

Rotary cut birch veneer grading rules.

Description of defects	A	B	C	D
Black pin knots (with diameter less or equal to 5 mm)	Not allowed	Allowed not more than 3 knots per square meter.	Allowed	Allowed
Sound knots	Allowed with diameter not more than 3 mm	Allowed with diameter not more than 15 mm not more than 3 knots per square meter without cracks	Allowed without cracks wider than 1,5 mm.	Allowed
Firm black knots	Not allowed	Allowed with diameter not more than 6 mm not more than 3 knots per square meter	Allowed with diameter up to 40 mm.	Allowed
Loose, decayed, falling out knots and knot holes	Not allowed	Allowed with diameter not more than 5 mm not more than 3 knots per square meter	Allowed with diameter not more than 20 mm	Allowed
Checks	Not allowed	Allowed maximum 20 mm long	Allowed maximum 200 mm long	Allowed
Sound discoloration	Not allowed	Allowed on the surface not more than 5% of a sheet	Allowed	Allowed
Unhealthy discoloration	Not allowed	Not allowed	Allowed not more than 20% of a sheet	Allowed
Sound false heart	Not allowed	Allowed on the surface not more than 5% of a sheet	Allowed	Allowed
Rot, bark	Not allowed	Not allowed	Not allowed	Not allowed
Worn holes, chemical discoloration	Not allowed	Not allowed	No allowed	Allowed
Mineral streaks	Allowed with maximum size 2*30 mm	Allowed with maximum size 4*60 mm	Allowed	Allowed
Peeling scratches and strips	Not allowed	Allowed not deep no more than 4 per sheet	Allowed	Allowed

Most common combinations of grades:

AB grade as mixture of grades A and B is used as thick face veneer for plywood or as thin veneer from 0,3 mm up to 0,8 mm for lamination.

ABCD grade as mixture of all grades (Mill Run) is most effective combination for production of fully birch plywood.

CD grade as mixture of grades C and D is used for thick veneer from 1 mm up to 2 mm mainly as core veneer.