



The world leader in birch plywood
production

SVEZA PLYWOOD GRADES SUMMARY



For full descriptions, see SVEZA Plywood Grades And Defects Reference.
Ask your supplier.

Code of restrictions on processing defects in plywood
under STO 00255177-001-2013 requirements

20
19
18
17
16
15
14
13
12
11
10
9
8
7
6
5
4
3
2
1
0



CONTENTS

Grade B. SVEZA plywood sheet sample (p. 3)

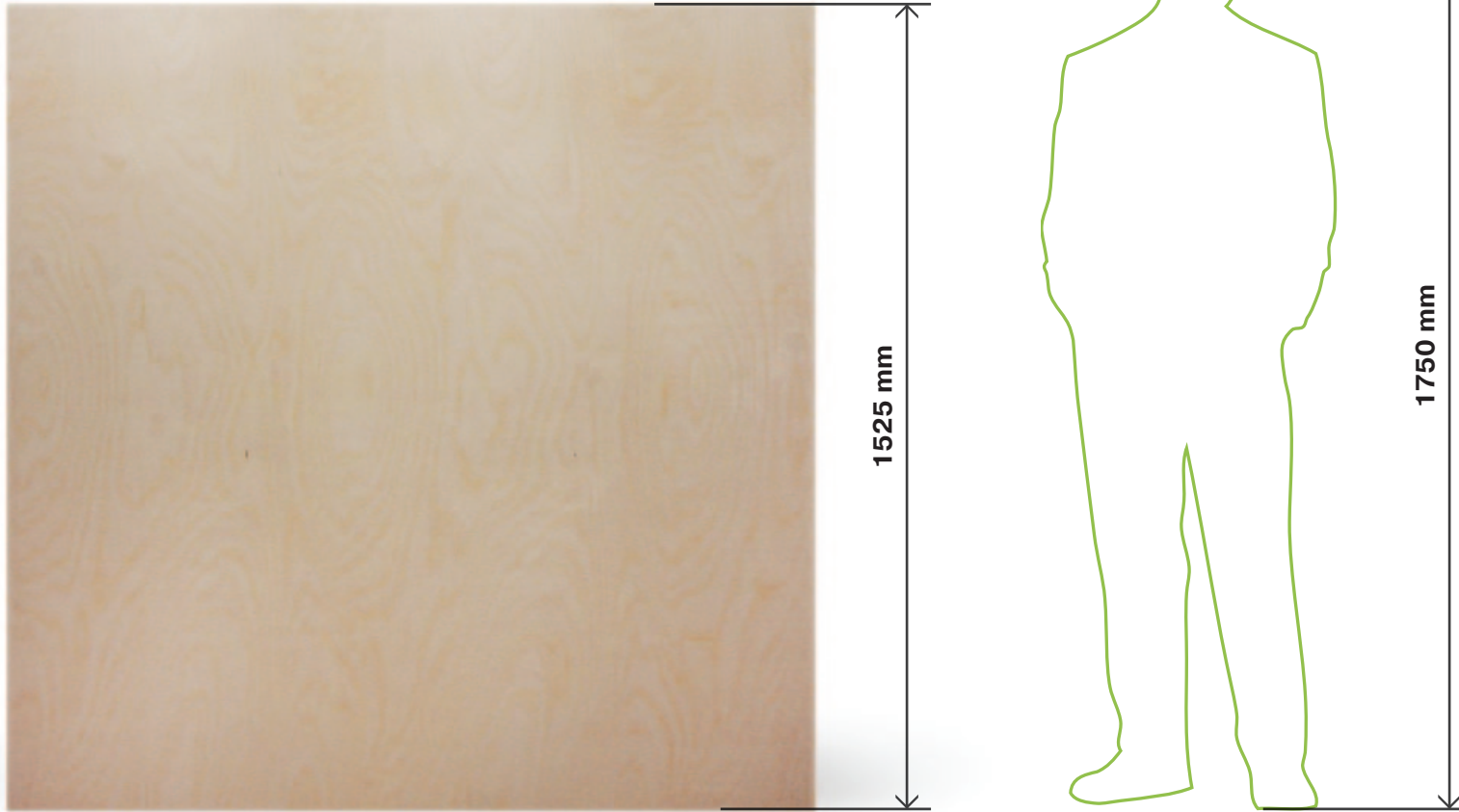
Grade BB. SVEZA plywood sheet sample (p. 5)

Grade CP. SVEZA plywood sheet sample (p. 7)

Grade C. SVEZA plywood sheet sample (p. 10)

SVEZA plywood grades description according to STO 00255177-001-2013 (p. 15)

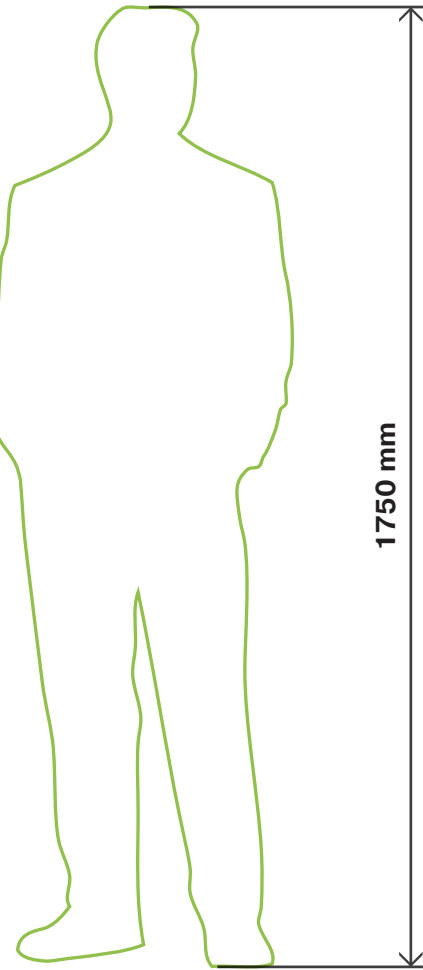
GRADE B SVEZA PLYWOOD SHEET SAMPLE



The picture shows a sample image of SVEZA grade B plywood.
See the detailed grade description with a full list of allowable and non-allowable defects further in the catalog.

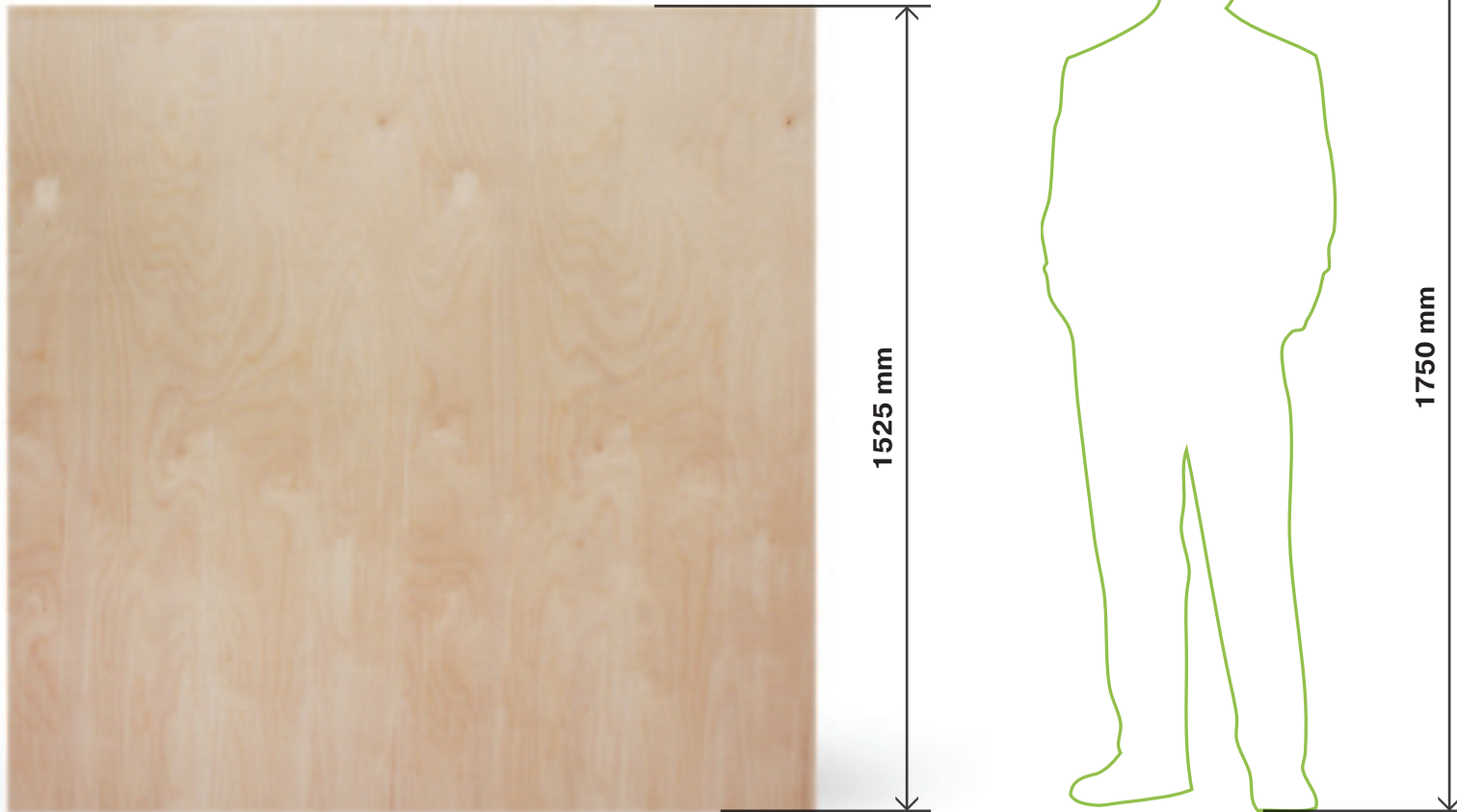


GRADE B SVEZA PLYWOOD SHEET SAMPLE



The picture shows a sample image of SVEZA grade B plywood.
See the detailed grade description with a full list of allowable and non-allowable defects further in the catalog.

GRADE BB SVEZA PLYWOOD SHEET SAMPLE



The picture shows a sample image of SVEZA grade BB plywood.
See the detailed grade description with a full list of allowable and non-allowable defects further in the catalog.

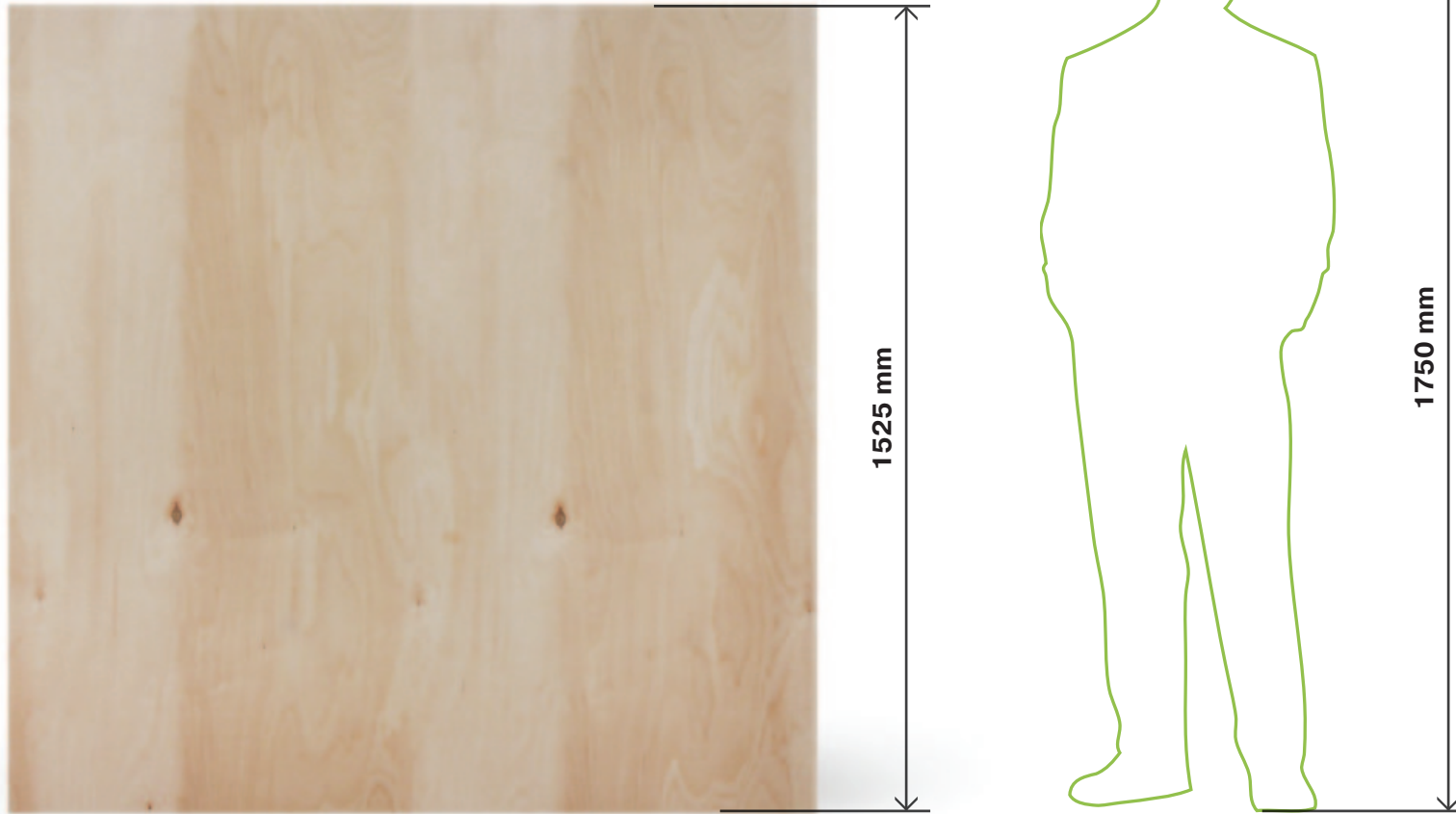


GRADE BB SVEZA PLYWOOD SHEET SAMPLE



The picture shows a sample image of SVEZA grade BB plywood.
See the detailed grade description with a full list of allowable and non-allowable defects further in the catalog.

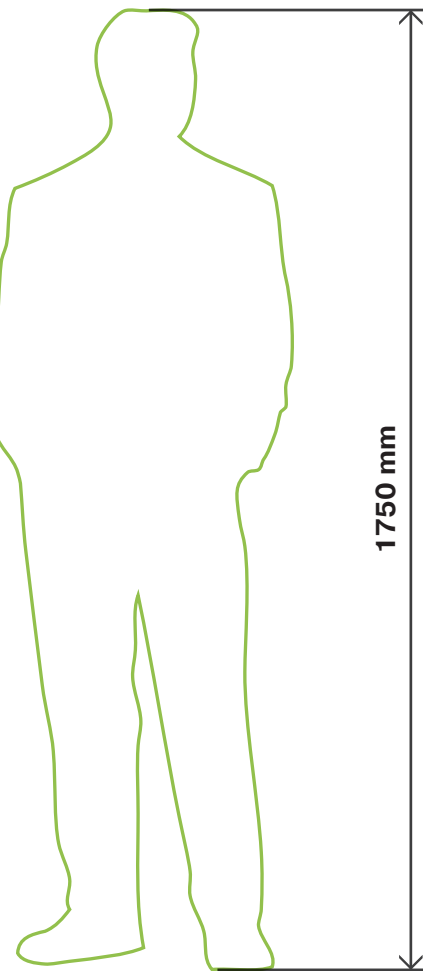
GRADE CP SVEZA PLYWOOD SHEET SAMPLE



The picture shows a sample image of SVEZA grade CP plywood.
See the detailed grade description with a full list of allowable and non-allowable defects further in the catalog.

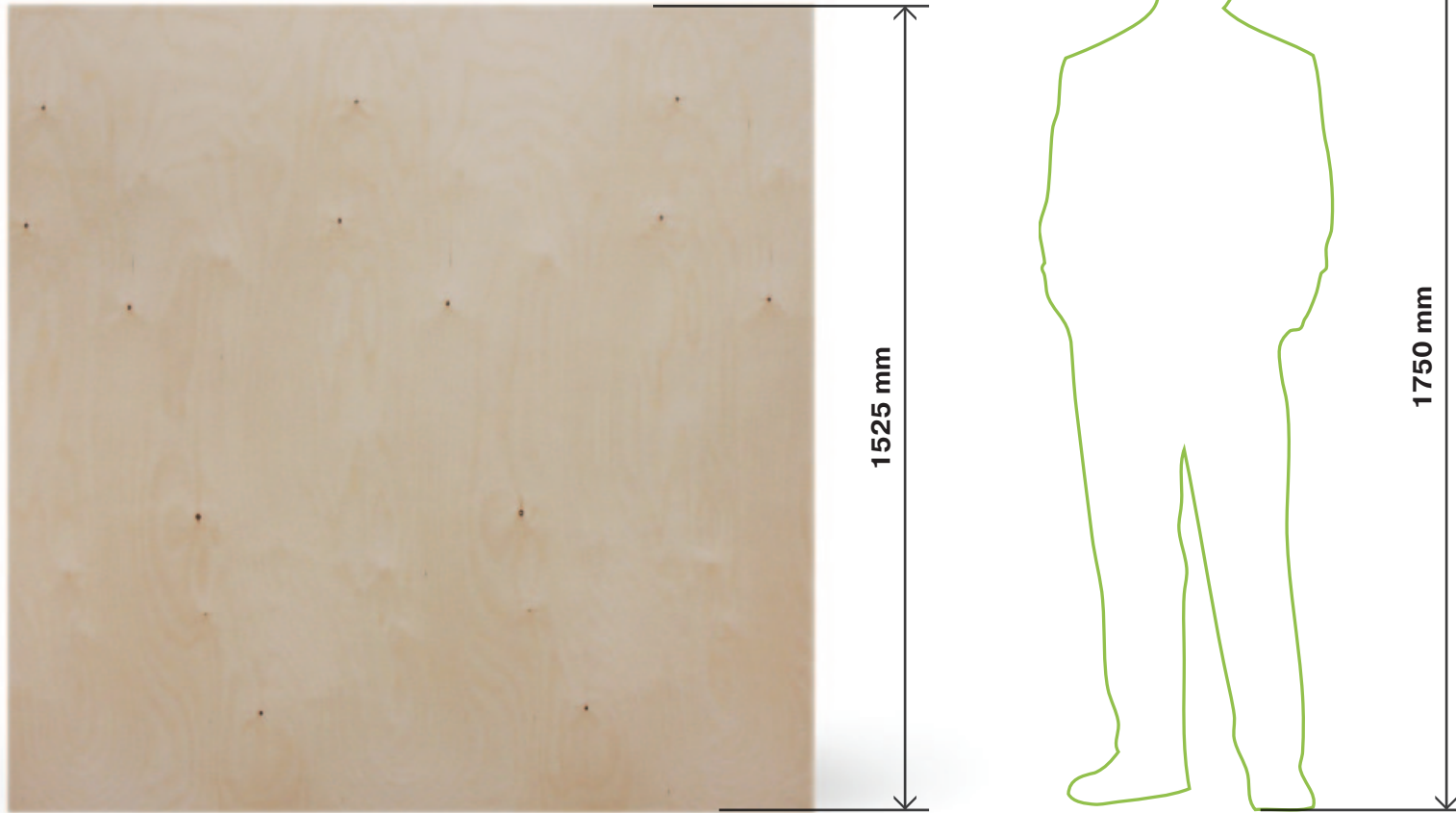


GRADE CP SVEZA PLYWOOD SHEET SAMPLE



The picture shows a sample image of SVEZA grade CP plywood.
See the detailed grade description with a full list of allowable and non-allowable defects further in the catalog.

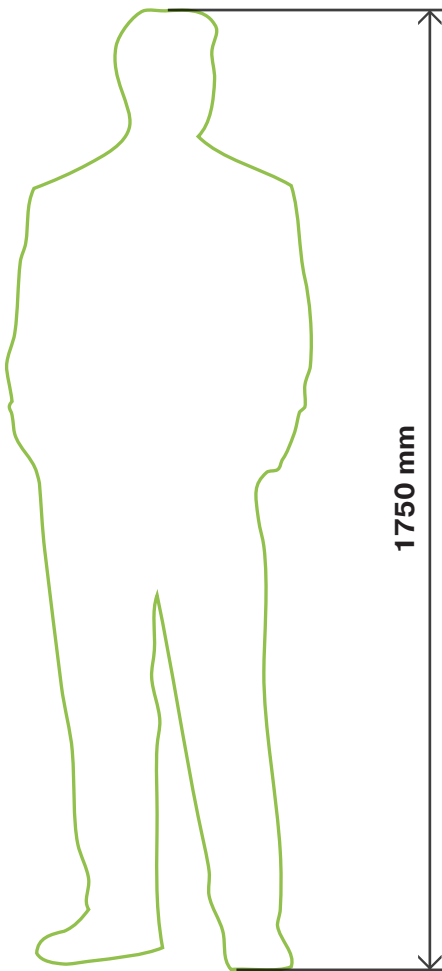
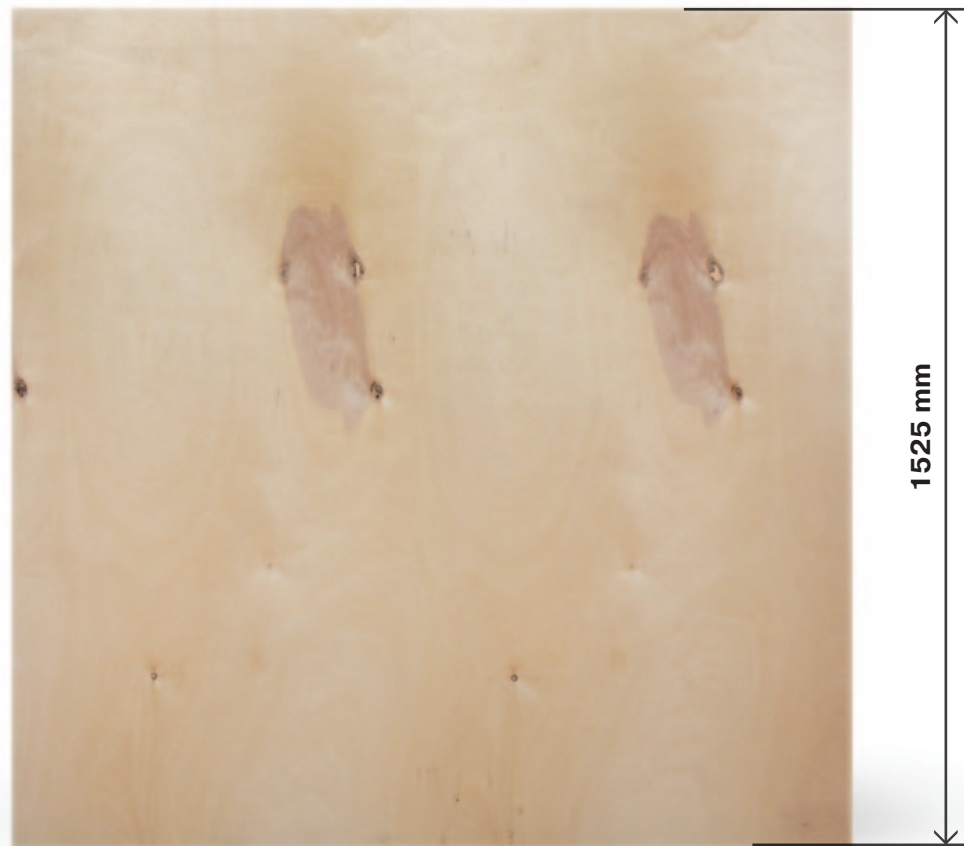
GRADE CP SVEZA PLYWOOD SHEET SAMPLE



The picture shows a sample image of SVEZA grade CP plywood.
See the detailed grade description with a full list of allowable and non-allowable defects further in the catalog.

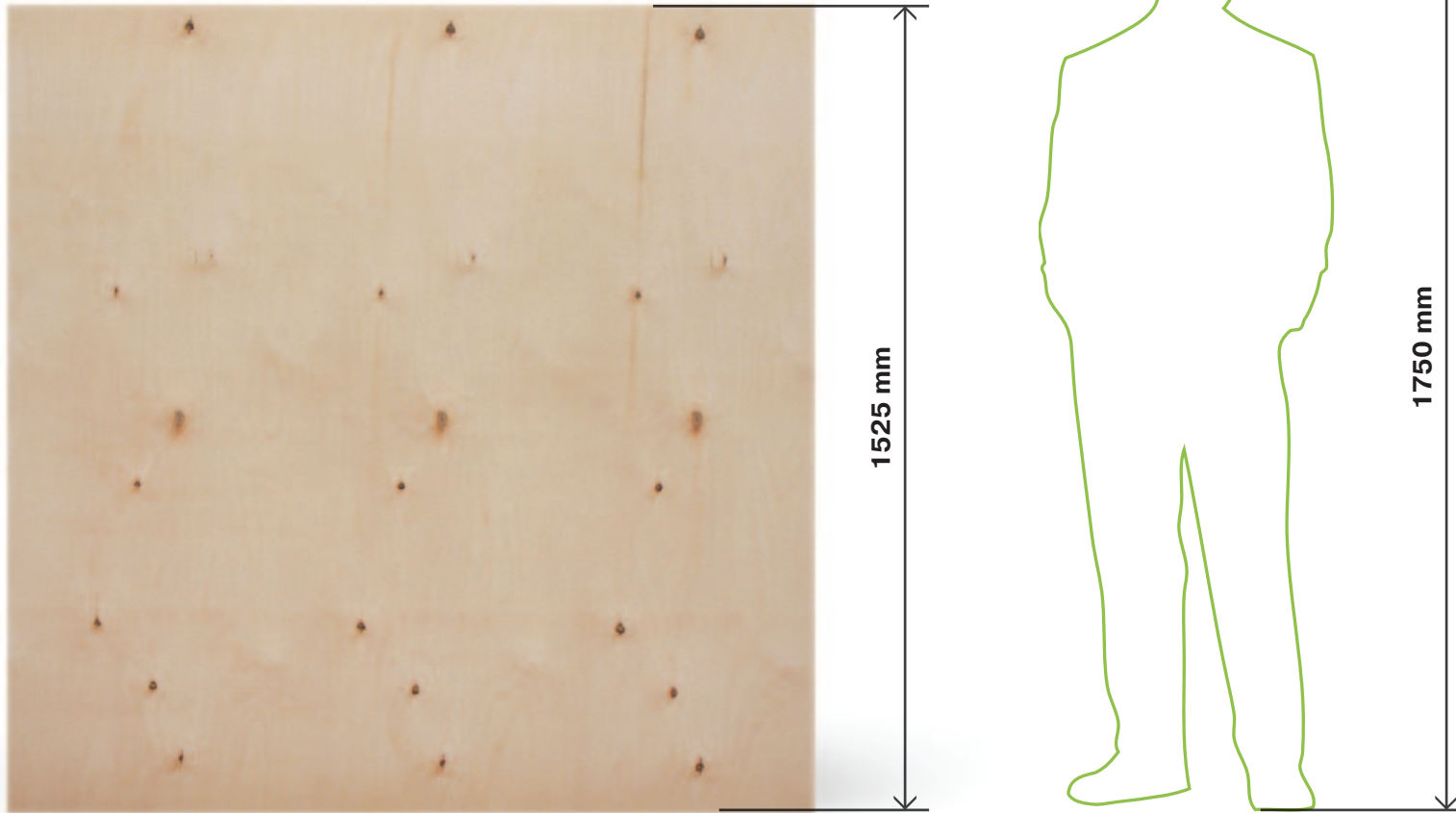


GRADE C SVEZA PLYWOOD SHEET SAMPLE



The picture shows a sample image of SVEZA grade C plywood.
See the detailed grade description with a full list of allowable and non-allowable defects further in the catalog.

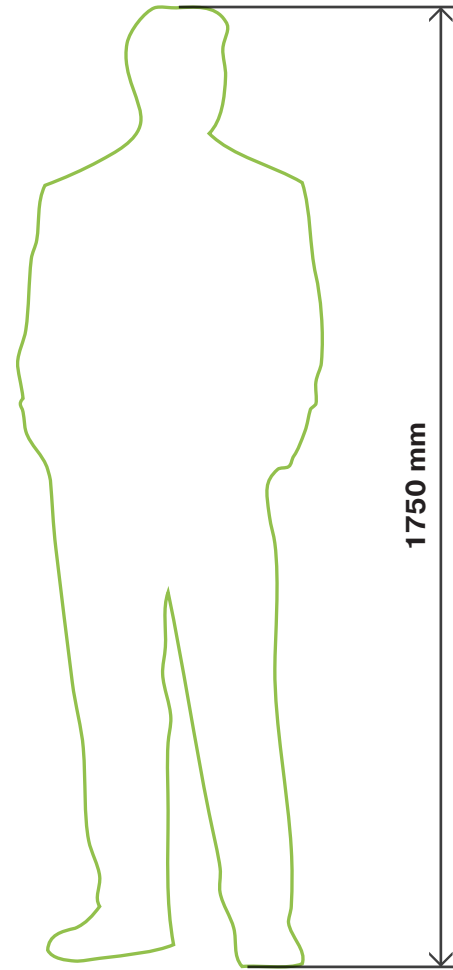
GRADE C SVEZA PLYWOOD SHEET SAMPLE



The picture shows a sample image of SVEZA grade C plywood.
See the detailed grade description with a full list of allowable and non-allowable defects further in the catalog.

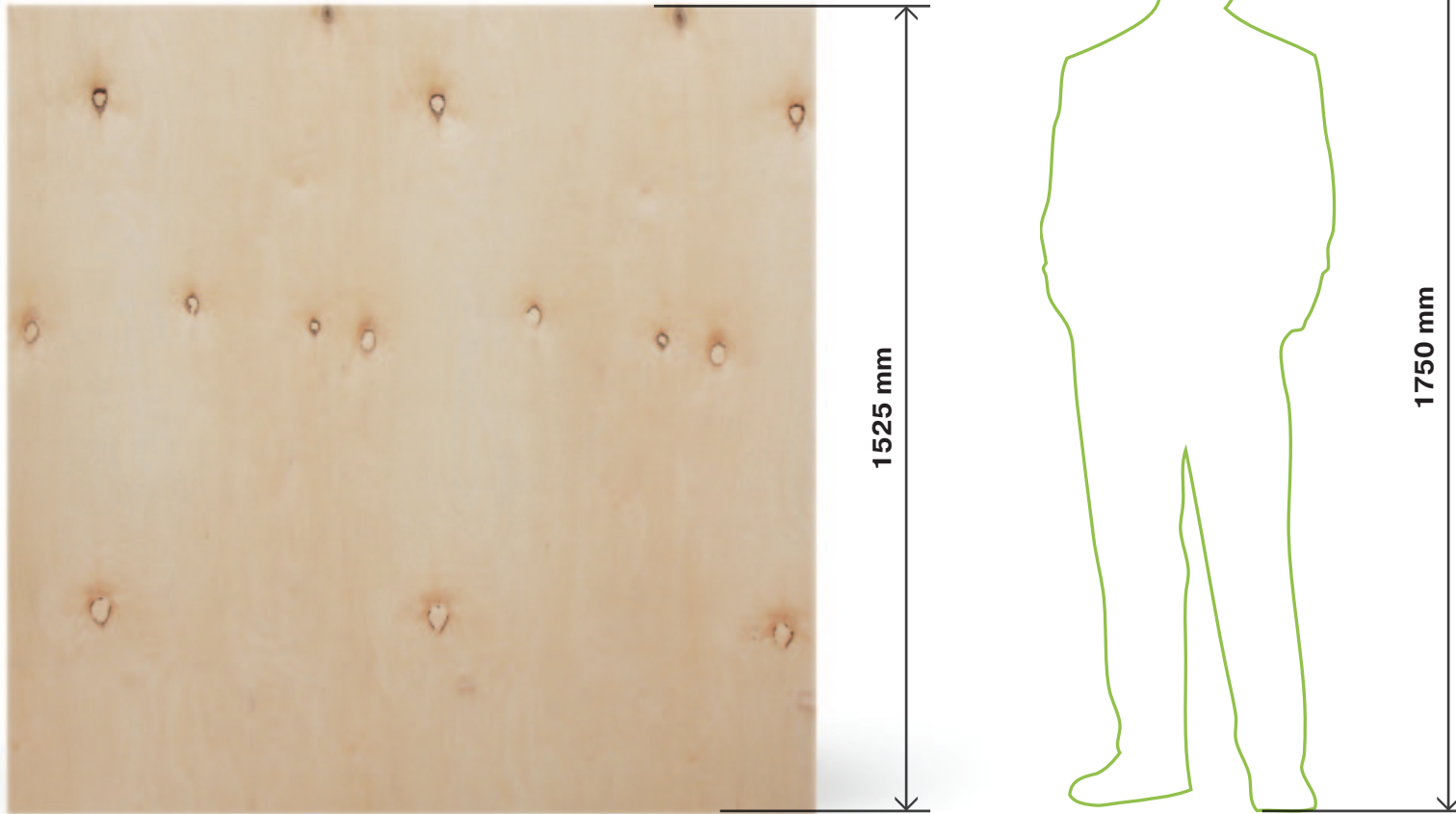


GRADE C SVEZA PLYWOOD SHEET SAMPLE



The picture shows a sample image of SVEZA grade C plywood.
See the detailed grade description with a full list of allowable and non-allowable defects further in the catalog.

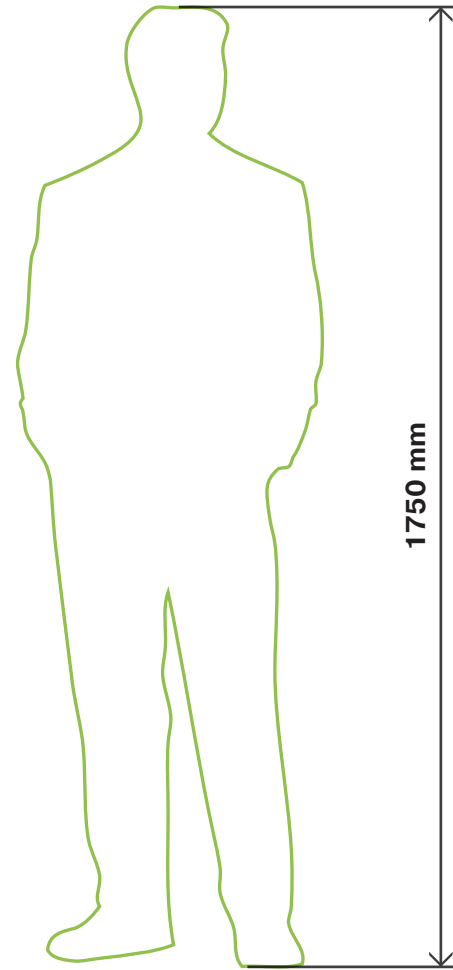
GRADE C SVEZA PLYWOOD SHEET SAMPLE



The picture shows a sample image of SVEZA grade C plywood.
See the detailed grade description with a full list of allowable and non-allowable defects further in the catalog.



GRADE C SVEZA PLYWOOD SHEET SAMPLE



The picture shows a sample image of SVEZA grade C plywood.
See the detailed grade description with a full list of allowable and non-allowable defects further in the catalog.

SVEZA PLYWOOD GRADES DESCRIPTION ACCORDING TO STO 00255177-001-2013

FLAWS IN WOOD AND PROCESSING DEFECTS	B Sel (I)	S Sel (I)	B (I)	S (I)	BBx (II)	BB (II)	CP (III)	WGE (III)	WG (III)	C (IV)	CC (IV)
1. Pin knots	Allowed										
2. Knots: sound, intergrown, light and dark	Not allowed	Allowed: up to 15 mm in diameter, with a shake up to 0.5 mm wide, 5 pc/m ²	Allowed: up to 15 mm, with a shake up to 0.5 mm wide, 5 pc/m ²	Allowed: up to 25 mm in diameter, with a shake up to 1 mm 10 pc/m ²	Allowed: with a shake up to 1 mm wide	Allowed					
3. Partially intergrown knots	Allowed with size and amount according to Item 4 hereby			Allowed within the total amount of intergrown knots up to 15 mm in diameter, 10 pc/m ²			Allowed: up to 40 mm in diameter, no amount restriction	Allowed: up to 70 mm in diameter, no amount restriction			
4. Black knots, loose knots, knot holes (no bark inclusions)	Allowed: up to 6 mm in diameter, 2 pc/m ²	Allowed within the total amount of intergrown knots up to 6 mm in diameter, 3 pc/m ²			Allowed: up to 6 mm in diameter, no amount restriction	Allowed: up to 15 mm in diameter, 7 pc/m ²	Allowed: up to 40 mm in diameter, no amount restriction (bark patches up to 5 mm wide around the knot are allowed)	Allowed: up to 70 mm in diameter, no amount restriction (bark patches up to 5 mm wide around the knot are allowed)			
5. Close shakes	Allowed: up to 200 mm long, 2 pc/m of the sheet's width	Allowed: up to 200 mm long, 5 pc/m of the sheet's width	Allowed: up to 300 mm long, 5 pc/m of sheet width	Allowed: marginal and medial							





FLAWS IN WOOD AND PROCESSING DEFECTS	B Sel (I)	S Sel (I)	B (I)	S (I)	BBx (II)	BB (II)	CP (III)	WGE (III)	WG (III)	C (IV)	CC (IV)
6. Open shakes, open splits in spliced veneer	Not allowed	Allowed: up to 200 mm long, up to 1 mm wide, 2 pc/m of the sheet's width	Not allowed	Allowed: up to 200 mm long, up to 1 mm wide, 2 pc/m of the sheet's width	Allowed: up to 200 mm long, up to 2 mm wide, 3 pc/m of the sheet's width	Allowed: up to 250 mm long, up to 2 mm wide, 3 pc/m of the sheet's width	Allowed: up to 600 mm long, up to 2 mm wide, 2 pc/m of the sheet's width + allowed up to 600 mm long, up to 5 mm wide if sealed with putty	Allowed: up to 600 mm long, up to 2 mm wide, 2 pc/m of the sheet's width + allowed up to 600 mm long, up to 5 mm wide if sealed with putty	Allowed: up to 600 mm long, up to 5 mm wide, 2 pc/m of the sheet's width	Allowed: up to 800 mm long, up to 10 mm wide, no amount restriction	Allowed: up to 15 mm wide, no amount restriction
7. Timber structure flaws (diagonal grain, swirly grain, burls, bud traces)	Allowed, except for dark bud traces		Allowed								
8. Flaws in wood (inner inbark, light and dark)	Light inbark only is allowed, the dark one is allowed under size and amount requirements for black knots				Light inbark is allowed, the dark one is allowed under size requirements for intergrown knots						
9. Flaws in wood (open inbarks)	Allowed, within the total amount under the black knot requirements										

FLAWS IN WOOD AND PROCESSING DEFECTS	B Sel (I)	S Sel (I)	B (I)	S (I)	BBx (II)	BB (II)	CP (III)	WGE (III)	WG (III)	C (IV)	CC (IV)
10. Sound discoloration (false heartwood)	Not allowed				Allowed: up to 25% of the sheet surface		Allowed: up to 75% of the sheet surface			Allowed	
11. Sound discoloration (streaks, streak traces)	Allowed: up to 100 mm long, up to 2 mm wide, 3 pc/m ²	Allowed: up to 175 mm long, up to 2 mm wide, 3 pc/m ²	Allowed: light up to 175 mm long, up to 4 mm wide, 3 pc/m ²	Allowed: light up to 175 mm long, up to 4 mm wide, 5 pc/m ²	Allowed: up to 250 mm long, up to 10 mm wide, 10 pc/m ²		Allowed				
12. Sound discoloration (congested streaks)	Not allowed	Allowed: light-colored, up to 30x30 mm, 1 pc/m ²			Allowed: 60x40 mm, 1 pc/m ²		Allowed				
13. Mineral streaks, sap stains (blue, colored sap stains), wood discoloration during storage	Not allowed	Allowed: up to 5% of the sheet surface	Allowed: up to 30% of the sheet surface		Allowed: up to 50% of the sheet surface (together with false heartwood)		Allowed: up to 75% of the sheet surface (together with false heartwood)			Allowed	
14. Biological damage (wormholes)	Allowed within the total amount under the black knot requirements										



0 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 2

FLAWS IN WOOD AND PROCESSING DEFECTS	B Sel (I)	S Sel (I)	B (I)	S (I)	BBx (II)	BB (III)	CP (III)	WGE (III)	WG (III)	C (IV)	CC (IV)
15. Discoloration with partial wood damage	Not allowed										Allowed as separate stripes up to 30 mm wide, up to 200 mm long, 2 pc/m of the sheet's length
16. Knotting and patching with wooden inserts	Not allowed	Allowed: 1 pc/m ²	Not allowed	Allowed: up to 1 pc/m ²	Not allowed	Allowed: up to 8 pc/m ²	Allowed with a gap up to 1 mm at one side (or up to 0.5 mm at both sides)	Allowed with a gap up to 1 mm at one side (or up to 0.5 mm at both sides)	Allowed		
17. Double patch	Not allowed					Allowed: up to 1 pc/m ²	Allowed				
18. Shake filling Note: Shake filling with patches or putty is subject to agreement with the customer	Not allowed					Shakes wider than 2 mm must be filled with glued veneer patches	Shakes wider than 5 mm must be filled with glued veneer patches	Shakes wider than 5 mm must be filled with glued veneer patches		Allowed	
19. Overlap ridges (telegraphing overlaps)	Not allowed				Allowed: up to 200 mm long, up to 10 mm wide, 3 pc/sheet		Allowed: up to 600 mm long, up to 10 mm wide, 5 pc/sheet		Allowed: up to 10 mm wide	Allowed	

FLAWS IN WOOD AND PROCESSING DEFECTS	B Sel (I)	S Sel (I)	B (I)	S (I)	BBx (II)	BB (II)	CP (III)	WGE (III)	WG (III)	C (IV)	CC (IV)
20. Overlap	Not allowed				Allowed: up to 100 mm long, up to 2 mm wide, 1 pc/m of the sheet's width		Allowed: up to 300 mm long, up to 2 mm wide, 2 pc/m of the sheet's width		Allowed: up to 600 mm long, up to 4 mm wide, 2 pc/m of the sheet's width	Allowed	
21. Manufacturing stains (beam traces, lines)	Not allowed				Allowed: up to 10% of sheets per bundle		Allowed				
22. Glue stain	Not allowed			Allowed: up to 1% of the sheet surface	Allowed: up to 2% of the sheet surface (3 to 21 mm thick plywood) Allowed: up to 5% of the sheet surface (24 mm thick and more)		Allowed: up to 5% of the sheet surface (3 to 21 mm thick plywood) Allowed: up to 10% of the sheet surface (24 mm thick and more)		Allowed: up to 5% of the sheet surface (3 to 21 mm thick plywood), up to 10% of the sheet surface (24 mm thick and more)	Allowed	
23. Mechanical defects (pinholes, saw cuts)	Allowed within the total amount under the black knot requirements										
24. Scratches, grooves, pimples, ridges	Not allowed						Allowed: up to 0.5 mm deep, up to 120 mm long, up to 10 mm wide	Allowed: up to 0.5 mm deep, up to 120 mm long, up to 10 mm wide	Allowed: up to 120 mm long	Allowed	



FLAWS IN WOOD AND PROCESSING DEFECTS	B Sel (I)	S Sel (I)	B (I)	S (I)	BBx (II)	BB (II)	CP (III)	WGE (III)	WG (III)	C (IV)	CC (IV)
25. Warping	Ignored in plywood up to 6.5 mm thick, allowed in plywood over 6.5 mm thick; Allowed up to 10 mm/m of the plywood sheet's diagonal length	Ignored in plywood up to 6.5 mm thick, allowed in plywood over 6.5 mm thick; Allowed up to 15 mm/m of the plywood sheet's diagonal length									
26. Adhesive thread occurrence	Not allowed						Allowed				
27. Blisters, delamination, bark patches	Not allowed										
28. Sander skips (uneven sanding)	Not allowed			Allowed: up to 5 mm off the edge			Allowed: up to 5% of the sheet surface			Allowed: up to 50% of the sheet surface	Allowed
29. Face veneer oversanding	Not allowed						Allowed: up to 1% of the sheet surface (3 to 21 mm thick plywood) Allowed: up to 2% of the sheet surface (24 mm thick and more)			Allowed: up to 5% of the sheet surface	
30. Metal inclusions	Not allowed						Allowed: nonferrous metal staples				
31. Edge defects caused by sanding, cutting (fringe), veneer shortage	Not allowed			Allowed: up to 5 mm wide along the edge						Allowed: up to 10 mm wide	Allowed: up to 25 mm wide

FLAWS IN WOOD AND PROCESSING DEFECTS	B Sel (I)	S Sel (I)	B (I)	S (I)	BBx (II)	BB (II)	CP (III)	WGE (III)	WG (III)	C (IV)	CC (IV)
32. Coarse peeling	Not allowed				Allowed: up to 5% of the sheet surface		Allowed: up to 15% of the sheet surface			Allowed	
33. Waviness (sanded plywood), rough saw cut, ripple	Not allowed						Allowed				
34. Rough surface	R _m roughness value according to GOST 7016, in μm, max: 100 for sanded plywood, 200 for unsanded plywood										
35. Pockets (without bark inclusions)	Not allowed				Allowed within congested streaks size (60x40 mm), 1 pc/m ²		Allowed				
36. Pasted veneer chips	Not allowed						Allowed: up to 150 mm long, up to 30 mm wide, 1 pc/sheet			Allowed	

NOTES

0
1
2
3
4
5
6
7
8
9
10
11
12
13
14
15
16
17
18
19
20
21
22

NOTES

0 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 2



The world leader in birch plywood
production

www.sveza.com

SVEZA © 01. 10. 2015