

SURFACES AND QUALITY DEFINITION

MINIMUM SURFACE QUALITY REQUIREMENTS

Criteria	Domestic visible (DVQ)	Industrial visible (IVQ)	Non visible + (NVQ +)	Non visible (NVQ)
Surface treatment	sanded	sanded	thicknesses 90 - 250 mm: planed with rotation traces other thicknesses: selectively sanded	planed
Type of wood	one type of wood	one type of wood; spruce / fir ($\leq 10\%$) are regarded as one type of wood	one type of wood; spruce / fir ($\leq 10\%$) are regarded as one type of wood	addition of other types of wood possible
Colour and texture	mostly balanced	generally balanced	no requirements	no requirements
Blue stain and red tinge	slight discolouration permissible ($\leq 3\%$)	slight discolouration permissible ($\leq 5\%$)	slight discolouration permissible ($\leq 8\%$)	no restrictions
Branches, tightly intergrown	permissible	permissible	no restrictions	no restrictions
Branches, black	permissible ≤ 25 mm \varnothing	permissible ≤ 35 mm \varnothing	permissible ≤ 45 mm \varnothing	no restrictions
Loose knots, knot holes	permissible ≤ 12 mm \varnothing	permissible ≤ 12 mm \varnothing	permissible ≤ 25 mm \varnothing	no restrictions
Resin pockets	sporadically permissible $\leq 3 \times 50$ mm	sporadically permissible $\leq 5 \times 70$ mm	no restrictions	no restrictions
Piths	sporadically permissible length ≤ 800 mm	sporadically permissible length ≤ 1000 mm	no restrictions	no restrictions
Bark ingrowth	impermissible	impermissible	no restrictions	no restrictions
Wane	impermissible	impermissible	impermissible	permissible
Compression wood	sporadically permissible	sporadically permissible	permissible	no restrictions
Cut burrows from inactive insect infestation	impermissible	impermissible	sporadically permissible	sporadically permissible
Wood moisture during production	$\leq 12\%$	$\leq 12\%$	$\leq 14\%$	$\leq 14\%$
Cracks and joints (at a reference moisture measurement of 12%)	sporadically permissible $\leq 1,5$ mm	sporadically permissible ≤ 2 mm	sporadically permissible ≤ 4 mm	sporadically permissible ≤ 6 mm
Surface defects	sporadically permissible ≤ 12 mm \varnothing	sporadically permissible ≤ 12 mm \varnothing	no restrictions	no restrictions
Surface re-treatment (Filling and plugging of branch holes, strips, etc.)	permissible	permissible	permissible	no restrictions
Defects on cutting edges	sporadic small defects permissible	sporadic defects permissible	permissible	no restrictions
Cutting edge re-treatment manually, using sand paper	yes	yes	yes	no
Chamfer on DL panels	yes	yes	no	no
Range of validity	The stated surface qualities apply: - upon dispatch, - to the top layer only, - not to narrow sides. Only the criteria for surface quality NVQ apply to narrow sides. Surface quality NVQ + is currently only available for DL panels.			
Crack formation	Like all solid wood products, the above stated qualities are subject to crack and joint formation as a result of drying to their future compensation moisture balance when installed due to the product characteristics. This cannot be prevented.			