



National Standards Authority of Ireland

IRISH STANDARD

I.S. EN 635-5:1999

ICS 79.060.10

**PLYWOOD - CLASSIFICATION BY SURFACE  
APPEARANCE - PART 5: METHODS FOR  
MEASURING AND EXPRESSING  
CHARACTERISTICS AND DEFECTS**

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EUROPEAN STANDARD  
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**EN 635-5**

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English version

**Plywood - Classification by surface appearance - Part 5:  
Methods for measuring and expressing characteristics and  
defects**

Contreplaqué - Classification selon l'aspect des faces -  
Partie 5: Méthodes de mesure et d'expression des  
caractéristiques et des défauts

Sperrholz - Klassifizierung nach dem Aussehen der  
Oberfläche - Teil 5: Meßverfahren und Angabe der  
Merkmale und Fehler

This European Standard was approved by CEN on 3 March 1999.

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COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

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### Foreword

This European Standard has been prepared by Technical Committee CEN/TC 112 "Wood-based panels", the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by September 1999, and conflicting national standards shall be withdrawn at the latest by September 1999.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

This Standard is one of a series of standards for the classification of plywood by surface appearance.

## 1 Scope

This European Standard specifies the methods for measuring and expressing:

- some inherent characteristics of wood, and
- some defects that come from the manufacturing process

which are used for the classification of the appearance of plywood surfaces according to EN 635-1, EN 635-2 and EN 635-3.

## 2 Normative references

This European Standard incorporates, by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references, the latest edition of the publication referred to applies.

EN 313-2

Plywood – Classification and terminology – Part 2: Terminology

EN 326-1

Wood-based panels – Sampling, cutting and inspection – Part 1: Sampling and cutting of test pieces and expression of test results

EN 635-1

Plywood – Classification by surface appearance – Part 1: General

EN 635-2

Plywood – Classification by surface appearance – Part 2: Hardwood

EN 635-3

Plywood – Classification by surface appearance – Part 3: Softwood

## 3 Definitions

For the purposes of this standard the definitions of EN 313-2 and EN 635-1 apply.

## 4 Measurements

For the purpose of determining the appearance class of plywood according to EN 635-1, EN 635-2 and EN 635-3, the following characteristics inherent in wood (see table 1) and manufacturing defects (see table 2) shall be measured for each surface classified, according to the methods described in clause 6 of this standard.

**Table 1: Measurements required to classify the characteristics inherent in wood of plywood surfaces**

Category of characteristics	Reference EN 635-2 : 1995 EN 635-3 : 1995	Number	Size			
			Dia- meter	Length	Width	Area
Pin knots	3.2.1.1	X				
Sound intergrown knots	3.2.1.2	X	X			
Unsound or non-adhering knots and knots holes	3.2.1.3	X	X			
Open splits	3.2.1.4	X		X	X	
Abnormalities due to insects and marine borers	3.2.1.5	X	X	X	X	
Resin pockets and inbark	3.2.1.6				X	
Irregularities in the structure of the wood, e.g. roughness	3.2.1.7					X
Discolouration which is not wood destroying	3.2.1.8					X

**Table 2: Measurements required to classify the manufacturing defects on plywood surfaces**

Category of defects	Reference EN 635-2 : 1995 EN 635-3 : 1995	Number	Size			
			Dia- meter	Length	Width	Area
Open joints	3.2.2.1	X			X	
Overlaps	3.2.2.2	X		X		
Hollows, imprints and bumps	3.2.2.4					X
Roughness, other than that due to irregularities in the structure of the wood	3.2.2.5					X
Sanding through	3.2.2.6					X
Glue penetration	3.2.2.7					X
Repairs	3.2.2.9	X				
Defects at the edges of the panel due to sanding or sawing	3.2.2.10				X	

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