

# Surface qualities

## CLT surface quality

Surface quality appearance with respect to product characteristics

Characteristics	VI	IVI	NVI
Bonding	occasional open joints up to max. 1 mm width permitted	occasional open joints up to max. 2 mm width permitted	occasional open joints up to max. 3 mm width permitted
Blue stains	not permitted	slight discolouration permitted	permitted
Discolorations (brown stains, etc.)	not permitted	not permitted	permitted
Resin pockets	no clusters of pockets, max. 5 × 50 mm	max. 10 × 90 mm	permitted
Bark ingrowths	occasional occurrences permitted	occasional occurrences permitted	permitted
Dry cracks	occasional surface cracks permitted	permitted	permitted
Core – pith	occasional, up to 40 cm long permitted	permitted	permitted
Insect damage	not permitted	not permitted	occasional small holes up to 2 mm permitted
Knots – sound	permitted	permitted	permitted
Knots – black	∅ max. 1.5 cm	∅ max. 3 cm	permitted
Knots – hole	∅ max. 1 cm	∅ max. 2 cm	permitted
Rough edges	not permitted	not permitted	max. 2 × 50 cm
Surface	100% sanded	100% sanded	max. 10% of surface rough
Quality of surface finish	occasional small faults permitted	occasional faults permitted	occasional faults permitted
Quality of narrow side bonding and face ends	occasional small faults permitted	occasional faults permitted	occasional faults permitted
Chamfer on L panels	yes	yes	no
Rework edge of cut with sandpaper	yes	no	no
Machining – chainsaw	not permitted	permitted	permitted
Lamella width	≤ 130 mm	max. 230 mm	max. 230 mm
Moisture content	max. 11%	max. 15%	max. 15%
Timber species mixture	not permitted	not permitted	with spruce, silver fir and pine are permitted
Aesthetic surface finish with bolts, pegs, etc.	permitted	permitted	permitted
With C panels, the sanding direction is at right angles to the grain	permitted	permitted	permitted

VI (visible quality)



IVI (industrial visible quality)



NVI (non-visible quality)

