

Eximcorp India Pvt Ltd

Simplified grading rules for plywood

Grades according 10.55- 71	B	BB	CP	C
Grades Gost-3916.1-96	I	II	III	IV
Pin knots	Not more than v3 per sq. meter	Allowed	Allowed	Allowed
Sound intergrown knots	Allowed with diameter not more than 15 mm	Allowed with diameter not more than 25 mm	Allowed with cracks not wider than 1,5 mm	Allowed
Other knots	Allowed with maximum diameter 6 mm	Allowed with maximum diameter 6 mm	Allowed with maximum diameter 6 mm	Allowed with maximum diameter 40 mm
Closed splits	Maximum length 200 mm	Maximum length 200 mm	Allowed	Allowed
Open splits	Not allowed	Allowed with maximum size 200*2 mm	Allowed with maximum size 300*2 mm	Allowed with maximum width 10 mm
Light discoloration	Allowed not more than 5% of the surface of the panel	Allowed	Allowed	Allowed
Heavy discoloration	Not allowed	Not allowed	Not allowed	Allowed
Glue penetration (through faces)	Not allowed	Allowed not more than 2% of the surface of the panel	Allowed not more than 5% of the surface of the panel	Allowed
Veneer overlapping	Not allowed	Allowed with max length 100 mm	Allowed with max length 200 mm	Allowed
Repairing by plugs	Not allowed	Allowed with single plugs	Allowed with double plugs	Allowed with double plugs
Sanding through faces	Not allowed	Not allowed	Not allowed	Allowed

Note: In practice plugs are the main difference between B and BB grade – there are plugs on BB faces and there are no plugs on the B face. Grades B, BB and CP are usually sanded whereas grade C remains unsanded.