



CORPORATE STANDARD*

SVEZA DRAWER BIRCH PLYWOOD Technical Specifications

STO 52654419-004-2018

Saint Petersburg
2018

* In case of discrepancies, the Russian version of the organization's standard is to be considered as priority. / В случае возникновения разночтений приоритетной является версия стандарта организации на русском языке

Preface

Development purposes and objectives, as well as the use of corporate standards in the Russian Federation, are stated by Federal Law 184-FZ *On Technical Regulation* of December 27, 2002 and Federal Law of June 29, 2015.

No. 162-FZ *On Standardization in the Russian Federation*.

Development and execution rules are stated by GOST R 1.0-2012 *Standardization in the Russian Federation. General provisions* and GOST R 1.4-2004 *Standardization in the Russian Federation. Corporate Standards. General Provisions*, subject to GOST R 1.5-2012, *Standardization In the Russian Federation. National standards. Regulations on arrangement, representation, execution, and designation*.

Information on Standard

1 DEVELOPED AND INTRODUCED by SVEZA Forest, a limited liability company

2 APPROVED AND ENACTED by order of the General Director of OOO SVEZA Forest dated _____ 20___.No. _____

3 APPROVED by OOO SVEZA Forest Sales and Marketing Director R.A. Muzyka _____, _____ 20 ____

4 FIRST RELEASE

5. THE EXPERT CONCLUSION, dated 03.05.2018, HAS BEEN RECEIVED from E.Yu. Tretyakova, Expert in the confirmation of the conformity of woodworking industry products, Head of the Fantest NP Certification Body, and member of Technical Committee on Standardization TK 121.

This standard may only be used for work with the written consent of OOO SVEZA Forest.

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CORPORATE STANDARD

SVEZA DRAWER BIRCH PLYWOOD Technical Specifications

BIRCH PLYWOOD SVEZA DRAWER Technical Requirements

Effective since _____, 20__

1 SCOPE

This standard applies to SVEZA DRAWER birch plywood (hereinafter referred as SVEZA DRAWER plywood), used as the main material in manufacture of parts, boxes, furniture components or other independent products in the form of boxes and other products, assuming the cutting of plywood with circular saws and end-mill cutters, as well as machining of sawn faces and edges.

2 REGULATORY REFERENCES

This standard hereby includes regulatory references to the following standards:

GOST 12.4.011-89 Occupational safety standards system. Worker means of protection. General requirements and classification.

GOST 427-75 Metal measuring rulers. Technical Specifications

GOST 2140-81 Visible defects of wood. Classification, terms and definitions, methods of measurement

GOST 3749-77 90° L-squares. Specifications

GOST 6507-90 Micrometers. Specifications

GOST 7016-2013 Products of wood and wooden materials. Surface roughness parameters

GOST 7502-98 Metal measuring tapes. Specifications

GOST 8925-68 Feeler gauges for machine tool accessories Design

GOST 9620-94 Glued laminated timber. Sampling and general requirements for testing

GOST 9621-72 Glued laminated timber. Methods for determination of physical properties

GOST 9624-2009 Glued laminated timber. Method for determination of shear strength

GOST 9625-2013 Glued laminated timber. Method of determining of static bending strength and modulus of elasticity in static bending

GOST 11358-89 Dial-type thickness gauges and dial-type wall thickness gauges graduated in 0.01 and 0.1 mm. Technical Specifications

GOST 15612-2013 Products of wood and wood materials. Methods for determination of surface roughness parameters

GOST 18321-73 Statistical quality control. Random sampling methods for custom production

GOST 27678-2014 Wood-based panels and plywood. Perforation method for determination of formaldehyde content

GOST 30255-2014 Furniture, timber and polymer materials. Method for determination of formaldehyde and other volatile chemicals in the air of climate chambers

GOST 30427-96 General-purpose plywood. General rules for classification by appearance

GOST 32155-2013 Wood-based panels and plywood. Determination of formaldehyde emissions by gas analysis method

Note: When using this standard, it is advisable to check the validity of the standards referenced against the National Standards reference index.

3 CLASSIFICATION AND DIMENSIONS

3.1 SVEZA DRAWER plywood is classified according to the glue joint water resistance as INT / FK- water-resistant plywood, glued using carbamide-formaldehyde adhesives, for indoor use.

Note: INT/FK SVEZA DRAWER birch plywood belongs to the INT formaldehyde emissions group.

3.2 Depending on surface appearance, the SVEZA DRAWER plywood is divided into grades: B, BB, BBx, CP, C (Latin letters) and I, II, III, IV (Roman numerals).

The grade designator is indicated by both Latin letters and Roman numerals. DR letters are added before the grade designation.

3.3 As for surface mechanical processing, SVEZA DRAWER plywood is available sanded on both sides — S2S / III2.

3.4 Dimensions

3.4.1 Length and width of SVEZA DRAWER sheets should be as shown in Table 1 below.

Table 1

In millimeters	
Length (width) of plywood sheet	Maximum deviation
1220; 1250	±3.0
1500, 1525	±4.0
2440; 2500	±4.0
Notes:	
1. SVEZA DRAWER plywood may be produced with other dimensions and maximum deviations by agreement between the manufacturer and the customer	
2. The SVEZA DRAWER plywood sheet length is measured along the grain of the face plies.	

3.4.2 Thickness and number of plies of SVEZA DRAWER plywood should be as shown in Table 2 below.

Table 2

Nominal Thickness of plywood (mm)	Minimum thickness (mm)	Maximal thickness (mm)	Maximum deviation (mm)	Thickness variation in one sheet, maximum (mm)	Number of plies, minimum
3.0	2.7	3.3	±0.3	0.2	3
4.0	3.7	4.3			3
5.0	4.7	5.3			4
6.0	5.7	6.3			5
6.5	6.2	6.8			5
8.0	7.7	8.3			7
9.0	8.7	9.3			7
10.0	9.7	10.3			7
12.0	11.7	12.3			9
12.7	12.4	13.0			9
14.9	14.6	15.2			11
15.0	14.7	15.3			11
18.0	17.7	18.3			13
21.0	20.7	21.3			15
24.0	23.7	24.3			17
25.0	25.7	25.3			17

Note - SVEZA DRAWER plywood is permitted to be produced with other thicknesses, number of plies, and maximum deviations by agreement between the manufacturer and the customer

3.4.3 SVEZA DRAWER plywood sheets must be cut at a right angle.

Out-of-squareness must not exceed 2 mm per 1 m of the sheet edge length, when checked as per section 6.4.1.

Difference in the diagonal lengths must not exceed 2 mm per 1 m of the sheet edge length, when checked as per section 6.4.2.

3.4.4 Out-of-straightness for the edges must not exceed 2 mm per 1 m of the sheet length.

3.5 SVEZA DRAWER plywood marking must include the following information:

- product designation with wood species specified;
- grade;

- combination of face ply grades (using Latin letters and Roman numerals);
- emission class;
- surface treatment type;
- dimensions;
- this Standard number.

Example of marking for SVEZA DRAWER birch plywood INT / FK with a combination of face ply grades B/BB (I/II), emission class E1, both sides sanded, 1,525 mm length, 1,525 mm width, 10 mm thickness:

*Фанера SVEZA DRAWER березовая / Birch Plywood SVEZA DRAWER,
INT / FK, DR B/BB (I/II), E1, S2S / III2, 1525 x 1525 x 10
STO 52654419-004-2018*

4 TECHNICAL REQUIREMENTS

4.1 Characteristics

4.1.1 Birch veneer of various thickness is used for core and face plies of SVEZA DRAWER plywood.

Minimum thickness of face plies after sanding should be not less than half the initial thickness of the face ply.

4.1.2 In outer veneers of the SVEZA DRAWER plywood, wood flaws and processing defects that exceed the limits specified in Appendix A are not allowed. Terms and definitions of wood flaws and processing defects are as per GOST 30427 and Appendix B.

4.1.3 SVEZA DRAWER plywood is available in any combination of the grades mentioned in clause 3.2 herein, depending on the quality of the outer plies, except for grade C/C

4.2 Formaldehyde content in the plywood and formaldehyde emission from SVEZA DRAWER plywood into the room air must comply with the value specified in Table 3.

Table 3

Emission class	Formaldehyde content per 100 grams of absolutely dry weight of plywood, mg	Formaldehyde release	
		Chamber method (mg/m ³ of air)	Gas analysis method (mg/m ² ·h)
E1	Up to 8.0 inclusively	Up to 0.124	Up to 3.5 inclusive, or less than 5.0 during 3 days after manufacturing

4.3 Physical and mechanical performance of SVEZA DRAWER plywood is specified in Table 4.

Table 4

Parameter name	Thickness (mm)	Physical and mechanical parameter values
1 Moisture, max (%)	3.0 – 25.0	10
2 Shear strength for shearing through adhesive layer (MPa), min	3.0 – 25.0	1.0
3 Ultimate static bending strength: — along the grain of face plies (MPa), min — across the grain of face plies (MPa), min	9.0 – 25.0	45 30
4 Modulus of elasticity in static bending: — along the grain (MPa), min — across the grain (MPa), min	9.0 – 25.0	5000 3000
5. Tensile strength perpendicular to the bonding plane (MPa), at least	5.0 – 25.0	1.2
Notes: 1. Indicated moisture limits should be adhered when shipping the SVEZA DRAWER plywood from the manufacturer's warehouse 2. Tests of INT / FK grade SVEZA DRAWER plywood shall be performed after soaking samples in water at (20 ± 3) °C for 24 hours. 3. Percentage of destruction in wood is determined visually 4. Adhesive layer cleaving test has to be performed in various plies of adhesive as per agreement between the manufacturer and customer		

4.4 SVEZA DRAWER plywood stock is accounted for in cubic meters. One sheet's volume is calculated without regard to rounding. The volume of assembled SVEZA DRAWER plywood stacks and batches is calculated with accuracy of 0.001 m³. The area of a single SVEZA DRAWER plywood sheet is calculated with accuracy of 0.01 m², and the area of the sheets in a batch with accuracy of 0.5 m².

4.5 Marking shall be applied using indelible black or green ink on the edge of each SVEZA DRAWER plywood sheet as a stamp or text without margins. Marking must include the following information:

- SVEZA DRAWER plywood type,
- SVEZA DRAWER plywood grade,
- manufacturer (number or name);
- thickness and/or sorter number.

Flat face should not be stamped.

Edge stamp is placed in the corner of the transverse or longitudinal edge.

For the SVEZA DRAWER plywood with a thickness of 5-9 mm the stamp may be placed once for each (1-3) sheet.

Allowable by agreement between the manufacturer and the customer:

- to not mark SVEZA DRAWER plywood sheets;
- to not include additional information in the mandatory marking.

4.6 Packing of SVEZA DRAWER plywood

The SVEZA DRAWER plywood must be packed into 400, 600 and 900 mm high stacks according to grade, size, and thickness.

By agreement between the manufacturer and the customer, the SVEZA DRAWER plywood may be packed in stacks of a height other than that specified.

The SVEZA DRAWER plywood in the stack must be placed with the grain running in the same direction.

The SVEZA DRAWER plywood in the stack should be placed so that the higher grade should face the top.

4.7 Packing and labeling of ready stacks of SVEZA DRAWER plywood

4.7.1 Packing of the SVEZA DRAWER plywood stacks shall ensure their integrity and preserve the stacks during transportation.

Main packing methods and types are regulated by OOO SVEZA Forest. By agreement of manufacturer with the customer, other types and methods of plywood packing may be used.

4.7.2 Marking of packed SVEZA DRAWER plywood stacks shall be performed with labels. The label text shall be in Russian and/or English, placed on two parallel or perpendicular side strips. Both labels shall bear the same information:

- trademark;
- product designation Birch Plywood SVEZA DRAWER / Фанера SVEZA DRAWER березовая;
- dimensions, plywood thickness and thickness tolerance value (if required);
- plywood grade in accordance with Appendix C;
- plywood grade (INT / FK);
- type of machining used for the plywood face;
- number of sheets in a stack;
- working shift;
- plywood production date;
- emission class;
- order No. as per Special Terms and Conditions (by agreement with the customer);
- Reference document governing the manufacture of SVEZA DRAWER plywood;
- manufacturer name and address;
- certification signs and quality control marks;
- handling signs: “Keep Dry” and “Use No Hooks”;
- barcode (if a data collection terminal (scanner) is available).

For more streamlined storage operations, additional marking may be applied using labels or stencils.

5 ACCEPTANCE REQUIREMENTS

5.1 SVEZA DRAWER plywood must be accepted in lots.

Lot means a certain number of SVEZA DRAWER plywood sheets of the same grade and size.

For each lot, a single supporting document has to be issued, containing the following information:

- trademark;
- manufacturer name and address;
- plywood mark;
- lot size;
- name of the process standard to which the plywood should comply.
- reference document governing the manufacture of SVEZA DRAWER plywood

5.2 The quality and dimensions of SVEZA DRAWER plywood sheets shall be checked by means of selective sampling and testing. In sampling inspection, sheets of SVEZA DRAWER plywood are selected by means of “random” sampling as per GOST 18321 in the quantity stated in Table 5.

Table 5

Lot size	Controlled parameter as per sections herein			
	3.4.1; 3.4.2; 3.4.3; 3.4.4		4.1.2	
	Sample size	Acceptance number	Sample size	Acceptance number
Up to 500	8	1	13	1
501-1200	13	1	20	2
1201-3200	13	1	32	3
3201-10,000	20	2	32	3

5.3 Moisture, shear strength through the adhesive layer, strength in static bending across and along the outer veneers, modulus of elasticity for static bending along and across the grains of the outer plies should be checked for each thickness and number of plies of SVEZA DRAWER plywood at least once per month.

5.4 To check the tensile strength perpendicular to the sheet surface, 1 sheet per 1,000 should be sampled, but not less than 1 sheet per order.

5.5 For the purpose of formaldehyde content and/or emission testing, one SVEZA DRAWER plywood sheet shall be selected from any sampling volume.

Formaldehyde emissions in each emissions group shall be tested at least once every 7 days

5.6 The lot is considered as compliant to the applicable requirements of the standard and are accepted, provided that in the samples:

- the number of SVEZA DRAWER plywood sheets not complying with the standard requirements in terms of dimensions, out-of-squareness, out-of-straightness,

wood defects, and processing defects, shall be less than or equal to the acceptance number established in Table 5;

- all SVEZA DRAWER plywood sheets are free from blisters, ply splitting, or bark patch;

- physical and mechanical parameters are compliant with the ranges set forth in Table 4;

- formaldehyde emissions are compliant with the limits set forth in Table 3.

6 TEST METHODS

6.1 Sampling procedure — as per GOST 9620, GOST 27678, GOST 32155, GOST 30255, [1]—[2], [6].

6.2 SVEZA SVEZA DRAWER plywood length and width are measured at two points parallel to the edges, at least 100 mm from edges with a metal tape measure according to GOST 7502 with a tolerance of 1 mm. The arithmetic mean value of the two measurements is considered the actual length (width) of the sheet.

6.3 SVEZA SVEZA DRAWER plywood thickness is measured at least 25 mm from edges, in the middle of each sheet's face.

The arithmetic mean value of the four measurements is considered the actual thickness of the sheet.

The following devices are used for thickness measurement:

- thickness gauge as per GOST 11358 with the scale division not exceeding 0.1 mm;

- micrometer as per GOST 6507 with the scale division not exceeding 0.1 mm;

Thickness difference in one SVEZA DRAWER plywood sheets defined as the difference between the maximum and the minimum thickness of the four measurements.

6.4 Out-of-squareness of a sheet of SVEZA DRAWER plywood

6.4.1 Out-of-squareness of SVEZA DRAWER plywood sheet shall be measured as per GOST 30427. The out-of-squareness shall be measured with an L-square as per GOST 3749. Out-of-squareness is defined by measuring the maximum deviation of the sheet edges from the L-square surface using a metal ruler in accordance with GOST 427 with a tolerance of 1 mm.

6.4.2 Out-of-squareness may be also determined by the difference of diagonal lines of the sheet measured by metal tape measure as per GOST 7502 with the scale division 1 mm.

6.5 Out-of-straightness of a SVEZA DRAWER plywood sheet's edges shall be determined by measuring the maximum gap between the sheet's edge and the edge of the metal ruler using a feeler gauge according to GOST 8925 with an error of 0.2 mm.

6.6 Warping shall be checked with a ruler as per GOST 427 placed over the diagonal of the SVEZA DRAWER plywood sheet on a level horizontal surface, and

measurement of maximum deflection with a feeler gauge as per GOST 8925 with an error of 1 mm.

6.7 Moisture — GOST 9621, [3].

6.8 Shear strength through adhesive layer — as per GOST 9624, [4].

6.9 Strength and modulus of elasticity in static bending — per GOST 9625, [5].

6.10 Formaldehyde content complies with GOST 27678 (this method is used as a reference), and formaldehyde emissions into the environment comply with GOST 30255, GOST 32155 and [1].

6.11 Tensile strength perpendicular to the panel surface as per [6].

6.12 Surface roughness — as per GOST 15612.

6.13 Measurement of wood flaws and processing defects as per GOST 30427 and GOST 2140.

7 TRANSPORTATION AND STORAGE

7.1 SVEZA DRAWER plywood should be transported in enclosed vehicles according to the haulage rules applicable to the respective means of transport.

Contact with moisture should be avoided during transportation in order to avoid changes in geometry, physical parameters and quality of the SVEZA DRAWER plywood, and in order to keep the emission class stable.

7.2 Storage of SVEZA DRAWER plywood

The SVEZA DRAWER plywood must be stored indoor in stacks placed horizontally on pallets or on wooden shims, at a temperature between $-40\text{ }^{\circ}\text{C}$ and $+50\text{ }^{\circ}\text{C}$ and relative humidity up to 80%.

8 MANUFACTURER'S WARRANTY

The manufacturer guarantees conformance of SVEZA DRAWER plywood to the quality requirements hereby if transportation and storage conditions are satisfied.

The INT/ FK grade SVEZA DRAWER plywood guaranteed shelf life is 3 years following the day of receipt by customer.

If the SVEZA DRAWER plywood is to be used for further processing, it is recommended to contact the manufacturer for more details about the properties and specifications of the plywood.

9 SAFETY AND ENVIRONMENTAL REQUIREMENTS

9.1 The content of hazardous chemicals emitted into residential or public building air during use of SVEZA DRAWER plywood products must not exceed requirements under items [7], [8].

9.2 Requirements [9] for products manufactured using SVEZA Drawer plywood shall be achieved by manufacturing solutions and protective coatings by furniture products manufacturers.

9.3 SVEZA DRAWER plywood must be produced using materials and components approved by the national sanitary and epidemiological inspection authorities.

9.4 Only persons age 18 and older with a clean bill of health are allowed to work in SVEZA DRAWER plywood production. Medical examinations are conducted according to the applicable instructions from the Ministry of Health of the Russian Federation.

9.5 Personnel engaged in SVEZA DRAWER plywood manufacturing must be provided with personal protective equipment according to the applicable regulations under GOST 12.4.011.

9.6 Specific activity of Cesium 137 in SVEZA DRAWER plywood must not exceed health standards set forth in [10].

9.7 The standard SVEZA DRAWER plywood composition does not include raw materials or components classified as hazardous waste.

9.8 SVEZA DRAWER plywood usually has a long service life, and there are a number of ways to recycle it. SVEZA DRAWER plywood must be recycled taking into account the ordinances regarding recycling in the effective laws of various countries.

APPENDIX A
(mandatory)

**Limit values for wood flaws and processing defects — as per GOST 30427 for outer plies
of SVEZA DRAWER plywood**

Limit values for wood flaws and processing defects as per GOST 30427 for outer plies of SVEZA DRAWER plywood are presented in Table A.1

Table A.1

WOOD FLAWS AND PROCESSING DEFECTS	B (I)	BBx (II)	BB (II)	CP (III)	C (IV)
1. Pin knots	allowable				
2. Sound knots, intergrown, light and dark	allowable: up to 15 mm in diameter, with cracks up to 0.5 mm wide, no more than 5 per m ²	Allowable: up to 25 mm in diameter with cracks up to 1 mm wide, no more than 10 per m ²		allowable: with a crack up to 1.5 mm in width	allowable
3. Partially intergrown knots	allowed within the number of par. 4 of this appendix, up to 6 mm in diameter, 3 per m ² maximum	intergrown knots up to 15 mm in diameter, 10 per m ² maximum — allowed			allowable: any number with diameters up to 40 mm
4. Black knots, loose knots, knot holes (no bark inclusions)	allowed, including intergrown knots up to 6 mm in diameter, 3 per m ² maximum		allowed, including intergrown knots up to 6 mm in diameter, 6 per m ² maximum	allowable: any number with a diameter up to 6 mm	allowable: any number with diameters up to 40 mm (bark patches up to 5 mm wide are allowed near the knot)

Appendix A — continued

WOOD FLAWS AND PROCESSING DEFECTS	B (I)	BBx (II)	BB (II)	CP (III)	C (IV)
5. Close cracks	allowable: up to 5 per meter of the sheet width, up to 200 mm long	allowable: up to 5 per meter of the sheet width, up to 300 mm long		allowable: cracks along the edge and middle	
6. Open cracks, open seam on spliced veneer	not allowable	allowable: up to 3 per meter of the sheet width, up to 200 mm long and up to 2 mm wide	allowable: no more than 3 per meter of the sheet width, up to 250 mm long and up to 2 mm wide	allowable: up to 600 mm long and up to 2 mm wide, no more than 2 per meter of the sheet width + allowable: up to 600 mm long and up to 5 mm wide, provided these are filled with sealing agents	allowable: up 800 mm long and up to 10 mm wide, no limitation on number
7. Timber structure flaws (diagonal grain, swirly grain, burls, bud traces)	allowable				
8. Timber structure flaws (light/dark inner inbark)	only light inbark is allowable; dark inbark is allowable in a number and size corresponding to the number of black knots	light inbark allowable; dark inbark allowable within the dimensions of intergrown knots			
9. Timber structure flaws (surface inbark)	allowable: with the total number under the black knot requirements				
10. Sound discoloration (false heartwood)	not allowable	allowable: up to 25 % of the surface		allowable	

Appendix A — continued

WOOD FLAWS AND PROCESSING DEFECTS	B (I)	BBx (II)	BB (II)	CP (III)	C (IV)
11. Heavy discoloration (stains, streaks, streak traces)	allowable: light, up to 15 % of the sheet surface area	Allowable: up to 250 mm long and up to 10 mm wide, no more than 10 per m ²	allowable		
12. Heavy discoloration (grouped streaks)	allowable: light, up to 15 % of the sheet surface area	allowable: up to 60 x 40 mm, no more than 1 per m ²	allowable		
13. Chemical colorations, sap stains (blue and colored sap stains), discoloration after storage of wood without compromising the wood integrity	up to 30 % of the surface — allowable	allowable: in the number of clause 10 of this appendix, less than 50 % of the sheet surface area	allowable		
14. Biological damage (wormholes)	allowable within the total number under the black knot requirements				
15. Discoloration with partial wood integrity damage	not allowable				
16. Knot and hole patching, using wood inserts before pressing	not allowable		allowable only with oval-shaped inserts, no more than 8 inserts per m ² , provided that the timber color and grain direction are similar to those of the face layer	allowable only with oval-shaped inserts, with a 1 mm gap on one side or a 0.5 mm gap on both sides	allowable only with oval-shaped inserts

Appendix A — continued

WOOD FLAWS AND PROCESSING DEFECTS	B (I)	BBx (II)	BB (II)	CP (III)	C (IV)
17. Double insert (Double patch)	not allowable		allowable: no more than 1 per m ²	allowable only with oval-shaped inserts	
18. Open crack patching, using sealing agents or veneer patches	not allowable				
19. Faceplate bulges (imprinted)	not allowable	allowable: up to 3 mm wide, no more than 3 per sheet		allowable: up to 5 mm wide, no more than 5 per sheet	allowable
20. Overlaps	not allowable	allowable: up to 1 per meter of the sheet width, up to 100 mm long and up to 2 mm wide		allowable: up to 2 per meter of the sheet width, up to 300 mm long and up to 2 mm wide	allowable
21. Stains from manufacturing (beam traces, strips)	not allowable	allowable: up to 10 % of the surface		allowable	
22. Glue staining	not allowable	allowable: up to 2 % of the surface		allowable: up to 5 % of the surface	allowable
23. Mechanical damage (cuts, holes)	allowable within the total number under the black knot requirements				
24. Scratches, ribs, blows, ridges	not allowable			allowable: up to 120 mm long, 10 mm wide and 0.5 mm in height (depth)	allowable

Appendix A — end

WOOD FLAWS AND PROCESSING DEFECTS	B (I)	BBx (II)	BB (II)	CP (III)	C (IV)
25. Warping	not considered for plywood up to 6.5 mm thick; no more than 15 mm per 1 m of the plywood sheet diagonal length is allowable for plywood more than 6.5 mm thick				
26. Presence of glue line	not allowable			allowable	
27. Blisters, delamination (also when bent), bark patches	not allowable				
28. Unsanded stains (nonuniform sanding)	not allowable			allowable: up to 50 % of surface	
29. Oversanding of face plies	not allowable			allowable: up to 1 % of the surface	allowable
30. Metal inclusions	not allowable			brackets of non-ferrous metals are allowable	
31. Edge defects caused by trimming, missing veneer	not allowable	allowable: no more than 2 mm			allowable: no more than 10 mm
32. Rough peeling	not allowable	allowable: up to 5 % of the surface		allowable: up to 15 % of the surface	allowable
33. Waviness (for sanded plywood), saw cut roughness, rippling	not allowable			allowable	
34. Surface roughness	roughness parameter R_m up to 100 (μm) per GOST 7016				
35. Pockets (no bark inclusions)	not allowable	allowable, within the total number under the requirements of par. 12 of this appendix		allowable	
36. Glued veneer particles	not allowable			allowable: up to 150 mm long and 30 mm wide, no more than 1 per sheet	allowable

Note: Any defects not specified in Appendix A are not allowable

**APPENDIX B
(mandatory)**

**Terms and definitions of processing defects of the outer plies of SVEZA
DRAWER plywood**

Terms and definitions of processing defects of external plies of the SVEZA DRAWER plywood are specified in Table B.1

Table B.1

Name of the processing defect	Description
Glued veneer particles	Veneer particles glued to or pressed into plywood surface
Rough peeling	Dense small surface recessions caused by local removal of wood during peeling
Pocket	a cavity in the wood or between annual rings filled with resin or gum

APPENDIX C
(mandatory)

Grade designators of SVEZA DRAWER plywood

Grade designation of SVEZA DRAWER plywood is presented in Table C.1

Table C.1

Latin Letters	Roman Numerals	Text on the label in the “Grade” column
B/B	I/I	DR B/B (I/I)
B/BB	I/II	DR B/BB (I/II)
B/BBx	I/II	DR B/BBx (I/II)
B/CP	I/III	DR B/CP (I/III)
B/C	I/IV	DR B/C (I/IV)
BB/BB	II/II	DR BB/BB (II/II)
BB/BBx	II/II	DR BB/BBx (II/II)
BBx/BBx	II/II	DR BBx/BBx (II/II)
BB/CP	II/III	DR BB/CP (II/III)
BBx/CP	II/III	DR BBx/CP (II/III)
BB/C	II/IV	DR BB/C (II/IV)
BBx/C	II/IV	DR BBx/C (II/IV)
CP/CP	III/III	DR CP/CP (III/III)
CP/C	III/IV	DR CP/C (III/IV)

References

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UDC 674-415:006.354

IKS 79.060.10

OKPD 2 16.21.12.119

Keywords: corporate standard, SVEZA DRAWER birch plywood, dimensions, technical requirements, packaging, labeling, quality control methods, transportation, storage, warranty.

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