

# Grading rules

## Grading rules for system flooring

Characteristics	A-DIN	B-DIN
<b>Knots</b>	Only tight knots which are at least with the half of their circumference intergrown with the surrounding wood are admissible, up to a diameter of 1/4 of the board width. A minimal edge breakage if they are covered by tongue and groove are also admissible. Pin knots up to a diameter of 8 mm as well as wooden dowels up to 1 piece / running meter - calculated with an average of the total pieces - are admissible.	Tight knots which are at least with the half of their circumference intergrown with the surrounding wood are admissible, up to a diameter of the half board width. A minimal edge breakage if they are covered by tongue and groove are also admissible. Sound knots up to a diameter of 20 mm in 25% of the whole quantity are admissible, if they are firmly fixed with the surrounding wood at least on one side of the board. Pin knots up to a diameter of 8 mm as well as wooden dowels up to 1 piece / 0,7 running meter - calculated with an average of the total pieces - are admissible.
<b>Resin pockets</b>	Resin pockets up to a surface of 1 cm <sup>2</sup> and 2 piece / board in 20% of the whole quantity are admissible.	Resin pockets up to a surface of 2 cm <sup>2</sup> and 5 piece / board in 35% of the whole quantity are admissible.
<b>Shakes</b>	Shakes on the surface are generally not admissible. However, end shakes up to a length of 30 mm in max. 15% of the total quantity, as well as shakes in the knot caused by kiln drying are admissible.	Shakes if they are not through are admissible. End shakes up to a length of the board width are admissible. Through shakes in the knot are admissible.
<b>Compression wood</b>	Compression wood is not admissible.	Compression wood is admissible, if it has no influence on laying the boards.
<b>Bark pockets</b>	Bark pockets up to a surface of 1 cm <sup>2</sup> in 10% of the whole quantity are admissible.	Bark pockets up to a surface of 2 cm <sup>2</sup> in 30% of the whole quantity are admissible.
<b>Pith</b>	Pith is up to 1/3 of the length of the board admissible, in 20% of the total quantity.	Pith is in the whole length of the board admissible, in 30% of the total quantity.
<b>Insect damage</b>	Insect damage is inadmissible.	Insect damage is inadmissible.
<b>Discoloration</b>	Discoloration and slight heart stain in 20% of the whole quantity is admissible. Blue stain is inadmissible.	Discoloration and slight heart stain in 50% of the whole quantity is admissible. Blue stain is inadmissible.
<b>Woodworking</b>	The boards are on the surface well sanded. Slight roughnesses (for example next to the knots) are admissible. On the backface one rough edge is admissible, if it has no influence on the stability and the laying of the boards. System flooring has basically tongue & groove on all edges, the edges on the surface are tapered, and has grooves on the backface.	The boards are on the surface well sanded. Slight roughnesses (for example next to the knots) are up to 2 cm <sup>2</sup> admissible. On the backface one rough edge is admissible. System flooring has basically tongue & groove on all edges, the edges on the surface are tapered, and has grooves on the backface.

Note:

According to ÖNORM, inevitable grading errors caused by visual grading, are up to 5% of the whole quantity admissible!