

English Version

**Plywood - Classification by surface appearance - Part 4:
Parameters of ability for finishing, guideline**

Contreplaqué - Classification selon l'aspect des faces -
Partie 4: Paramètres d'aptitude à la finition, guide

Sperrholz - Klassifizierung nach dem Aussehen der
Oberfläche - Teil 4: Einflussgrößen auf die Eignung zur
Oberflächenbehandlung, Leitfaden

This Technical Specification (CEN/TS) was approved by CEN on 14 July 2007 for provisional application.

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Foreword

This document (CEN/TS 635-4:2007) has been prepared by Technical Committee CEN/TC 112 "Wood-based panels", the secretariat of which is held by DIN.

This document is one of a series for the classification of plywood by surface appearance. The other parts of this series are listed in Clause 2.

This document supersedes ENV 635-4:1996.

Compared to ENV 635-4:1996 the following changes have been made:

- the deliverability has been changed from ENV to CEN/TS. No technical changes have been made.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to announce this Technical Specification: Austria, Belgium, Bulgaria, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

Introduction

Properties specific to plywood can affect the quality of surface finishes and should be taken into account for determining the surface appearance and integrity in both the long and short term together with the required durability.

The information is presented only as a guide for the end user aimed at maximising the lifespan of plywood panels. As this document covers only general situations, the end user is advised to refer to additional documentation for specific products and/or specific situations.

1 Scope

This document gives guidance for the end user on the selection of plywood for application of various finishes for use in dry, humid, or exterior end-use conditions.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 314-2, *Plywood — Bonding quality — Part 2: Requirements*

EN 635-1, *Plywood — Classification by surface appearance — Part 1: General*

EN 635-2, *Plywood — Classification by surface appearance — Part 2: Hardwood*

EN 635-3, *Plywood — Classification by surface appearance — Part 3: Softwood*

EN 636, *Plywood — Specifications*

3 General

The following criteria should be considered in applying a finishing to plywood to achieve a panel of the desired appearance and durability:

- the intended end-use and service condition (dry, humid or exterior);
- the wood species and appearance class(es) of the surface(s);
- the lay-up of the panel, and the quality of the first inner ply, which could affect the quality of the finish;
- the type of finishing, e.g. varnish, paint, wood stain, or an overlay.

In some situations different criteria can apply.

Indications given in Tables 1, 2 and 3 should be considered as minimum requirements.

4 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

4.1

finish

chemical formulation applied to a surface in one or more coats which turn into a solid film, either by solvent evaporation or chemical reaction

NOTE Three groups are generally considered which differ by their formulation and properties.

4.1.1

varnish

product which, when applied to a substrate, forms a solid transparent film having protective, decorative or other specific technical properties

NOTE Its appearance can be glossy, satin or matt.