

## Film Faced Birch Plywood Quality Grades

CHARACTERISTICS	GRADES		
	F1/W1	F2/W2	F3
Film lamination	Film shall be clean, smooth and firmly glued to the plywood surface	Film shall be clean, smooth and firmly glued to the plywood surface	Film shall be firmly glued to the plywood surface on the face side
Delamination of film, film detaching, ruptures, absence, peeling	Permitted on one edge not more than 3mm provided that it is coated with moisture-protective paint	Permitted no more than 2% of sheet area provided it is coated with moisture-resistant paint	Permitted on reverse face
Printing of wood grain structure, sound knots, inserts	Permitted	Permitted	Permitted
Film diffuse stains and stripes on surface	Permitted not more than 15% of sheet area stains without face coating integrity loss	Permitted	Permitted
Matt spots and stripes	Permitted not more than 15% of sheet area stains without face coating integrity loss	Permitted	Permitted
Stripes and stains from press plates	Permitted	Permitted	Permitted
Temperature stains on surface	Not permitted	Permitted without damaging the coating	Permitted
Film overlaps (riffles, wrinkles)	Not permitted	Permitted without any limitations with a width of up to 30 mm	Permitted
Sticking of film fragments	Not permitted	Permitted	Permitted
Burned film (burnout) due to veneer defects: cracks, damages, detached knots	Not permitted	Permitted with a width of up to 20 mm (1 pc/width m), allowed as heat stains/spots with a diameter of up to 30 mm (1 pc/m <sup>2</sup> ) or unlimited if under 10 mm	Permitted

Burned film (burnout) due to veneer defects: rough peeling	Not permitted	Permitted	Permitted
Burned film (burnout) due to veneer defects: stripes and spots from sanding	Not permitted	Permitted up to 25% of sheet area	Permitted
Traces from inner ply defects: detached knots, holes	Not permitted	Permitted	Permitted
Traces of inner ply defects: open joint, cracks	Not permitted	Permitted	Permitted
Trace of glued or scarf-jointed veneer	Permitted without face coating damage	Permitted	Permitted
Veneer particles glued into the face ply	Not permitted	Permitted	Permitted
Dents	Permitted up to 6 mm in diameter, no more than 1 per m <sup>2</sup> , provided there is a durable film bond	Permitted no more than 0.5 mm depth without face coating damage	Permitted
Scratches and scrapes	Permitted minor scrapes on the reverse face if the film is not scraped through	Permitted if the film is not scraped through	Permitted
Trimming defects, edge splintering	Permitted no more than 3 mm long provided it is coated with moisture-resistant paint	Permitted no more than 10 mm long provided it is coated with moisture-resistant paint	Permitted
Sealing paint streaks	Permitted no more than 5 mm	Permitted no more than 5 mm	Permitted
Absence of veneer	Not permitted	Permitted on single edge, no more than 5mm depth	Permitted
Local delamination	Not permitted	Not permitted	Permitted up to 100 cm <sup>2</sup> /m <sup>2</sup>