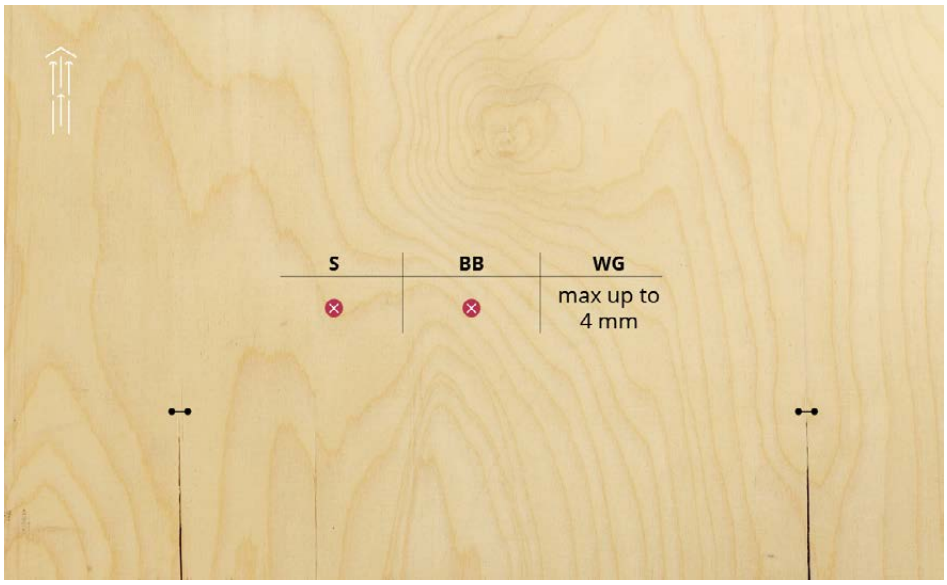
GRADE		
S	BB	WG
5. Irregularities in the structure of the wood		
✓	✓	✓

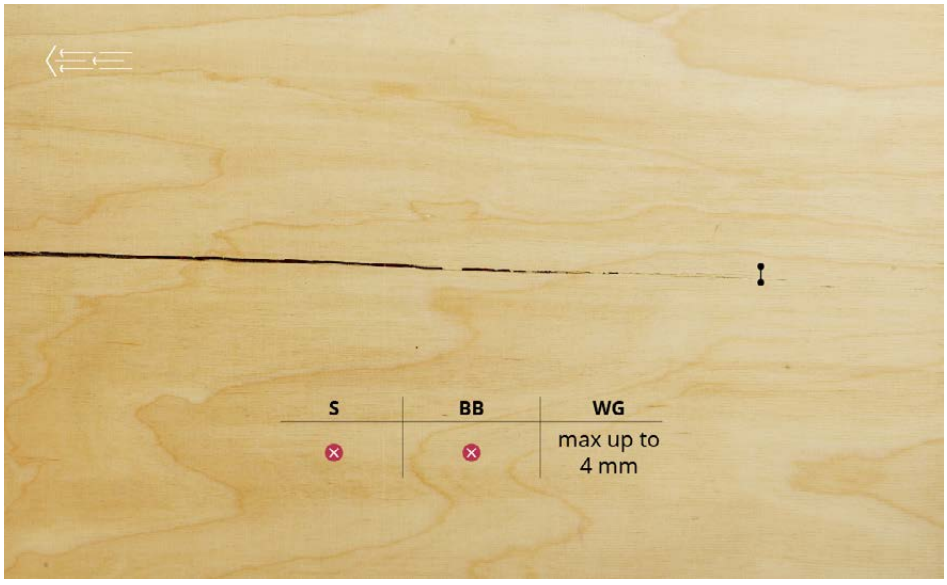
✓ Permitted ✗ Not permitted ○ Not applicable

GRADE		
S	BB	WG
6. Curly grain		
✗	✓	✓

✓ Permitted ✗ Not permitted ○ Not applicable

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

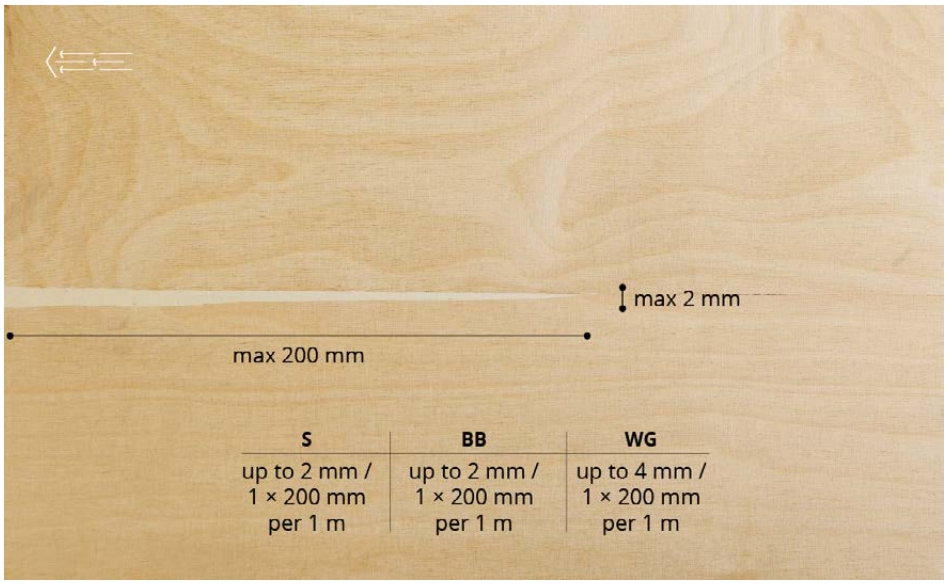


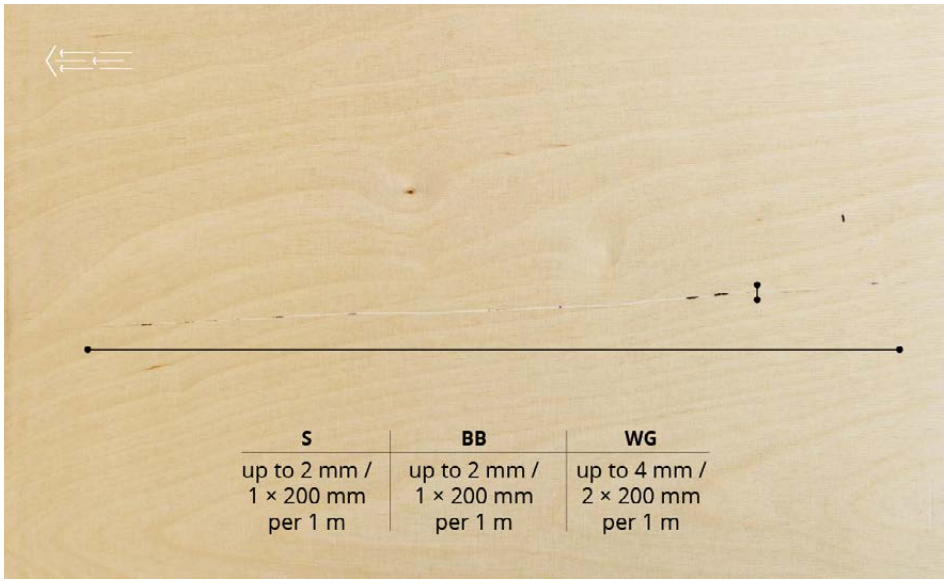


✓ Permitted ⊗ Not permitted ○ Not applicable

RigaWood

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





Permitted

Not permitted

Not applicable

RigaWood

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

Permitted

Not permitted

Not applicable

RigaWood

GRADE		
S	BB	WG
10. Wood discolouration		
Permitted slightly		

Permitted Not permitted Not applicable

RigaWood

GRADE		
S	BB	WG
11. Coloured streaks		
Permitted slightly		

Permitted Not permitted Not applicable

RigaWood

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

RigaWood

GRADE		
S	BB	WG
13. Inserts		
Permitted, if properly inserted and match the plywood colour, not more than 1/m²	Permitted up to 10 pieces per square meter	

Permitted Not permitted Not applicable

RigaWood

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

RigaWood

GRADE		
S	BB	WG
15. Overlap		
⊗	⊗	⊗

Permitted

Not permitted

Not applicable

RigaWood

GRADE		
S	BB	WG
16. Imprints and bumps		
✗	✓ Permitted slightly, up to 2 cm² per panel	✓ Permitted slightly

✓ Permitted ✗ Not permitted ○ Not applicable

RigaWood

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

✓ Permitted ✗ Not permitted ○ Not applicable

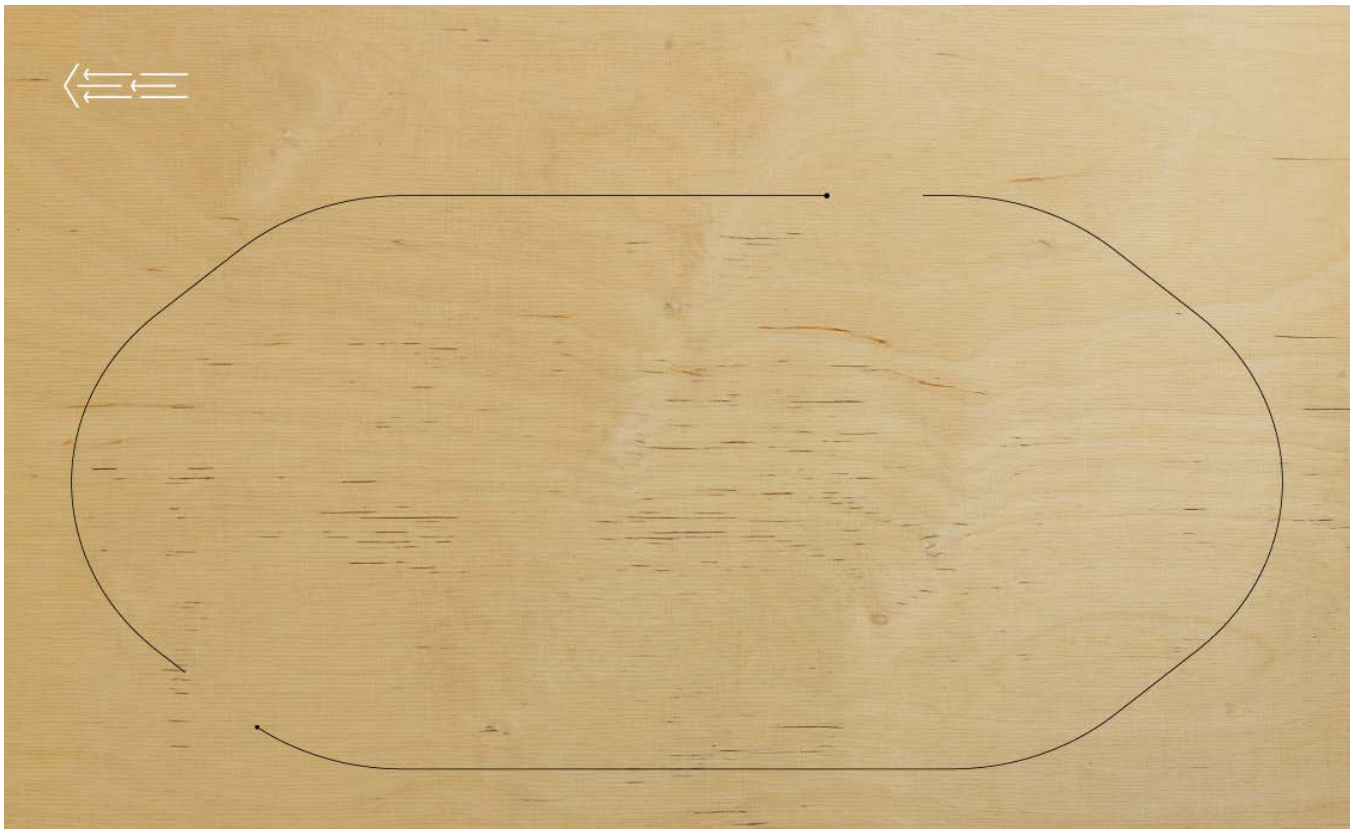
RigaWood

GRADE		
S	BB	WG
18. Sanding through		
✗	✓ Permitted ≤ 10 cm²/m²	✓ Permitted ≤ 20 cm²/m²

✓ Permitted ✗ Not permitted ○ Not applicable

RigaWood

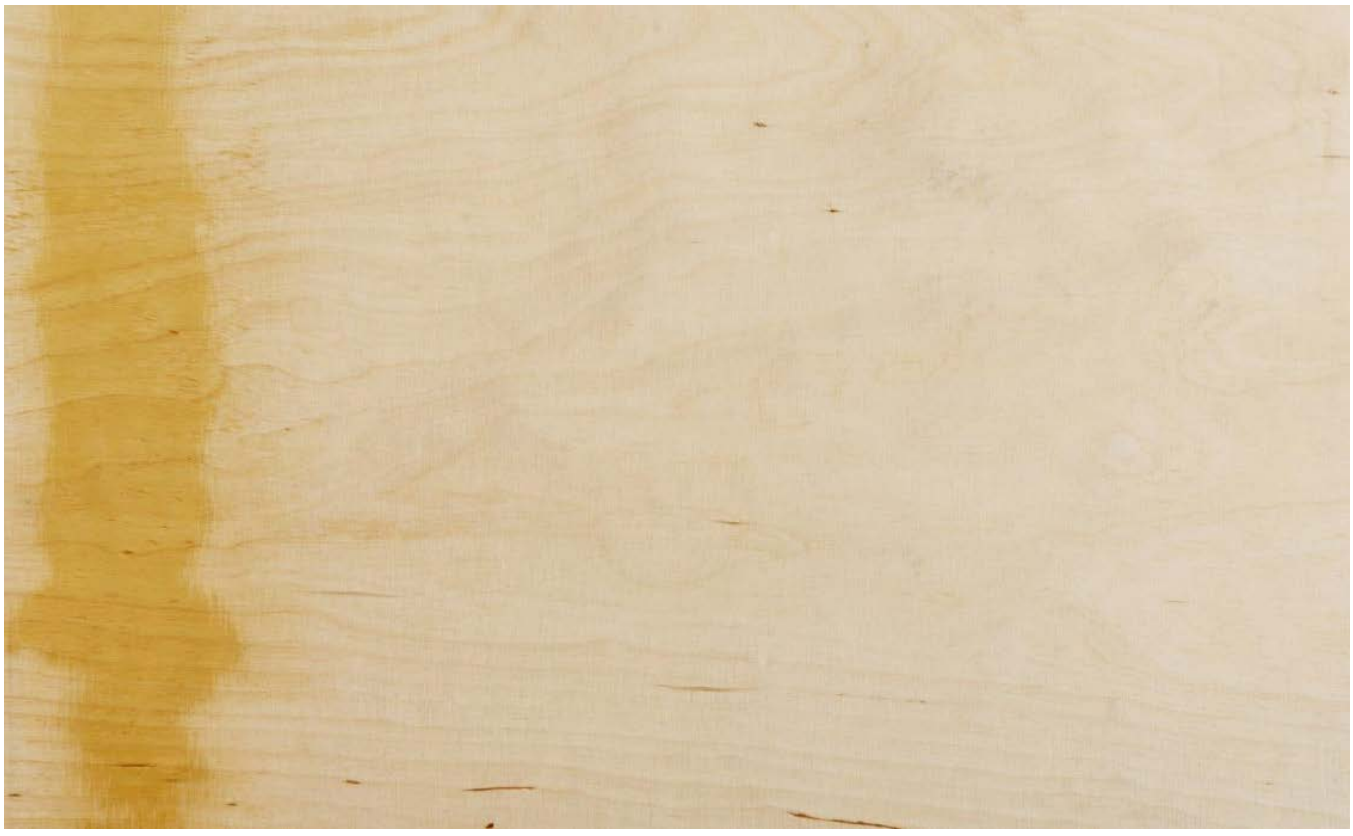
GRADE		
S	BB	WG
19. Glue penetration		
Permitted, if occasionally	Permitted up to 5% of the surface area	



Permitted Not permitted Not applicable

RigaWood

GRADE		
S	BB	WG
20. Unsanded areas		
✗	✗	✓ Permitted up to an extent of 5% of the panel surface



✓ Permitted ✗ Not permitted ○ Not applicable

RigaWood

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

Permitted Not permitted Not applicable

RigaWood

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

Permitted Not permitted Not applicable

RigaWood

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 website.

Permitted

Not permitted

Not applicable