



ESTPLY BIRCH PLYWOOD

Surface Veneer Grading Guide

ESTPLY BIRCH
ESTPLY INTERIOR

Surface Grades S, BB, WG

A word from the panel itself: "Time to time I look a bit different, but I'm always ready for painting. I enjoy furniture and other similar applications, where people appreciate my smooth surface."

Description EN	Face veneer
Pin knots	Permitted
Sound intergrown knots	Permitted to max \varnothing 12 mm, Total knot sum 50 mm/m ²
Unsound adhering knots	Permitted to max \varnothing 8 mm, Total knot sum 25 mm/m ²
Other knots and holes	Permitted to max \varnothing 8 mm, Total knot sum 25 mm/m ²
Open splits	Allowed if filled 1 pcs/rm Max width 2 mm Length 200 mm
Closed splits and Checks	Allowed 2 pcs/rm total length 200 mm
Discoloration	Max 50% of the total area
Colored lines	Permitted
Irregular dark lines	Permitted
Open joints	Not permitted
Folds and overlaps	Not permitted
Surface Roughness	Permitted, if disappears after sanding
Peeling stripes	Permitted small amount, if disappears after sanding
Bark	Not permitted
Cambium	Not permitted
Patches	Not permitted
Composed wet veneer joints	Not permitted
Max defects per sheet	6

The surface veneer grades are based on the Handbook of Finnish Plywood in compliance with the requirements of the European Standard EN 635-2. Classification by surface appearance - Part 2: Hardwood.

All images shown are for illustration purposes only. Wood is a natural product with indefinite variations. See the table above for the detailed description of the allowed defects.



A word from the panel itself: "I consider myself as the bread and butter of birch plywood. I'm perfect when used in structures and components. I want to look good and that's why I batch my face. However, if you like a more beautiful version of me, talk to S."

Description EN	Face veneer
Pin knots	Permitted
Sound intergrown knots	Permitted to max \varnothing 25 mm, total knot sum 60 mm/m ²
Unsound adhering knots	Permitted to max \varnothing 6 mm, total knot sum 25 mm/m ²
Other knots and holes	Permitted to max \varnothing 6 mm, total knot sum 25 mm/m ²
Open splits	Allowed if filled 1 pcs/rm. Max width 2 mm, length 200 mm
Closed splits and Checks	Allowed 2 pcs/rm, length 200 mm
Discoloration	Permitted
Colored lines	Permitted
Irregular dark lines	Permitted
Open joints	Permitted 1 pcs/rm. Max width 2 mm, length 200 mm
Folds and overlaps	Permitted 1 pcs/rm, length 200 mm
Surface Roughness	Slightly - light roughness
Peeling stripes	Randomly, slightly
Bark	Not permitted
Cambium	Not permitted
Patches	17 pcs/m ² 4 ft x 4ft total 30 pcs 4 ft x 8 ft total 60 pcs 5 ft x 5 ft total 45 pcs 5 ft x 10 ft 75 pcs Overlapping patches not permitted
Composed wet veneer joints	Not permitted
Max defects per sheet	9

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A word from the panel itself: “Choose me when you value the strength properties over the looks. Because of my uneven surface I’m not made for coating. Otherwise I’m ok with all the applications.”

Description EN	Face veneer
Pin knots	Permitted
Sound intergrown knots	Permitted to max \varnothing 65 mm, Total knot sum 600 mm/m ²
Unsound adhering knots	Permitted to max \varnothing 20 mm, Total knot sum 200 mm/m ²
Other knots and holes	Permitted to max \varnothing 15 mm, Total knot sum 100 mm/m ²
Open splits	Permitted 2 pcs/rm Max width 3 mm
Closed splits and Checks	Permitted if filled
Discoloration	Permitted
Colored lines	Permitted
Irregular dark lines	Permitted
Open joints	Permitted max width 3 mm
Folds and overlaps	Permitted if overlaps fixed 2 pcs/rm length 500 mm
Surface Roughness	Permitted - stronger roughness
Peeling stripes	Slightly
Bark	Not permitted
Cambium	Not permitted
Patches	Permitted
Composed wet veneer joints	Permitted
Max defects per sheet	N/A

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