

SURFACE QUALITY STANDARD - ACCORDING TO EN13017-1/ 2020
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Surface quality and characteristics

No	Characteristics	V(Visible)	I (industrial)	N (non-visible)
1.	Appearance grade	A/B	B/B; B/C	C/C
2.	Type of wood	One type of wood	Admixture of pine is allowed if <10%	Addition of other types of wood possible
3.	Bonding	Occasional open joints up to 1,5mm width permitted	Occasional open joints up to 3mm width permitted	Occasional open joints up to 5mm width permitted
4.	Blue stains	Not permitted	Occasionally slight discolouration	Permitted
5.	Resin galls	Occasionally up to 3 x 50 mm permitted	Occasionally up to 5 x 50 mm permitted	Permitted
6.	Bark ingrowth	Occasional occurrences permitted	Occasional occurrences permitted	Permitted
7.	Dry cracks	Occasional with a width of 1.5mm is permitted	Occasional cracks permitted	Permitted
8.	Core- pith	Occasional, up to 400 mm long permitted	Permitted	Permitted
9.	Insect damage	Not permitted	Not permitted	Single small worm holes permitted provided worms are inactive
10.	Knots - sound	Permitted	Permitted	Permitted
11.	Knots - black	Occasionally up to 15 mm Ø permitted	Occasionally up to 30 mm Ø permitted	Permitted
12.	Knots - hole	Max. 10 mm Ø	Max. 20 mm Ø	Permitted
13.	Surface	100% sanded	100% sanded	No requirements
14.	Quality of surface finish	Occasional small technical faults permitted	Occasional small technical faults permitted	Occasional small technical faults permitted
15.	Wood moisture	Max. 12 % ± 2%	Max. 12 % ± 2%	Max. 12 % ± 2%
16.	Cutting edge retreatment manually using sandpaper	Available on request	Available on request	Available on request

V – Visible quality



I – Industrial quality



N – Non-Visible quality



The given surface qualities valid:

- At the time of delivery;
- Only for the covering layer, not for the narrow sides);
- For one-sided visible surfaces, if not specified;
- For narrow sides and CNC-treated surfaces, the criteria for non-visible surface quality apply;
- For double-sided visible surfaces, a small amount of on-site reworking is to be expected.

Wood is a natural product. Minor deviations from the table values are natural and are no reason for complaint.

Dried cracks:

Like all solid wood products, CLT is also subject to the formation of cracks and joints as the material dries and adjusts to the future equilibrium humidity level after installation. This is due to the characteristics of the product and cannot be avoided. Especially in the first few years, cracking noises may also occur along with the formation of cracks, which are considered harmless.

Especially for surfaces that are of visible quality, it is important to avoid significant fluctuations in the room climate both during the construction phase (e.g. when the floor concrete dries) and during use. The ideal air humidity level is between 40% and 60%.

For white-glazed surfaces, in particular, undesired and irreversible contrasts may occur due to crack or gap formation. Please inform building owners and instruct all subsequent parties accordingly during the construction phase.

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