

## China Plywood Grade

Categories of defects	Inspection Item	Face				Back	
		Grade Of Plywood					
		AA Grade	A Grade	B Grade	C Grade		
(1)Pin knots	ii	Allowed					
(2)Inter grown knots	maximal single diameter (mm)	10	20	Not Restricted			
(3)partially inter grown knots, dead knots, inbark	the entries on one side per square meter	Not allowed	3	4	6	Not Restricted	
ii	partially inter grown knots	maximal single diameter (mm)	Not allowed	10 25 (not counted up to 5)		Not Restricted	
	Dead knots	maximal single diameter (mm)	Not allowed	4 (not counted up to 2)	6 (not counted up to 4)	15	50
	Inbark	maximal single length (mm)	Not allowed	15 (not counted up to 5)	30 (not counted up to 10)	Not Restricted	
(4)Abnormals tructure	ii	Allowed					
(5)Split	maximal single width (mm)	Not allowed	1 Basswood:0.5 Southern Timber:1.5	1.5 Basswo od:1 Souther n Timber: 2	3 Basswood: 1.5 Southern Timber:4	6	
	maximal single length (mm)		200 Southern Timber:250	300 Souther n Timber: 350	400 Southern Timber:45 0	Not Restricted	
(6)Worm holes,dog holes,holes	maximal single diameter (mm)	Not allowed	2	4	8	15	
	the entries on o		4	4(not co	Not Sifter Shape Appearencef-Not Re		

	one side per square meter			limited up to 2mm)	restricted		
(7)Discoloration	Not exceed the area of side(%)	Not Allowed	5	25	Not Restricted		
		<p>Note: «Tint fleck streaks is counted as discoloration»</p> <p>«A grade: fuscous fleck streaks not exceed 20mm in length and 2mm in width;</p> <p>«B grade: fuscous fleck streaks not exceed 150mm in length and not exceed 3 spots per m<sup>2</sup></p> <p>«Basswood Board(except AA grade),false heartwood is allowed ,but the color and luster of the A grade should be attempted</p> <p>«Basswood board (A gradee),brown or black pith flecks are not allowed;</p> <p>«(AA grade) limbic heartwood of different color are counted as discoloration</p>					
(8)Rot	ii	Not allowed		Symbols of incipient decay are allowed if not affect strength ,yet the area not exceed 1% of the side area	incipient decay is allowed but the veneer of this part will not flake off,also can't be twisted into powder		
(9) outer ply open joint	Max. single width(mm)	Not allowed	0.5	1	2		
	Max. single length account for the length of the panel (%)		10	30	50		
	Bar /metre in width		1	2	Not restricted		
(10) outer ply overlap	Max single width(mm)	Unallowed		8	Not restricted		
	Max. single length account for the length of the panel (%)			20			
(11)Core gap	The core gap appressed to	Max single width(mm)	Not allowed	2	4	8	10

	outer ply	Bar /metre in width		2	3 (not counted up to 2mm)	Not restricted	
	The max gap width of other ply(mm)			10			
(12)centers gap	Max single width (mm)	Not allowed	10				
(13) blister, delamination	ii	Not allowed					
(14)Hollow, imprint,bump	Max. single area(mm <sup>2</sup> )	Not allowed	50	400	3000	Not restricted	
	the entries on one side per square meter		1	4	Not restricted		
(15) torn grain	Not exceed side area(%)	Not allowed	1	3	25	Not restricted	
	The depth not exceed(mm)		0.4	Not penetrate through, allowed			
(16)outer ply sanding through	Area on side per mm <sup>2</sup>	Not allowed			1000	Not restricted	
(17)glue penetration & any other manmade stain	Not exceed side area(%)	Not allowed	0.5	3	30	Not restricted	
(18)patch;çsh im	Allowed(If made in proper way and fill up durably),the entries on side per m <sup>2</sup>	Not allowed		3	Not restricted	Not restricted	
	add up to not exceed side area(%)			0.5	3		
	Gap not exceed(mm)			0.5	1	2	
(19)aluminou	ii	Not allowed		allowed			

s inclusions				
(20)defects at the edges of the panel	Not exceed mm(within the nominal breadth)	Not allowed	5	10
(21)other defects	ii	Not allowed	Regarded as the most similar defects	

Table 2. **conifer timber plywood gradation**

Categories of defects	Inspection Item	Face				Back
		Grade Of Plywood				
		AA Grade	A Grade	B Grade	C Grade	
(1) Pin knots	ii	allowed				
(2)intergrown knots,partially intergrown knots,dead knots	the entries on one side per square meter	Not allowed	5	8	10	Not restricted
ii	Intergrown knots	Max. single diameter (mm)	Not allowed	(not counted up to 10)		Not restricted
	partially inter grown knots,dead knots	Max. single diameter (mm)	Not allowed	5	15 (not counted up to 5)	30 (not counted up to 10) Not restricted
(3)Abnormalstructure	ii	allow				
(4)inbark; resin pocket	the entries on one side per square meter	Not allowed	3 4 (not counted up to 10)		10 (not counted up to 15)	Not restricted
ii	inbark	Max. single length (mm)	Not allowed	15	60	Not restricted
	resin pocket	Max. single length (mm)	Not allowed	15	30	Not restricted
(5)split	maximal single width (mm)	Not allowed	1	1.5	3	6
	maximal single length (mm)		200	400	800	Not restricted
(6)Worm holes, dog holes, holes	maximal single diameter (mm)	Not allowed	2	5	8	15
	the entries on one side per square meter		4	5 (not counted up to 2mm)	10 (not counted up to 5mm)	If not Sifter Shape Appearan

							ce then not Restricted
(7)Discoloration	Not exceed the area of side(%)	Not allowed	tint 10	30	Not restricted		
(8)Rot		Not allowed			Symbols of incipient decay are allowed if not affect the strength ,yet the area not exceed 1% of the side area	incipient decay is allowed but the veneer of this part will not flake off, also can't be twisted into powder	
(9)Resin streak	Max single length(mm)	Not allowed	150	Not restricted			
	Max. single length account for the length of the panel (%)		10				
	the entries on one side per square meter		4				
(10) outer ply open joint	Max. single width(mm)	Not allowed		0.5	1	2	
	Max. single length account for the length of the panel (%)			10	30	50	
	Bar /metre in width			1	2	Not restricted	
(11)outer ply overlap	Max single width(mm)	Not allowed			8	Not restricted	
	Max. single length account for the length of the panel (%)				20		
(12)core gap	The core gap appressed to outerply	Max single width(mm)	2	4	8	10	
		Bar /metre in width	2	3 (not counted up to 2mm)	Not restricted		
	The max gap width of other ply(mm)	10					

(13)centers gap	Max single width (mm)	Not allowed	10			
(14)blister, delamination	ii	Not restricted				
(15)hollow, imprint, bump	Max. single area(mm <sup>2</sup> )	Not allowed	50	400	3000	Not restricted
	the entries on one side per square meter		2	4	Not restricted	
(16)torn grain	Not exceed side area(%)	Not allowed	5	20	60	Not restricted
	The depth not exceed(mm)		0.5	Not penetrate through, allowed		
(17)outer ply sanding through	Area on side per mm <sup>2</sup>	Unallowed			1000	Not restricted
(18) glue penetration & any other manmade stain	Not exceed side area(%)	Not allowed	1	10	Not restricted	
(19)patch; shim	Allowed(If made in proper way and fill up durably),the entries on side per m <sup>2</sup>	Not allowed		6	Not restricted	
	add up to not exceed side area(%)			1	5	Not restricted
	Gap not exceed(mm)			0.5	1	2
(20)aluminous inclusions	ii	Not allowed		allow		
(21) defects at the edges of the panel	Not exceed (mm) (within the nominal breadth)	Not allowed		5	10	
(22) other defects	ii	Not allowed	Regarded as the most similar defects			

CANEX GROUP  
T: 86-22-88385862  
F: 86-22-88385863  
www.canex-group.com  
info@canex-group.com