

Birch plywood quality grades

| CHARACTERISTICS | I | II | III | IV | C |
|---|---|---|---|---|--|
| | B | S | BB | CP | |
| Pin knots (sound intergrown knots of no more 3 mm diameter) | Permitted | Permitted | Permitted | Permitted | Permitted |
| Sound intergrown knots | Diameter up to 6 mm, cumulative diameter does not exceed 12 mm/m ² | Diameter up to 20 mm, cumulative diameter does not exceed 50 mm/m ² Knots may have slight splits up to 0.5 mm | Diameter up to 25 mm, cumulative diameter does not exceed 60 mm/m ² Knots may have slight splits up to 0.5 mm | Diameter up to 40 mm, cumulative diameter does not exceed 400 mm/m ² Knots may have splits up to 1 mm | Permitted |
| Unsound adhering knots | Not permitted | Not permitted | Not permitted | Diameter up to 5 mm up to 3 per m ² | Permitted |
| Other knots and holes | Not permitted | Not permitted | Diameter up to 6 mm, cumulative diameter does not exceed 25 mm/m ² , repaired | Diameter up to 15 mm, cumulative diameter does not exceed 100 mm/m ² , repaired | Diameter up to 40 mm up to 10 per m ² |
| Abnormalities due to insects | Not permitted | Not permitted | Diameter of 3 mm vertically to the plane of panel, up to 10 per m ² , repaired | Width 15 mm and length 60 mm, up to 3 per m ² | Permitted |
| Open splits and checks | Not permitted | Up to an individual width up to 2 mm and of an individual length 200 mm, up to 1 per meter of panel width, repaired | Up to an individual width up to 2 mm and of an individual length 200 mm, up to 1 per meter of panel width, repaired | Up to an individual width up to 2 mm and of an individual length 600 mm, up to 2 per meter of panel width, repaired | Up to an individual width up to 10 mm and of an individual length 400 mm, up to 5 per meter of panel width |
| Closed splits and checks | Not permitted | Up to an individual length 200 mm, up to 2 per meter of panel width, repaired | Up to an individual length 200 mm, up to 2 per meter of panel width, repaired | Permitted | Permitted |

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| Irregularities in the structure of the wood | Permitted, but slightly | Permitted | Permitted | Permitted | Permitted |
| Stains from manufacturing (beam traces, strips) | Not permitted | Not permitted | Permitted up to 10% of the sheet surface are | Permitted | Permitted |
| Curly grain | Not permitted | Not permitted | Permitted | Permitted | Permitted |
| Discoloration and colored streaks | Up to 15% of the panel surface without colored streaks | Up to 15% of the panel surface, few streaks of color and minerals | Up to 15% of the panel surface | Permitted | Permitted |
| Brown, but not rot | Not permitted | Not permitted | Up to 3% of the panel surface | Permitted | Permitted |
| Brown, hard rot at the initial phase | Not permitted | Not permitted | Not permitted | Not permitted | Permitted |
| Inserts | Not permitted | Allowed if properly matched color tones and not more than 1 / m ² | Permitted 10 pieces per square meter | Permitted | Permitted |
| Open joints | Not permitted | Not permitted | Up to an individual width up to 2 mm and of an individual length 200 mm, up to 1 per meter of panel width, repaired | Up to an individual width up to 2 mm and of an individual length 600 mm, up to 2 per meter of panel width, repaired | Up to an individual width up to 7 mm |
| Dents and bumps | Not permitted | Not permitted | Very slight in height or depth up to 2 cm ² , up to 3 defects per panel | Up to 0.5 mm in height or depth, up to 120 mm in width | Permitted |
| Roughness | Not permitted | Not permitted | Slight up to 10 cm ² /m ² , up to 3 defects per panel | Permitted | Permitted |
| Sanding through | Not permitted | Not permitted | Up to 10 cm ² per m ² | Up to 10 cm ² per m ² | Permitted |
| Glue penetration | Not permitted | Occasionally | Up to 5% of the panel surface | Up to 10% of the panel surface | Permitted |
| Unsanded areas (for sanded plywood) | Not permitted | Up to 5 mm from the edge | Up to 5 mm from the edge | Up to 5% of the panel surface | Up to 50% of the panel surface |

| Defects at the edges (sanding, trimming) | Up to 5 mm from the edge, if the glue is not visible | Up to 5 mm from the edge, not in all length, repaired | Up to 5 mm from the edge, not in all length, repaired | Up to 5 mm from the edge | Up to 10 mm from the edge |
|--|--|---|---|--------------------------|---------------------------|
| Delamination | Not permitted | Not permitted | Not permitted | Not permitted | Not permitted |
| A part of bark or bast remaining on face veneer area | Not permitted | Not permitted | Not permitted | Not permitted | Not permitted |