



Technical Description for Birch and Beech Plywood

Manufactured based on Harmonised standards EN 13986:2004+A1:2015 Class +2 /1870-CRP-1636

Panel sizes	2500x1250 , 2440x1220 mm
Size tolerances	± 4.0 mm
Thickness	6.5 – 30 mm
Thickness tolerances	± 0.3 mm
Moisture	5-10%
Glue	Phenolic WBP (exterior)
Formaldehyde emissions	E0.5
Quality grades	B , BB , CP , C
Surfaces	S2S , Film faced , Wire mesh

Thickness	6.5 mm	9 mm	12 mm	15 mm	18 mm	21 mm	24 mm	27 mm	30 mm
Plies	5	7	9	11	13	15	17	19	21

S2S

Description of Defects	B	BB	CP	C
Pin knots	Max 3 per M2 allowed	Allowed	Allowed	Allowed
Sound lights and/or dark knots	Up to 5 per M2 max, 15mm diam. cracks no more than 0,5mm wide	Up to 10 per M2 max, 25mm diam. cracks no more than 1mm wide	Allow cracks not more than 1,5mm wide	Allow cracks not more than 1,5mm wide
Loose knots or with/without knot holes, worm holes in cluster or scattered	Up to 3 with max 6mm diam.	Up to 6 with max 6mm diam.	Up to 6 with max 6mm diam.	No limits with max 40 mm diam.
Tight cracks/splits	Up to 2 per 1M of plywood, max 200mm long	Up to 2 per 1M of plywood, max 200mm long	Allowed	Allowed
Wide cracks/splits	Not allowed	Up to 2 per 1M of plywood filled with putty max 200mm long	Up to 2 per 1M of plywood filled with putty max 600mm long and 5 mm wide	Allowed with limitations
Light Mould	Allowed	Allowed	Allowed	Allowed
Deviation in wood structure	Allowed	Allowed	Allowed	Allowed
Pinholes	Up to 3 with max 6mm diam.	Up to 6 with max 6mm diam.	Up to 6 with max 6mm diam.	No limits with max 40 mm diam.
Lack of veneer, defects of panel edges due to sanding or squaring	Allowed with a width of no more than 2mm	Allowed with a width of no more than 4mm	Allowed with a width of no more than 4mm	Allowed with a width of no more than 5mm
Glue bleed through	Not allowed	Allowed no more than 2% of panel surface	Allowed no more than 5% of panel surface	Allowed
Scratches	Not allowed	Allowed	Allowed	Allowed
Indentations or imprints	Not allowed	Allowed if depth/height is in	Allowed if depth/height is in	Allowed

		range of thickness variance	range of thickness variance	
Torn Grain, Brushy Fibres	Not allowed	Allowed no more than 5% of panel surface	Allowed no more than 15% of panel surface	Allowed
Warp and twist	Allowed with sag of no more than 15mm over 1M panel's diagonal length	Allowed with sag of no more than 15mm over 1M panel's diagonal length	Allowed with sag of no more than 15mm over 1M panel's diagonal length	Allowed with sag of no more than 15mm over 1M panel's diagonal length
Delamination, bubbles, etc	Not allowed	Not allowed	Not allowed	Not allowed
Wooden plugs	Not allowed	Allowed in repair up to 8 pieces for 1m2 of panel	Allowed with no limits	Allowed with no limits
Overlapped plugs	Not allowed	Allowed no more than 2 pieces per 1m2 of panel	Allowed	Allowed

Film Faced and Wire Mesh

Description of Defects	F1	F2	W/F1	W/F2
Scoring , cutting defects	Allowed not more than 3 mm , coated	Allowed not more than 15 mm , coated	Allowed not more than 3 mm , coated	Allowed not more than 15 mm , coated
Film tearing , absence	Allowed on 1 edge ≤3mm , coated	Allowed 5% of surface , coated	Allowed on 1 edge ≤3mm , coated	Allowed 5% of surface , coated
Dents	Allowed ≤ 6mm not more than 1 pcs/m ²	Allowed	Allowed ≤ 6mm not more than 1 pcs/m ²	Allowed
Edge paint flows	Allowed ≤5mm	Allowed	Allowed ≤5mm	Allowed
Press plate marks	Allowed not more than 5% of surface	Allowed	Allowed not more than 5% of surface	Allowed
Film stripes and stains due to volatile emissions	Allowed not more than ≤ 15% of surface	Allowed	Allowed not more than ≤ 15% of surface	Allowed
Temp stains due to premature film hardening	Not allowed	Allowed without surface damaging	Not allowed	Allowed without surface damaging
Stains and strips due to press plate dirt	Allowed	Allowed	Allowed	Allowed
Scratches	Not allowed	Allowed without damaged surface coating	Not allowed	Allowed without damaged surface coating
Burn out film surface	Not allowed	Allowed	Not allowed	Allowed
Marks of wood grain structure and sound knots	Allowed	Allowed	Allowed	Allowed
Inner layer traces defects	Allowed not more than 5% of surface	Allowed	Allowed not more than 5% of surface	Allowed
Wrapping	Allowed with sag of no more than 15mm over 1M panel's diagonal length	Allowed with sag of no more than 15mm over 1M panel's diagonal length	Allowed with sag of no more than 15mm over 1M panel's diagonal length	Allowed with sag of no more than 15mm over 1M panel's diagonal length
Delamination (hidden bubbles)	Not allowed	Not allowed	Not allowed	Not allowed
Lack of edge veneer	Not allowed	Allowed ≤10mm	Not allowed	Allowed ≤10mm