



## **CORPORATE STANDARD**

# **BIRCH PLYWOOD SVEZA PARQUET Technical Specifications**

**STO 52654419-002-2018**

Saint Petersburg  
2018

## Preface

Development purposes and objectives, as well as the use of corporate standards in the Russian Federation are stated by Federal Law 184-FZ *On Technical Regulation* of December 27, 2002 and Federal Law of June 29, 2015.

No. 162-FZ *On Standardization in the Russian Federation*.

Development and execution rules are stated by GOST R 1.0-2012 *Standardization in the Russian Federation. General provisions* and GOST R 1.4-2004 *Standardization in the Russian Federation. Corporate Standards. General Provisions*, subject to GOST R 1.5-2012, *Standardization in the Russian Federation. National standards. Regulations on arrangement, representation, execution, and designation*.

### Information on Standard

1 DEVELOPED AND INTRODUCED by SVEZA Forest, a limited liability company

2 APPROVED AND ENACTED by order of the General Director of OOO SVEZA Forest dated \_\_\_\_\_ 20\_\_\_. No. \_\_\_\_\_

3 APPROVED by OOO SVEZA Forest Sales and Marketing Director R.A. Muzyka \_\_\_\_\_, \_\_\_\_\_ 20 \_\_\_\_

4. FIRST RELEASE

5. THE EXPERT CONCLUSION, dated 26.04.2018, HAS BEEN RECEIVED from E.Yu. Tretyakova, Expert in the confirmation of the conformity of woodworking industry products, Head of the Fantest NP Certification Body, and member of Technical Committee on Standardization TK 121.

This standard may only be used for work with the written consent of OOO SVEZA Forest.

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## CORPORATE STANDARD

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### **BIRCH PLYWOOD SVEZA PARQUET Technical Specifications**

### **BIRCH PLYWOOD SVEZA PARQUET Technical Requirements**

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Effective since \_\_\_\_\_, 20\_\_

#### **1 SCOPE**

This standard covers SVEZA PARQUET birch plywood used as the main or auxiliary component in the production of parquet strips or engineered wood with subsequent usage as the flooring material in residential and public spaces.

#### **2 REGULATORY REFERENCES**

This standard hereby includes regulatory references to the following standards:  
GOST 12.4.011-89 Occupational safety standards system. Protective equipment for workers. General requirements and classification.

GOST 427-75 Metal rulers. Technical Specifications

GOST 2140-81 Visible defects of wood. Classification, terms and definitions, methods of measurement

GOST 3749-77 90° L-squares. Specifications

GOST 6507-90 Micrometers. Specifications

GOST 7016-2013 Products of wood and wooden materials. Surface roughness parameters

GOST 7502-98 Metal measuring tapes. Specifications

GOST 8925-68 Feeler gauges for machine tool accessories. Design

GOST 9620-94 Glued laminated timber. Sampling and general requirements for testing

GOST 9621-72 Glued laminated timber. Methods for determination of physical properties

GOST 9624-2009 Glued laminated timber. Methods for determination of shear strength

GOST 9625-2013 Glued laminated timber. Methods for determination of tensile strength and modulus of elasticity in static bending.

GOST 11358-89 Dial-type thickness gauges and dial-type wall thickness gauges graduated in 0.01 and 0.1 mm. Technical Specifications

GOST 15612-2013 Products of wood and wood materials. Methods for determination of surface roughness parameters

GOST 18321-73 Statistical quality control. Random sampling methods for piece goods

GOST 27678-2014 Wood panels and plywood. Perforation method for determination of formaldehyde content.

GOST 30255-2014 Furniture, wood, and polymer materials. The method for determination of formaldehyde and other harmful volatile chemicals in climate chambers

GOST 30427-96 General purpose plywood. General rules for classification by appearance

GOST 32155-2013 Wood panels and plywood. Determination of formaldehyde emissions by gas analysis method

Note: When using this standard it is advisable to check the validity of the standards referenced against the National Standards reference index.

### **3 CLASSIFICATION AND DIMENSIONS**

3.1 SVEZA PARQUET plywood is classified according to the glue joint water resistance as EXT/FSF, or plywood of increased water resistance of the glue joint, glued using phenol-formaldehyde adhesives; it is intended for indoor and outdoor usage.

3.2 SVEZA PARQUET plywood could be of the two following types depending on the requirements applicable to the inner layers: SVEZA PARQUET Standard (PST) and SVEZA PARQUET Premium (PPR).

3.3 SVEZA PARQUET Standard Plywood falls into two grades according to the combination of its face veneer grades: CP, C, (Latin letters) and III, IV (Roman numerals).

SVEZA PARQUET Premium Plywood falls into two grades according to the combination of its face veneer grades: BB, CP, (Latin letters) and I, II, III (Roman numerals).

The grade designator is indicated by both Latin letters and Roman numerals.

3.4 As for surface machining, SVEZA Parquet plywood is available sanded on both sides — S2S / Sh2.

3.5 Please refer to Appendix E for the Packing assembly scheme for SVEZA PARQUET Premium plywood.

#### **3.6 Dimensions**

3.6.1 Length and width of SVEZA PARQUET sheets must be as shown in Table 1 below.

Table 1

In millimeters

Length (width) of plywood sheet	Maximum deviation
1220; 1250	±3.0
1500; 1525	±4.0
2440; 2500	±4.0
3000; 3050	±5.0

Note:

1. SVEZA PARQUET plywood may be produced with other dimensions and maximum deviations by agreement between the manufacturer and the customer
2. The SVEZA PARQUET plywood sheet length is measured along the grain of the face veneers.

3.6.2 Thickness and number of plies of SVEZA PARQUET plywood must be as shown in Table 2 below.

Table 2

Nominal plywood thickness	Minimum thickness (mm)	Maximum thickness (mm)	Maximum deviation (mm)	Thickness variation in one sheet, maximum (mm)	Number of plies, minimum
5.9	5.7	6.1	±0.2	0.2	5
6.0	5.8	6.2			5
6.5	6.3	6.7			5
8.0	7.8	8.2			7
9.0	8.8	9.2			7
9.1	8.9	9.3			7
10.0	9.8	10.2			7
12.0	11.8	12.2			9
12.7	12.5	12.9			9
14.9	14.7	15.1			11
15.0	14.8	15.2			11

Note - SVEZA PARQUET plywood is permitted to be produced with other thicknesses, number of layers, and maximum deviations by agreement between the manufacturer and the customer

3.6.3 SVEZA PARQUET plywood sheets must be cut square.

Out-of-squareness must not exceed 2 mm per 1 m of the sheet edge length, when measured as per section 6.4.1.

The difference in the diagonal lengths must not exceed 2 mm per 1 m of sheet edge length, when measured as per section 6.4.2.

3.6.4 Out-of-straightness for the edges must not exceed 2 mm per 1 m of sheet length.

3.7 SVEZA PARQUET plywood marking must include the following information:

- product designation with wood species specified;
- grade;
- type and combination of face veneer grades (using Latin letters and Roman numerals);
- emission class;
- surface treatment type;
- dimensions;
- this Standard number.

Example of identification marking for birch plywood SVEZA PARQUET Premium type EXT/FSF with a combination of face veneer grades BB/CP (II/III), emission class E1, both sides sanded, 1,525 mm length, 1,525 mm width, 10 mm thickness:

*Фанера SVEZA PARQUET березовая / Birch Plywood SVEZA PARQUET,  
EXT / FSF, PPR BB/CP (II/III), E1, S2S / III2, 1525 x 1525 x 10  
STO 52654419-002-2018*

## 4 TECHNICAL REQUIREMENTS

### 4.1 Characteristics

4.1.1 Birch veneer is used for core and face plies of SVEZA PARQUET plywood.

Veneer thickness in the external and inner plies of SVEZA PARQUET plywood shall not exceed 2.0 mm.

Minimum thickness of face plies after sanding shall be not less than half the initial thickness of the face ply.

4.1.2 Wood flaws and processing defects that exceed the limits specified in Appendix A are not allowed in face veneers of the SVEZA PARQUET plywood. Terms and definitions of wood flaws and processing defects are as per GOST 30427 and Appendix B.

4.1.3 Wood flaws and processing defects that exceed the limits specified in Appendix C are not allowed in core plies of SVEZA PARQUET Premium plywood.

4.1.4 Cavities at the edges of SVEZA PARQUET Premium plywood caused by core veneer defects such as crevices or knots, are allowed within the limits suggested in the Appendix C for related defects.

Cavities at the outer edges of SVEZA PARQUET Premium plywood caused by any other defect (not mentioned in Appendix C) shall be not more than 5 mm in depth in one ply.

4.1.5 SVEZA PARQUET plywood, depending on the quality of face veneers, is manufactured with grade compositions as follows:

- SVEZA PARQUET Premium plywood - BB/BB, BB/CP and CP/CP grades;

— SVEZA PARQUET Standard plywood - CP/CP and CP/C grades.

4.2 Formaldehyde content in the plywood and formaldehyde emission from SVEZA PARQUET plywood into the room air must comply with the value specified in Table 3.

Table 3

Emission class	Formaldehyde content per 100 grams of absolutely dry weight of plywood (mg)	Formaldehyde emission	
		Chamber method (mg/m <sup>3</sup> of air)	Gas analysis method (mg/m <sup>2</sup> ·h)
E1	Up to 8.0 inclusively	Up to 0.124	Up to 3.5 inclusive, or less than 5.0 at 3 days after manufacturing

4.3 Physical and mechanical performance of SVEZA PARQUET plywood is specified in Table 4.

Table 4

Parameter	Thickness (mm)	Physical and mechanical parameter values
1 Moisture (%)	5.9–15	5–9
2 Shear strength for shearing through adhesive layer (MPa) min	5.9–15	1.0
3 Static bending strength: — along the grain of face plies (MPa), min — across the grain of face plies (MPa), min	9–15	60 30
4 Modulus of elasticity in static bending: — along the grain (MPa), min — across the grain (MPa), min	9–15	6000 3000



Table 4 (end)

Parameter	Thick- ness (mm)	Physical and mechani- cal parameter values
5 Tensile strength perpendicular to the bonding plane (MPa), min — SVEZA PARQUET Standard plywood — SVEZA PARQUET Premium plywood	5.9–15	not regulated 1.75
<p>Note:</p> <ol style="list-style-type: none"> <li>1. Indicated moisture limits must be complied with when shipping the SVEZA PARQUET plywood from the manufacturer's warehouse</li> <li>2. Adhesive layer shear test must be performed in various layers of adhesive as per agreement between the manufacturer and customer</li> <li>3. SVEZA PARQUET plywood samples preparation procedure for adhesive layer cleaving test is as follows: <ul style="list-style-type: none"> <li>— soaking in water at <math>(20 \pm 3)</math> °C for 24 hours,</li> <li>— boiling in water for 4 hours,</li> <li>— drying in a vented cabinet for (16–20) hours,</li> <li>— second boiling in water for 4 hours;</li> <li>— cooling in water for 1 hour.</li> </ul> </li> <li>4. Percentage of destruction in wood is not determined</li> </ol>		

4.4 SVEZA PARQUET plywood stock is taken in cubic meters. One sheet's volume is calculated without regard to rounding. The volume of assembled SVEZA PARQUE plywood stacks and batches is calculated with accuracy of  $0.001 \text{ m}^3$ . The area of a single SVEZA PARQUET plywood sheet is calculated with accuracy of  $0.01 \text{ m}^2$ , and the area of the sheets in a batch with accuracy of  $0.5 \text{ m}^2$ .

4.5 Marking is applied using indelible black or purple ink on the edge of each SVEZA PARQUE plywood sheet as a stamp or text without margins. Marking must include the following information:

- plywood type,
- plywood grade,
- manufacturer (number or name);
- thickness and/or sorter number.

Flat face must not be stamped.

Edge stamp is placed in the corner of the transverse or longitudinal edge.

For the SVEZA PARQUET plywood with a thickness of 5.9-9 mm the stamp may be placed once for each (1-3) sheet.

Allowable by agreement between the manufacturer and the customer:

- to not mark SVEZA PARQUET plywood sheets;
- to not include additional information in the mandatory marking.

#### 4.6 Packing of SVEZA PARQUET plywood

The SVEZA PARQUET plywood must be packed in 400, 600 or 900 mm high stacks according to type, grade, size and thickness.

By agreement between the manufacturer and the customer, the SVEZA PARQUET plywood may be packed in stacks of height other than that specified.

The SVEZA PARQUET plywood in the stack must be stacked with the grain running in the same direction.

The SVEZA PARQUET plywood in the stack must be placed so that the higher grade must face the top.

#### 4.7 Packing and labeling of ready stacks of SVEZA PARQUET plywood

4.7.1 Packing of the plywood stacks shall ensure their integrity and preserve the stacks during transportation.

Main packing methods and types are regulated by OOO SVEZA Forest. Other types and methods of plywood packing may be used by agreement between the manufacturer and the customer.

4.7.2 Marking of packed plywood stacks shall be performed with labels. The label text shall be in Russian and/or English, placed on two parallel or perpendicular side strips. Both labels shall bear the same information:

- trademark;
- product designation - Birch Plywood SVEZA PARQUET / Фанера SVEZA PARQUET березовая;
- dimensions, plywood thickness and thickness tolerance value (if required);
- plywood type and grade as per Appendix D;
- plywood type (EXT/FSF);
- type of machining used for the plywood face;
- number of sheets in a stack;
- working shift;
- plywood production date;
- emission class;
- order No. as per Special Terms and Conditions (by agreement with the customer);
- reference document governing plywood manufacture;
- manufacturer name and address;
- certification signs and quality control marks;
- handling signs: “Keep Dry” and “Use No Hooks”;
- barcode (if a data collection terminal (scanner) is available).

For more streamlined storage operations, additional marking may be applied using labels or stencils.

## 5 ACCEPTANCE REQUIREMENTS

5.1 SVEZA PARQUET plywood must be accepted in lots.

Lot means a certain number of plywood sheets of the same type, grade and size.

For each lot, a single supporting document has to be issued, containing the following information:

- trademark;
- manufacturer name and address;
- plywood mark;
- lot size;
- name of the process standard to which the plywood must comply.

5.2 The quality and dimensions of SVEZA PARQUET plywood sheets shall be verified by means of selective sampling and testing. In sampling inspection, sheets of SVEZA PARQUET plywood are selected by means of “random” sampling as per GOST 18321 in the quantity stated in Table 5.

Table 5

In sheets

Lot size	Controlled parameter as per sections herein			
	3.6.1; 3.6.2; 3.6.3; 3.6.4		4.1.2	
	Sample size	Acceptance number	Sample size	Acceptance number
Up to 500	8	1	13	1
501-1,200	13	1	20	2
1,201-3,200	13	1	32	3
3,201-10,000	20	2	32	3

5.3 Moisture, shear strength through the adhesive layer, shear strength in static bending across and along the outer plies, module of elasticity in static bending along and across the grains of the outer plies must be tested for each thickness and number of plies of SVEZA PARQUET plywood at least once per month.

5.4 To test the tensile strength perpendicular to the sheet surface, 1 sheet per 1,000 must be sampled, but not less than 1 sheet per order.

5.5 For the purpose of formaldehyde content and/or emission monitoring, one SVEZA PARQUET plywood sheet shall be selected from any sampling volume.

A reading of formaldehyde content and emission shall be monitored at least once every 30 days.

5.6 The lot is considered as compliant to the applicable requirements of the standard and is accepted, provided that in the samples:

- the number of SVEZA PARQUET plywood sheets not complying with the standard requirements in terms of dimensions, out-of-squareness, out-of-straightness,

wood defects, and processing defects shall be less than or equal to the acceptance number specified in Table 5;

— all SVEZA PARQUET plywood sheets are free of blisters, ply splitting, or bark patch;

— physical and mechanical parameters are compliant with the ranges set forth in Table 4;

— the formaldehyde content and/or emission is compliant with limits set forth in Table 3.

## 6 TEST METHODS

6.1 Sampling procedure — as per GOST 9620, GOST 27678, GOST 32155, GOST 30255, [1]—[2], [6].

6.2 SVEZA PARQUET plywood length and width are measured at two points parallel to the edges, at least 100 mm from edges with a metal measuring tape according to GOST 7502 with a tolerance of 1 mm. The arithmetic mean value of the two measurements is considered the actual length (width) of the sheet.

6.3 SVEZA PARQUET plywood thickness is measured at least 25 mm from the edges, in the middle of each sheet's face.

The arithmetic mean value of the four measurements is considered the actual thickness of the sheet.

The following devices are used for thickness measurement:

— thickness gauge as per GOST 11358 with a scale division not exceeding 0.1 mm;

— micrometer as per GOST 6507 with a scale division not exceeding 0.1 mm.

The thickness difference in one SVEZA PARQUET plywood sheet is defined as the difference between the maximum and the minimum thickness of the four measurements.

6.4 Out-of-squareness of a sheet of SVEZA PARQUET plywood

6.4.1 Out-of-squareness of SVEZA PARQUET plywood sheet shall be measured as per GOST 30427. The out-of-squareness shall be measured with an L-square as per GOST 3749. Out-of-squareness is defined by measuring the maximum deviation of the sheet edges from the L-square surface using a metal ruler in accordance with GOST 427 with an error of 1 mm.

6.4.2 Out-of-squareness may be also determined by the difference of diagonal lines of the sheet measured by metal measuring tape as per GOST 7502 with a scale division of 1 mm.

6.5 Out-of-straightness of a SVEZA PARQUET plywood sheet edges shall be determined by measuring the maximum gap between the sheet edge and the edge of the metal ruler using a feeler gauge according to GOST 8925 with an error of 0.2 mm.

6.6 Warping — as per GOST 30427.

6.7 Moisture — GOST 9621, [3].

6.8 Shear strength through adhesive layer — as per GOST 9624, [4].

6.9 Ultimate strength and modulus of elasticity in static bending — per GOST 9625, [5].

6.10 Formaldehyde content as per GOST 27678; formaldehyde emission into the environment as per GOST 30255, GOST 32155 and [1].

6.11 Tensile strength perpendicular to the panel surface — as per [6].

6.12 Surface roughness — as per GOST 15612.

6.13 Measurement of wood flaws and processing defects as per GOST 30427 and GOST 2140.

## **7 TRANSPORTATION AND STORAGE**

7.1 SVEZA PARQUET plywood must be transported in enclosed vehicles according to the haulage rules applicable to the respective means of transport.

Contact with moisture must be avoided during transportation in order to avoid changes in the geometry, physical parameters and quality of the SVEZA PARQUET plywood, and the emission class.

7.2 Storage of SVEZA PARQUET plywood

SVEZA PARQUET plywood must be stored indoor in stacks placed horizontally on pallets or on wooden shims, at a temperature between  $-40^{\circ}\text{C}$  and  $+50^{\circ}\text{C}$  and relative humidity up to 80%.

## **8 MANUFACTURER'S WARRANTY**

The manufacturer guarantees conformance of the plywood to the quality requirements of this standard if transportation and storage conditions are satisfied.

The EXT / FSF grade SVEZA PARQUET plywood guaranteed shelf life is 5 years following the day of receipt by the customer.

If the SVEZA PARQUET plywood is to be used for further processing, it is recommended to contact the manufacturer for more details about the properties and specifications of the plywood.

## **9 SAFETY AND ENVIRONMENTAL REQUIREMENTS**

9.1 The content of hazardous chemicals emitted into residential or public building air during use of SVEZA PARQUET plywood products must not exceed the requirements under items [7], [8], and [9].

9.2 SVEZA PARQUET plywood must be produced using materials and components approved by the national sanitary and epidemiological inspection authorities.

9.3 Only persons age 18 and older with a clean bill of health are allowed to work in SVEZA PARQUET plywood production. Medical examinations are conducted according to the applicable instructions from the Ministry of Health of the Russian Federation.

9.4 Personnel engaged in SVEZA PARQUET plywood manufacturing must be provided with personal protective equipment according to the applicable regulations under GOST 12.4.011.

9.5 Specific activity of Cesium 137 in SVEZA PARQUET plywood must not exceed health standards set forth in [10].

9.6 The standard SVEZA PARQUET plywood composition does not include raw materials or components classified as hazardous waste.

9.7 SVEZA PARQUET plywood usually has a long service life, and there are a number of ways to recycle it. SVEZA PARQUET plywood must be recycled taking into account the ordinances regarding recycling in the effective laws of various countries.

APPENDIX A  
(mandatory)

**Limit values for wood flaws and processing defects — as per GOST 30427 for outer plies  
of the SVEZA PARQUET plywood**

Limit values for wood flaws and processing defects — as per GOST 30427 for outer plies of SVEZA PARQUET plywood are listed in Table A.1

Table A.1

WOOD FLAWS AND PROCESSING DEFECTS	BB (II)	CP (III)	C (IV)
1. Pin knots	allowable		
2. Sound knots, intergrown, light and dark	light ones up to 25 mm in diameter with cracks up to 1 mm width, 10 per square meter maximum — allowed	allowed with cracks up to 1 mm width	allowable
3. Partially intergrown knots	intergrown knots up to 15 mm in diameter, 10 per square meter maximum — allowed		allowable: any number with diameters up to 40 mm
4. Black knots, loose knots, knot holes (no bark inclusions)	allowed including intergrown knots up to 6 mm in diameter, 3 per square meter maximum	allowable: any number with diameters up to 6 mm	allowable: any number with diameters up to 40 mm  (bark patches up to 5 mm wide allowed near the knot)
5. Closed cracks	allowable: up to 5 per meter of sheet width, up to 300 mm long	edge and middle cracks are allowable	

## Appendix A — continued

WOOD FLAWS AND PROCESSING DEFECTS	BB (II)	CP (III)	C (IV)
6. Open cracks	allowable: up to 3 per meter of sheet width, up to 250 mm long and up to 2 mm wide, provided they are filled up using sealing agent	allowable: up to 600 mm long and up to 2 mm wide; in total not more than 2 per meter of sheet width, + up to 600 mm long and up to 5 mm wide, provided they are filled up using sealing agent	allowable up 800 mm long and up to 10 mm wide, no limitation on number
7. Open joints on spliced veneer	Edge-jointed veneer is not allowed		
8. Timber structure flaws (diagonal grain, swirly grain, burls, bud traces)	allowable		
9. Timber structure flaws (light/dark inner inbark)	light inbark — allowable, dark inbark allowable within dimensions of jointed knots		
10. Timber structure flaws (surface inbark)	allowable within the total number under the black knot requirements		
11. Sound discoloration (false heartwood)	up to 25 % of surface — allowable	up to 75 % of surface — allowable	
12. Sound discoloration (stains, streaks, streak traces)	allowable: up to 250 mm long and up to 10 mm wide in total not more than 10 per m <sup>2</sup>	allowable	
13. Sound discoloration (grouped streaks)	allowable: up to 60x40 mm, not more than 1/m <sup>2</sup>	allowable	



## Appendix A — continued

WOOD FLAWS AND PROCESSING DEFECTS	BB (II)	CP (III)	C (IV)
14. Chemical coloration, sap stains (blue and colored sap stains), discoloration after storage	allowable: up to 50% of the sheet surface area (false heartwood included)	allowable: up to 75% of the sheet surface area (false heartwood included)	allowable
15. Biological damage (wormholes)	allowable within the total number under the black knot requirements		
16. Discoloration with partial wood damage	not allowable		
17. Patching of knots and holes with wood inserts	allowable not more than 8 wooden inserts per m <sup>2</sup> , of various shapes and sizes provided that color of timber and direction of grains are similar to those of face ply	allowable — 1 mm gap from one side, 0.5 mm gap from two sides by inserts of various shapes and sizes	allowable
18. Double insert	allowable: not more than 1/m <sup>2</sup>	allowable	
19. Patching open cracks with sealing agents or veneer patches	open cracks wider than 2 mm must be patched with sealing agents	open cracks wider than 5 mm must be patched with sealing agents	allowable
20. Faceplate bulges (imprinted)	allowable: up to 3 mm wide in total not more than 3 per sheet	allowable: up to 5 mm wide in total not more than 5 per sheet	allowable
21. Overlaps	allowable: up to 1 per meter of sheet width, up to 100 mm long and up to 2 mm wide	allowable: up to 2 per meter of sheet width, up to 300 mm long and up to 2 mm wide	allowable

## Appendix A — continued

WOOD FLAWS AND PROCESSING DEFECTS	BB (II)	CP (III)	C (IV)
22. Stains from manufacturing (beam traces, strips)	up to 10 % of surface — allowable	allowable	
23. Glue stains	up to 2 % of surface — allowable	up to 5 % of surface — allowable	allowable
24. Mechanical damage (cuts, holes)	allowable within the total number under the black knot requirements		
25. Scratches, ribs, blows, ridges	not allowable	allowable up to 120 mm long and up to 10 mm wide, and 0.5 mm in depth	allowable
26. Warping	not considered for plywood up to 6.5 mm thick; not more than 15 mm per 1 m of sheet diagonal is allowable for plywood thicker than 6.5 mm		
27. Blister, delamination (also when bended), bark patch	not allowable		
28. Unsanded stains (nonuniform sanding)	not allowable		
29. Oversanding of surface layers	not allowable	up to 1 % of surface — allowable	up to 5 % of surface — allowable
30. Metal inclusions	not allowable	brackets of non-ferrous metals are allowable	
31. Edge defects caused by trimming, lack of veneer	no more than 2 mm		up to 10 mm wide
32. Non-smooth peeling	up to 5 % of surface — allowable	up to 15 % of surface — allowable	allowable
34. Waviness (for sanded plywood), roughness, ripple	not allowable	allowable	
33. Surface roughness	roughness parameter $R_m$ as per GOST 7016 ( $\mu\text{m}$ ), 100 maximum		

*Appendix A — end*

WOOD FLAWS AND PROCESSING DEFECTS	BB (II)	CP (III)	C (IV)
34. Pockets (no bark inclusions)	allowable: in size of group streaks not more than 60x40 mm, not more than 1/m <sup>2</sup>	allowable	
35. Glued veneer particles	not allowable	allowable: up to 150 mm long and up to 30 mm wide in total not more than 1 per sheet	allowable

Note: Any defects not specified in Appendix A are not allowed.

**APPENDIX B  
(mandatory)**

**Terms and definitions for processing defects of the outer plies of the SVEZA  
PARQUET plywood**

Terms and definitions for processing defects of external layers of the SVEZA PARQUET plywood are specified in Table B.1

Table B.1

Name of processing defect	Description
Glued veneer particles	Veneer particles glued to or pressed into plywood surface
Non-smooth peeling	Dense small surface recessions caused by local removal of wood during peeling
Pocket	a cavity in the wood or between annual rings filled with resin or gum.

**APPENDIX C**  
**(mandatory)**

**Limit values for wood flaws and processing defects of the inner plies  
of the SVEZA PARQUET Premium plywood**

Wood flaws and processing defects limits for internal plies of SVEZA PARQUET Premium plywood are listed in Table C.1

Table C.1

Wood flaws and processing defects	1 middle (S1)	2 middle (S2)
1. Pin knots	allowable	
2. Sound knots, intergrown, light and dark	allowable	
3. Partially intergrown knots	allowable 20 mm max. in diameter	allowable 40 mm max. in diameter
4. Non-intergrown knots, loose knots, knot holes (no bark inclusions), tobacco color	allowable 15 mm max. in diameter	allowable 40 mm max. in diameter
5. Closed cracks	allowable in an unlimited number	
6. Open cracks	allowable — no more than 2 mm	allowable — no more than 5 mm
7. Edge-jointed veneer usage Gap in edge-jointed veneer joints	Edge-jointed veneer usage is not allowed	
8. Spliced veneer usage	allowable	
9. Bark	not allowable	
10. Chemical coloration, sap stains (blue and colored sap stains), discoloration after storage without compromising the wood integrity	allowable	
11. Discoloration with partial wood integrity damage	allowable: up to 5% of the sheet surface area	allowable: up to 25% of the sheet surface area

*Appendix C — end*

WOOD FLAWS AND PROCESSING DEFECTS	1 middle (S1)	2 middle (S2)
12. Biological damage (wormholes), mechanical damage (including pinholes caused by the hook)	allowable 15 mm max. in size	allowable 40 mm max. in size
13. Crevices and holes left by knots	can be patched by veneer patches of any size and shape	
14. Soot, soot dust and other products of burning on the veneer surface	not allowable	
15. Sound discoloration (false heartwood, stains, strains, group strains)	allowable	
16. Non-smooth peeling	allowable	
17. Open ingrowth (no bark inclusions)	allowable — no more than 2 mm width	allowable — no more than 5 mm width
18. Other defects	allowable provided they do not affect the quality and size of the plywood as per requirements set forth in this Standard	

APPENDIX D  
(mandatory)

**Designation of SVEZA PARQUET plywood grades and types**

For types and grade designators of SVEZA PARQUET plywood, see Table D.1

Table D.1

Latin Letters	Roman Numerals	Text on the label in the “Grade” column
<b>SVEZA PARQUET Premium plywood</b>		
BB/BB	II/II	PPR BB/BB (II/II)
BB/CP	II/III	PPR BB/CP (II/III)
CP/CP	III/III	PPR CP/CP (III/III)
<b>SVEZA PARQUET Standard plywood</b>		
CP/CP	III/III	PST CP/CP (III/III)
CP/C	III/IV	PST CP/C (III/IV)

APPENDIX E  
(mandatory)

**Packing assembly schemes for SVEZA PARQUET Premium plywood**

The packet assembly scheme for SVEZA PARQUET Premium plywood is shown in Figure 1.

Face ply	S1	S2	S2	S2	...	S2	S2	S2	S1	Face ply
<b>I</b>	-	<b>I</b>	-	<b>I</b>	...	<b>I</b>	-	<b>I</b>	-	<b>I</b>

Figure 1

## References

- [1] DIN EN ISO 12460-3 Wood-based panels - Determination of formaldehyde release. Part 3. Gas analysis method
- [2] EN 326-1-1994 Wood-based panels. Sampling, cutting, and quality control. Part 1. Testing sample selection and cutting, expressing test results
- [3] EN 322:1993 Wood-based panels. Determination of moisture content
- [4] EN 314-1:2004 Plywood. Bond quality. Part 1. Test methods
- [5] EN 310:1993 Wood-based panels. Determination of the modulus of elasticity in bending and of bending strength
- [6] DIN EN 319:1993 Particleboards and fiberboards. Determination of tensile strength perpendicular to the plane of the board
- [7] GN 2.1.6.3492-17 Maximum allowable concentrations (MAC) of pollutants in the atmospheric air of urban and rural settlements
- [8] GN 2.1.6.2309-07 Tentative safe exposure levels (TSEL) of pollutants in the atmospheric air of populated places. Hygienic standards
- [9] GN 2.1.6.2328-08 Addendum to GN 2.1.6.2309-07, Tentative safe exposure levels (TSEL) of pollutants in the atmospheric air of populated places. Hygienic standards
- [10] Unified sanitary-epidemiological and health standards for goods subject to sanitary and epidemiological control, approved by the Customs Union Commission decision No. 299 as of May 28, 2010



UDC 674-415:006.354

MKS 79.060.10

OKPD 2 16.21.12.119

Keywords: corporate standard, SVEZA PARQUET plywood, dimensions, technical requirements, packaging, labeling, quality control methods, transportation, storage, warranty.

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