

Artisan- Birch Plywood Grading Rules

Categories of defects	Plywood grades				
	B	S	BB	WG	C
	Permitted	Permitted	Permitted	Permitted	Permitted
Sound intergrown knots	Permitted $\leq \varnothing 6$ mm, $\Sigma \leq 12$ mm/m ²	Permitted $\leq \varnothing 20$ mm, $\Sigma \leq 50$ mm/m ²	Permitted $\leq \varnothing 25$ mm, $\Sigma \leq 60$ mm/m ²	Permitted $\leq \varnothing 65$ mm, $\Sigma \leq 600$ mm/m ²	Permitted
Unsound adhering knots	Not permitted	Not permitted	Not permitted	Permitted $\leq \varnothing 20$ mm, $\Sigma \leq 200$ mm/m ²	Permitted
Other knots and holes	Not permitted	Not permitted	Permitted $\leq \varnothing 6$ mm, $\Sigma \leq 25$ mm/m ² , repaired	Permitted $\leq \varnothing 15$ mm, $\Sigma \leq 100$ mm/m ²	Permitted $\leq \varnothing 40$ mm, ≤ 10 /m ²
Irregularities in the structure of the wood	Permitted, but slight	Permitted	Permitted	Permitted	Permitted
Curly grain	Not permitted	Not permitted	Permitted	Permitted	Permitted
Open splits and checks	Not permitted	Permitted for an individual width up to 2 mm and of an individual length ≤ 200 mm and ≤ 1 per metre of panel width, repaired	Permitted for an individual width up to 2 mm and of an individual length ≤ 200 mm and ≤ 1 per metre of panel width, repaired	Permitted for an individual width up to 4 mm and ≤ 2 per metre of panel width	Permitted for an individual width up to 10 mm and of an individual length ≤ 400 mm and ≤ 5 per metre of panel width
Closed splits and checks	Not permitted	Permitted for an individual length up to 200 mm and in number up to 2 per metre of panel width	Permitted for an individual length up to 200 mm and in number up to 2 per metre of panel width	Permitted	Permitted
Discolouration	Permitted, but slight (not at the edges of panel) $\leq 15\%$ of panel surface				
Discolouration and coloured streaks	Not permitted	Permitted up to an extent of 15% of the panel surface, some streaks of colour and minerals	Permitted up to an extent of 30% of the panel surface	Permitted	Permitted
Brown, but not rot	Not permitted	Not permitted	Permitted up to an extent of 30% of the panel surface	Permitted	Permitted
Brown, rot at the initial period	Not permitted	Not permitted	Not permitted	Not permitted	Permitted
Inserts	Not permitted	Permitted ≤ 1 /m ²	Permitted up to an extent of 3% of the panel surface	Permitted	