

GENERAL GRADING RULES - SOUTH EAST ASIAN PLYWOOD (INCLUDING CHINESE OKOUME FACED POPLAR PLYWOOD)

GRADE BB/CC

Particulars	Face	Back
Sound live knots	Max diameter 25mm Not clustered Max 6 per panel	Max diameter 40mm Max 6 per panel
Dead knots & Knot holes	Not permitted	Max diameter 15mm, well filled and Sanded. Max 2 per panel
Open knot holes	Not permitted	As per face
Live pin knots	Permitted	As per face
Sound burls	Permitted	As per face
Dry pitch pockets	Permitted if well filled Max size 100 x 4mm, max 2 per panel	As per face
Minor natural Discolouration	Permitted if only slightly conspicuous	As per face
Stains / mineral streaks	Permitted if only slightly conspicuous	As per face
Decay	Not permitted	Permitted if not conspicuous
Cross split	Hairline, max 100mm in length Permitted, Max 1 per panel	As per face
Open split	Hairline, max 100mm in length Permitted, Max 3 per panel (unfilled)	As per face
Filled splits	Max size 150 x 5.0mm, max 2 at each End, well filled and matched for colour	Max size 300 x 10.0mm, max 2 at each end well filled and matched for colour
Putty smear	Permitted if not conspicuous	As per face
Pinworm holes / tracks	Not permitted	Occasional pinworm holes permitted if Scattered, well filled and matched for colour
Pin holes	Permitted if not conspicuous and Not clustered	Permitted if tight

Vine marks	Permitted if occasional, level and smoothly sanded	As per face
Rough cut	Permitted if not conspicuous and smoothly sanded	As per face
Torn grain	Permitted if slight	As per face
Patches	Permitted if not conspicuous, max 3 per panel.	As per face
Shims	Permitted if not conspicuous and do not exceed 300 x 5.0mm long grain.	As per face
Veneer joints	Max 2 per panel, well made, parallel to edges and well matched for colour and grain direction	Max 3 per panel, well made, parallel to edges and well matched for colour and grain direction
Tape or glue residue	Permitted if slight and smoothly sanded	As per face
Knife marks	Max 0.7mm if smooth and not conspicuous	As per face
Sanding	Smooth, free from conspicuous streaks or chatter	Smooth
Bark	Permitted if very slight	As per face
Mechanical defects (oil stains, chain marks, sanding burns etc)	Not permitted	Permitted if not conspicuous
Wet pitch	Not conspicuous	As per face
Press marks	Not permitted	Not permitted
Core gaps	Permitted, max 150 x 15mm but plugged	
Core overlaps	Permitted but not severe	
Blisters / delamination	Not permitted	
Short core veneers	Not permitted	

Note:The aforementioned grading rules are not based on any specific grading rules and are a combination of BSI, IHPA & JPIC grading rules which are open to different interpretations.

Furthermore, these rules are intended to be used as a general guidelines only and no responsibility will be accepted for qualities which do not comply with these guidelines.

GENERAL GRADING RULES - SOUTH EAST ASIAN PLYWOOD (INCLUDING CHINESE OKOUME FACED POPLAR PLYWOOD)

GRADE BB/CC

Particulars	Face	Back
Sound live knots	Max diameter 13mm Not clustered Max 4 per panel	Max diameter 25mm Max 5 per panel
Dead or unsound knots	Not permitted	Not permitted
Open knot holes	Not permitted	Not permitted
Pin knots	Permitted if tight and not clustered	Permitted
Sound burls	Permitted if smooth	Permitted
Dry pitch pockets	Not permitted	Permitted if well filled, Max size 100 x 4mm, Max 2 per panel
Minor natural Discolouration	Permitted if not conspicuous	Permitted if only slightly conspicuous
Stains / mineral streaks	Permitted if not conspicuous	Permitted if only slightly conspicuous
Decay	Not permitted	Not permitted
Cross split	Hairline, max 100mm in length Permitted, Max 1 per panel	As per face
Open split	Hairline, max 100mm in length Permitted, Max 3 per panel (unfilled)	As per face

Filled splits	Max size 150 x 3.0mm, max 2 at each End, well filled and matched for colour	Max size 300 x 5.0mm, max 2 at each end well filled and matched for colour
Putty smear	Permitted if not conspicuous	Permitted if not severe
Pinworm holes / tracks	Not permitted	Occasional pinworm holes permitted if Scattered, well filled and matched for colour
Pin holes	Not permitted	Permitted if not conspicuous
Vine marks	Max size 100 x 4.0mm, max 2 per Panel if level and smoothly sanded	Permitted if occasional if level and smoothly sanded
Rough cut	Permitted if smoothly sanded	Permitted if smoothly sanded
Torn grain	Permitted if very slight	Permitted if slight
Patches	Not permitted	Permitted if not conspicuous, max 3 per Panel.
Shims	Not permitted	Permitted if not conspicuous and do not exceed 300 x 5.0mm long grain.
Veneer joints	Max 1 per panel, well made, parallel to edges and well matched for colour and grain direction	Max 2 per panel, well made, parallel to edges and well matched for colour and grain direction
Tape or glue residue	Not permitted	Permitted if slight and smoothly sanded
Knife marks	Not permitted	Max 0.7mm if smooth and not Conspicuous
Sanding	Smooth, free from conspicuous Streaks or chatter	Smooth
Bark	Not permitted	Permitted if very slight
Mechanical defects (oil stains, chain marks, sanding burns etc)	Not permitted	Permitted if not conspicuous
Wet pitch	Not permitted	Not conspicuous
Press marks	Not permitted	Not permitted

Core voids	Permitted, max 5mm wide filled with veneer
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Core gaps	Permitted, max 200 x 5.0mm, smooth and not severe
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Note: The aforementioned grading rules are not based on any specific grading rules and are a combination of BSI, IHPA & JPIC grading rules which are open to different interpretations.

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