

# Class I

Surface appearance classification determined by **wood characteristics**

## ALLOWED

- ✓ Pin knots  
Allowed: 3 pcs/m<sup>2</sup>
- ✓ Knots: sound, intergrown, light and dark  
Allowed up to 15 mm in diameter individually and 30 mm maximum when grouped; small shakes allowed.
- ✓ Black knots, intergrown knots, loose knots, knot holes  
Allowed up to 6mm in diameter when filled; 2pcs /m<sup>2</sup>
- ✓ Open shakes, open splits in spliced veneer  
Allowed up to 1/10 of the sheet's length and up to 3mm width, 3 pcs/m when filled
- ✓ Closed shakes

## NOT ALLOWED

- ✗ Inbark
- ✗ Resin blemishes

Surface appearance classification determined by **manufacturing process**

## ALLOWED

- ✓ Knotting and patching:
  - a) Wooden inserts
  - b) WedgesAllowed when filled and complete, 5 pcs/m<sup>2</sup>
- ✓ Edge defects caused by sanding, cutting (fringe), veneer shortage  
Allowed: up to 2 mm wide along the edge

## NOT ALLOWED

- ✗ Overlap ridges
- ✗ Air pockets
- ✗ Scratches, grooves, ridges
- ✗ Uneven sanding
- ✗ Face veneer oversanding
- ✗ Glue stains
- ✗ Metal inclusions

**Class I**



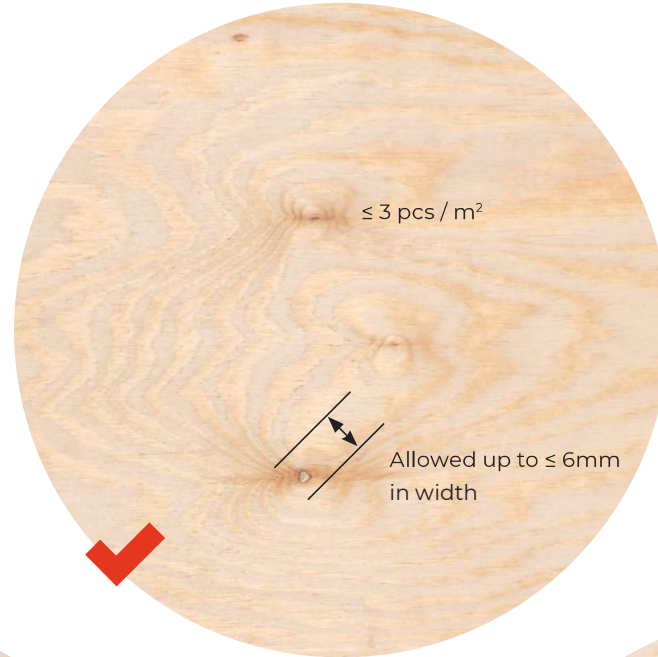
# Class I

Wooden inserts



$\leq 5 \text{ pcs} / \text{m}^2$

Pin knots and open shake



$\leq 3 \text{ pcs} / \text{m}^2$

Allowed up to  $\leq 6\text{mm}$   
in width



# Class II

Surface appearance classification determined by **wood characteristics**

## ALLOWED

- ✓ Pin knots
- ✓ Knots: sound, intergrown, light and dark  
Allowed up to 50 mm in diameter; small shakes allowed.
- ✓ Black knots, intergrown knots, loose knots, knot holes  
Allowed up to 25mm in diameter when filled; up to 5mm, when open; 6pcs/m<sup>2</sup>
- ✓ Open shakes, open splits in spliced veneer  
Allowed up to 1/3 of the sheet's length and up to 10mm width, 3 pcs/m. All shakes of 2 mm and more must be filled.
- ✓ Closed shakes
- ✓ Resin canals and pockets; inbark, light and dark  
Allowed up to 6 mm in width when filled
- ✓ Resin blemishes  
Allowed in moderation
- ✓ Timber structure flaws (diagonal grain, swirly grain, burls, bud traces)  
Allowed when moderate
- ✓ Sound discoloration  
Dopuszcza się nieznaczne różnicowanie naturalnej barwy drewna

## NOT ALLOWED

- ✗ Biological damage (wormholes, parasitic plants, microorganisms)  
No traces of parasitic plants allowed. Hollow corridors and wormholes are allowed of 3mm in diameter vertically to the sheet's surface, 10 pcs/m<sup>2</sup>

Surface appearance classification determined by **manufacturing process**

## ALLOWED

- ✓ Open shakes  
Allowed when filled with width of 1 mm and more – 1pc/m of the sheet's width
- ✓ Overlap ridges  
Allowed up to 100 mm length, 1 pc/m<sup>2</sup>
- ✓ Scratches, grooves, ridges      Allowed when moderate
- ✓ Uneven sanding      Allowed when moderate
- ✓ Glue stains  
Allowed when moderate
- ✓ Knotting and patching  
a) Wooden inserts  
b) Wedges  
Allowed when filled and complete
- ✓ Edge defects caused by sanding, cutting (fringe), veneer shortage  
Allowed: up to 5 mm wide along the edge

## NOT ALLOWED

- ✗ Face veneer oversanding
- ✗ Metal inclusions
- ✗ Air pockets

**Class II**

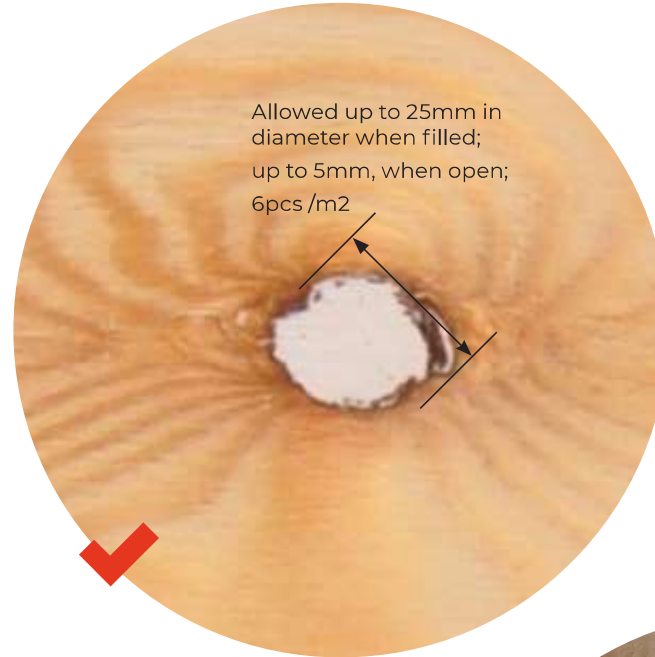


# Class II

Resin blemish

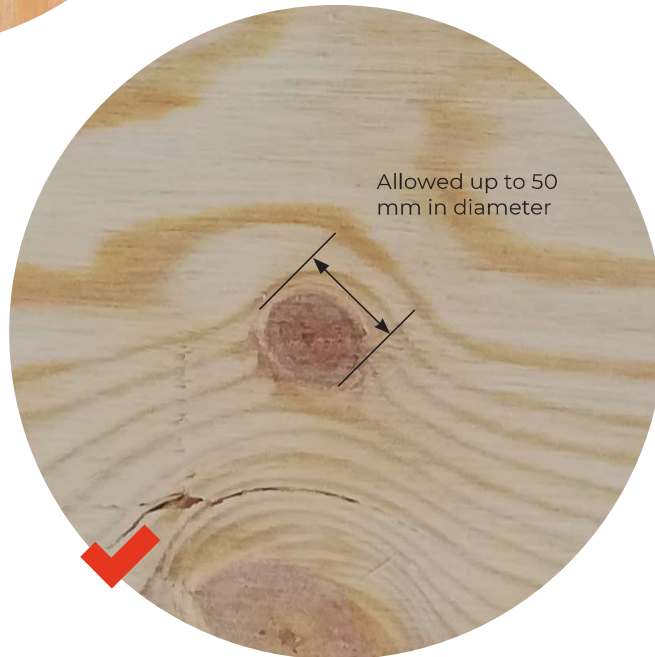


Filled knot



Allowed up to 25mm in diameter when filled; up to 5mm, when open; 6pcs /m<sup>2</sup>

Sound knot



Allowed up to 50 mm in diameter

Open shake



Allowed up to 1/3 of the sheet's length and up to 10mm width, 3 pcs/m.

All shakes of 2 mm and more must be filled.

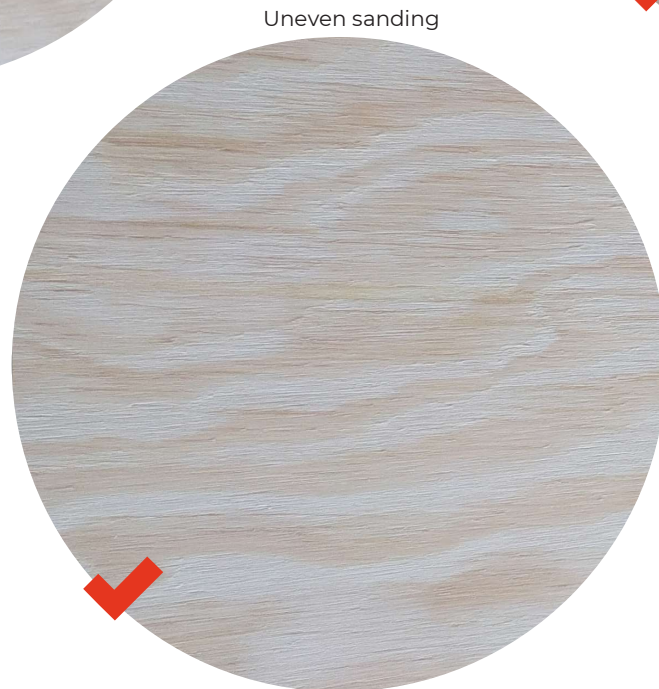
# Class II



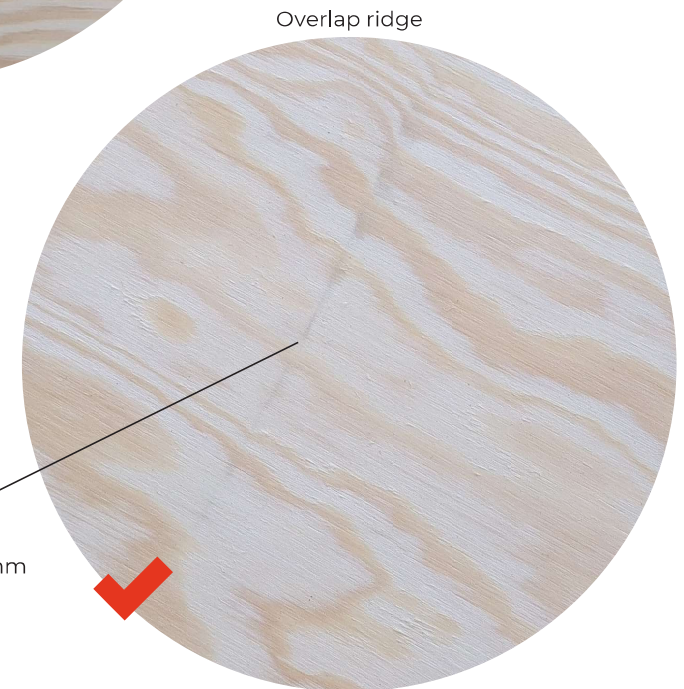
Sound discoloration



Wooden insert



Uneven sanding



Overlap ridge

Allowed up to 100 mm length, 1 pc/m<sup>2</sup>