

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		

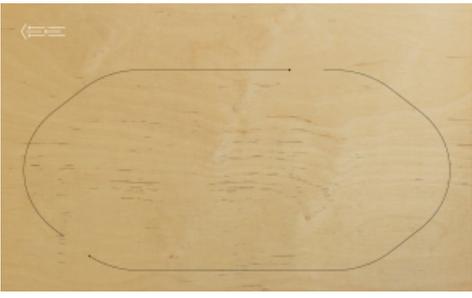
Grade	Recommended application		
WG	For use where surface appearance is not important, reverse grade. The total number of defects is unlimited		
WGE	Plywood of WG grade without open defects (repaired with filler), for overlaying with non-transparent finishing material.		

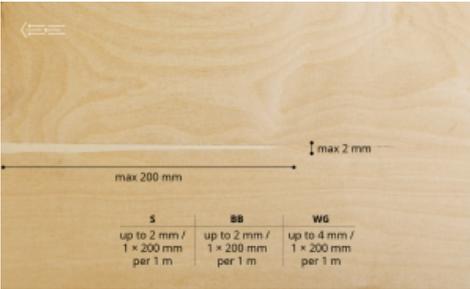
* Plywood grade photos are made of a compilation of A5 samples

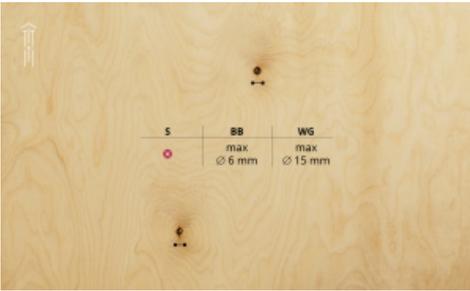
✓ Permitted

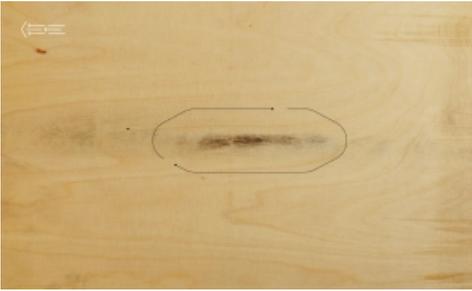
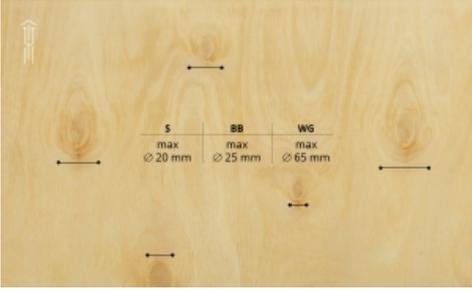
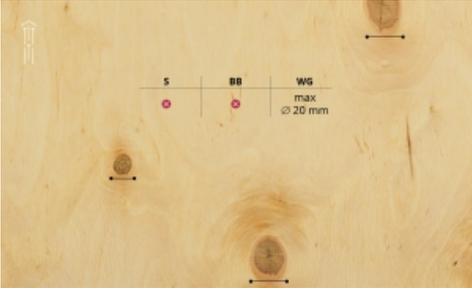
✗ Not permitted

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

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

DEFECT	PLYWOOD GRADES		
	S	BB	WG
Irregularities in the structure of the wood			
	✓	✓	✓
Open joints			
	✗	✓ 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	✓ Up to an individual max width 3 mm
Open splits and checks			
	✗	✗	✓ 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			
	✓ 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		
	S	BB	WG
Other knots and holes			
		 Up to an individual max Ø 6 mm, if the cumulative Ø does not exceed 25 mm/m ²	 Up to an individual max Ø 15 mm, if the cumulative Ø does not exceed 100 mm/m ²
Overlap			
			
Pin knots			
			
Roughness			
		 Slightly, up to 10 cm ² /m ² , if repaired with putty – max 3 defects per panel	

DEFECT	PLYWOOD GRADES								
	S	BB	WG						
Sanding through									
		 ≤ 10 cm ² /m ²	 ≤ 20 cm ² /m ²						
Sound intergrown knots									
 <table border="1" data-bbox="236 797 434 846"> <tr> <td>S</td> <td>BB</td> <td>WG</td> </tr> <tr> <td>max ∅ 20 mm</td> <td>max ∅ 25 mm</td> <td>max ∅ 65 mm</td> </tr> </table>	S	BB	WG	max ∅ 20 mm	max ∅ 25 mm	max ∅ 65 mm	 Up to an individual max ∅ 20 mm, if the cumulative ∅ does not exceed 50 mm/m ²	 Up to an individual max ∅ 25 mm, if the cumulative ∅ does not exceed 60 mm/m ²	 Up to an individual max ∅ 65 mm, if the cumulative ∅ does not exceed 600 mm/m ²
S	BB	WG							
max ∅ 20 mm	max ∅ 25 mm	max ∅ 65 mm							
Unsanded areas									
			 Up to an extent of 5% of the panel surface						
Unsound adhering knots									
 <table border="1" data-bbox="236 1671 434 1720"> <tr> <td>S</td> <td>BB</td> <td>WG</td> </tr> <tr> <td>max ∅ 20 mm</td> <td>max ∅ 20 mm</td> <td>max ∅ 20 mm</td> </tr> </table>	S	BB	WG	max ∅ 20 mm	max ∅ 20 mm	max ∅ 20 mm			 Up to an individual max ∅ 20 mm, if the cumulative ∅ does not exceed 200 mm/m ²
S	BB	WG							
max ∅ 20 mm	max ∅ 20 mm	max ∅ 20 mm							

DEFECT	PLYWOOD GRADES		
	S	BB	WG
Wood discolouration			
	 Slightly	 Up 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 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.