

Filmfaced plywood grades

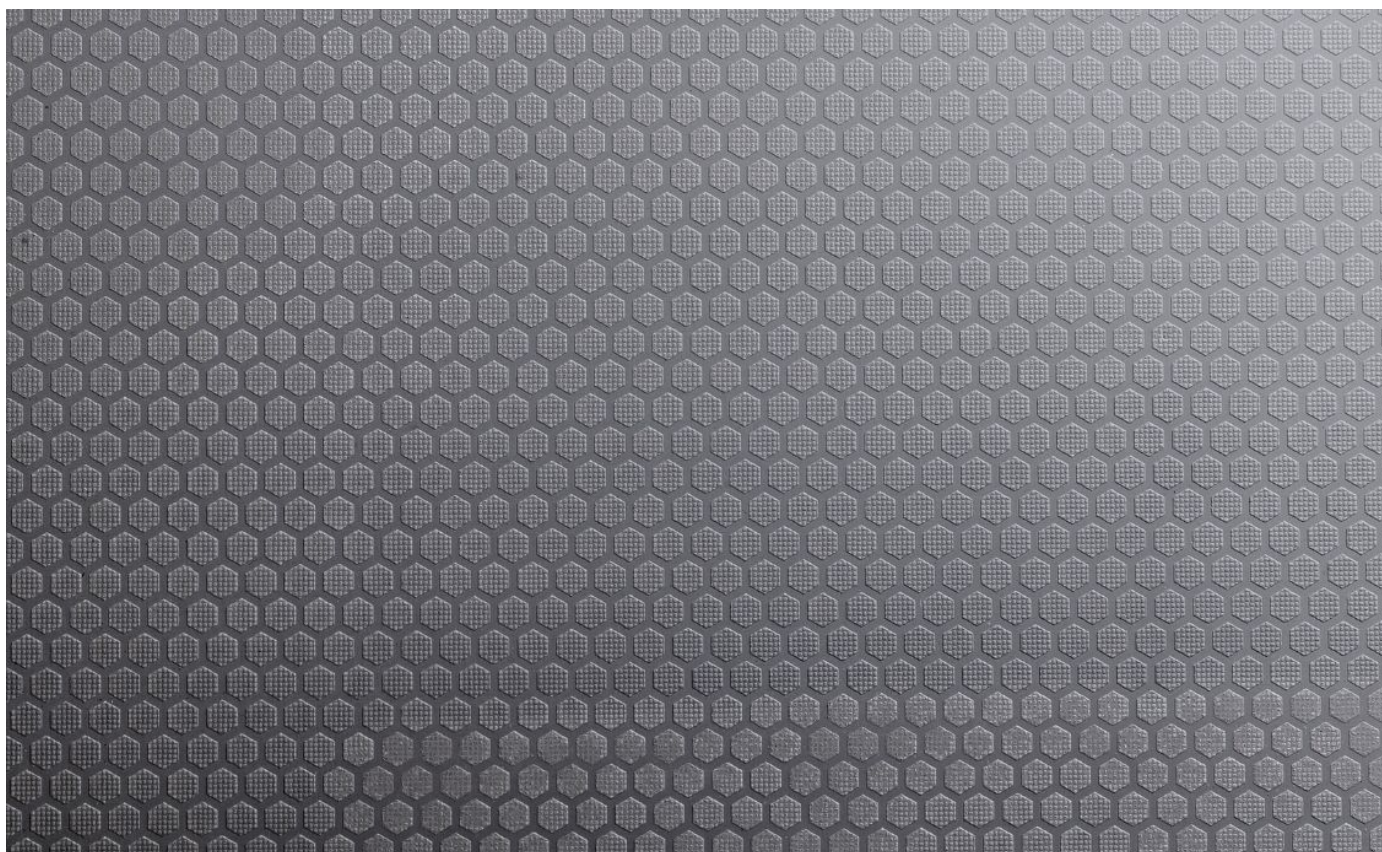
The quality grade of filmfaced plywood is defined by type and quantity of visible defects.

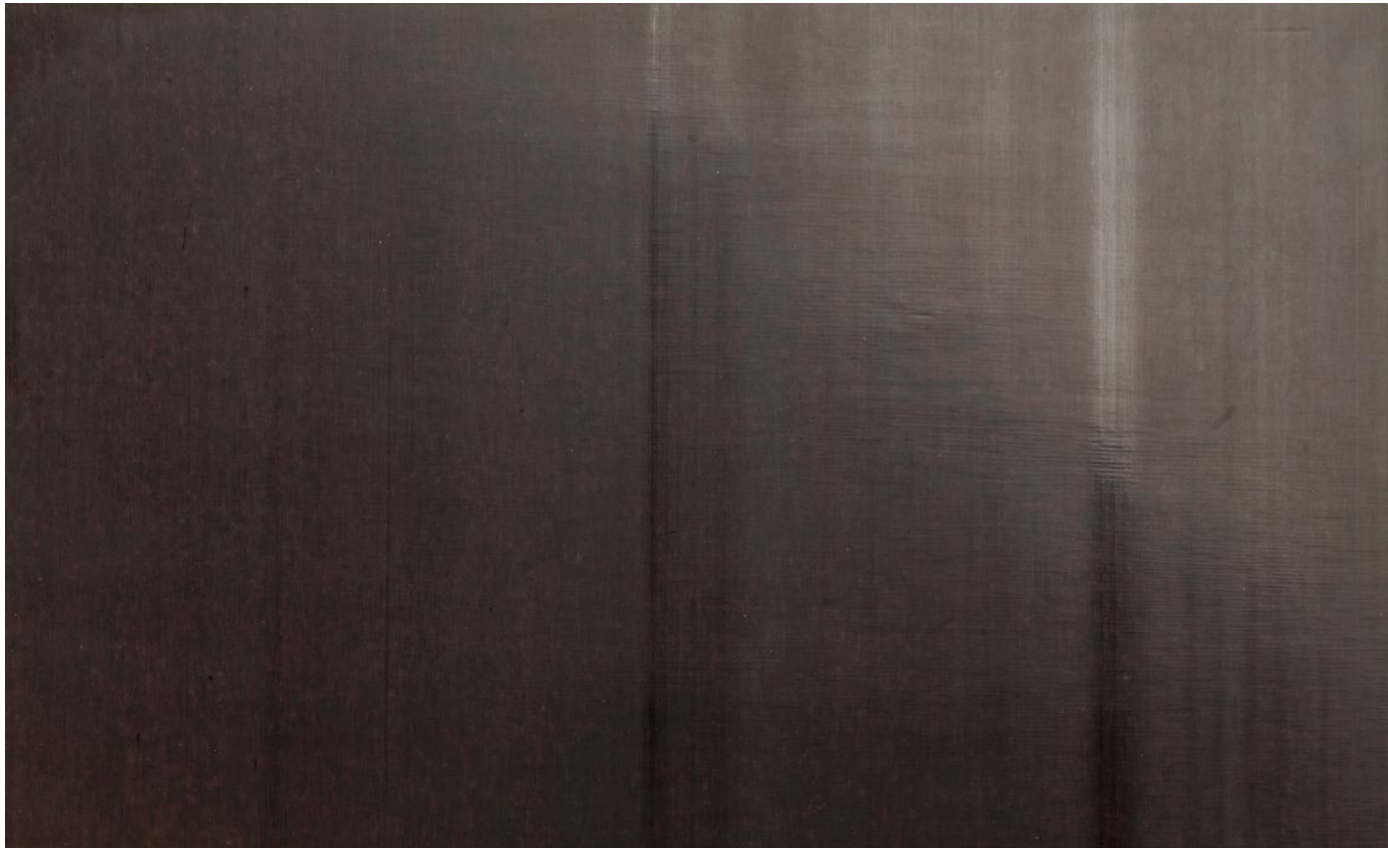
The limitations described refer to the following Riga Wood filmfaced plywood products:

FORM	PATTERNS	COLORED
TEX		TRANSPARENT
Riga Form (dark brown, black)	Riga Heksa Plus	Riga Form (light brown, silver grey etc.)
Riga Tex (dark brown, black)	Riga Heksa	Riga Mel
	Riga Trans	Riga Preprime
	Riga Dot	Riga Paint
	Riga Foot	
	Riga Diamond	
	Riga Rhomb	
	Riga Smooth Mesh	
	Riga Superwire	
	Riga Frost	
	Riga Timber	

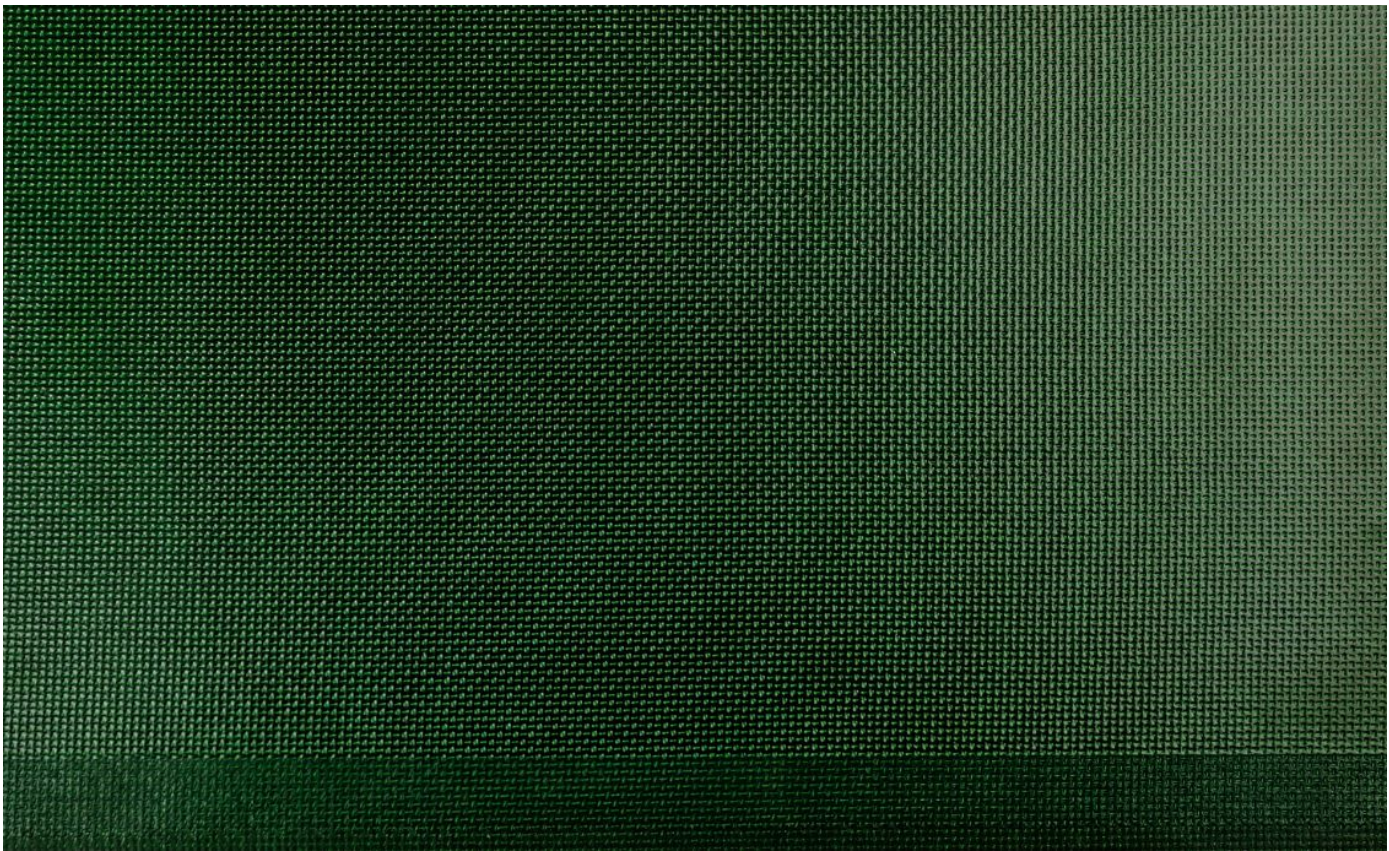
☒ Permitted
 ☒ Not permitted
 ☐ Not applicable

GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Damaged pattern, uneven pattern			
A			
I	 Strips: 10 mm in width, 1 pc/width m; Spots: Ø 30 mm, 1 pc/m² or unlimited, if Ø 10 mm	 Strips: 5 mm in width, 1 pc/width m; Spots: Ø 20 mm, 1 pc/m² or unlimited, if Ø 10 mm	
II			



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Diffuse strips on surface (variations in color tone or gloss)			
A	 If grade A on both faces, permitted minor on one face	 Permitted minor on reverse face	 If grade A on both faces, permitted minor on one face
I	 Minor	 Minor	 Minor
II			
			

GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Displacement of wire mesh or pattern			
A			
I			
II			



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Edge sealing paint on laminated surface			
A	✓ ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even	✓ ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even	✓ ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even
I	✓ ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even	✓ ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even	✓ ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even
II	✓	✓	✓



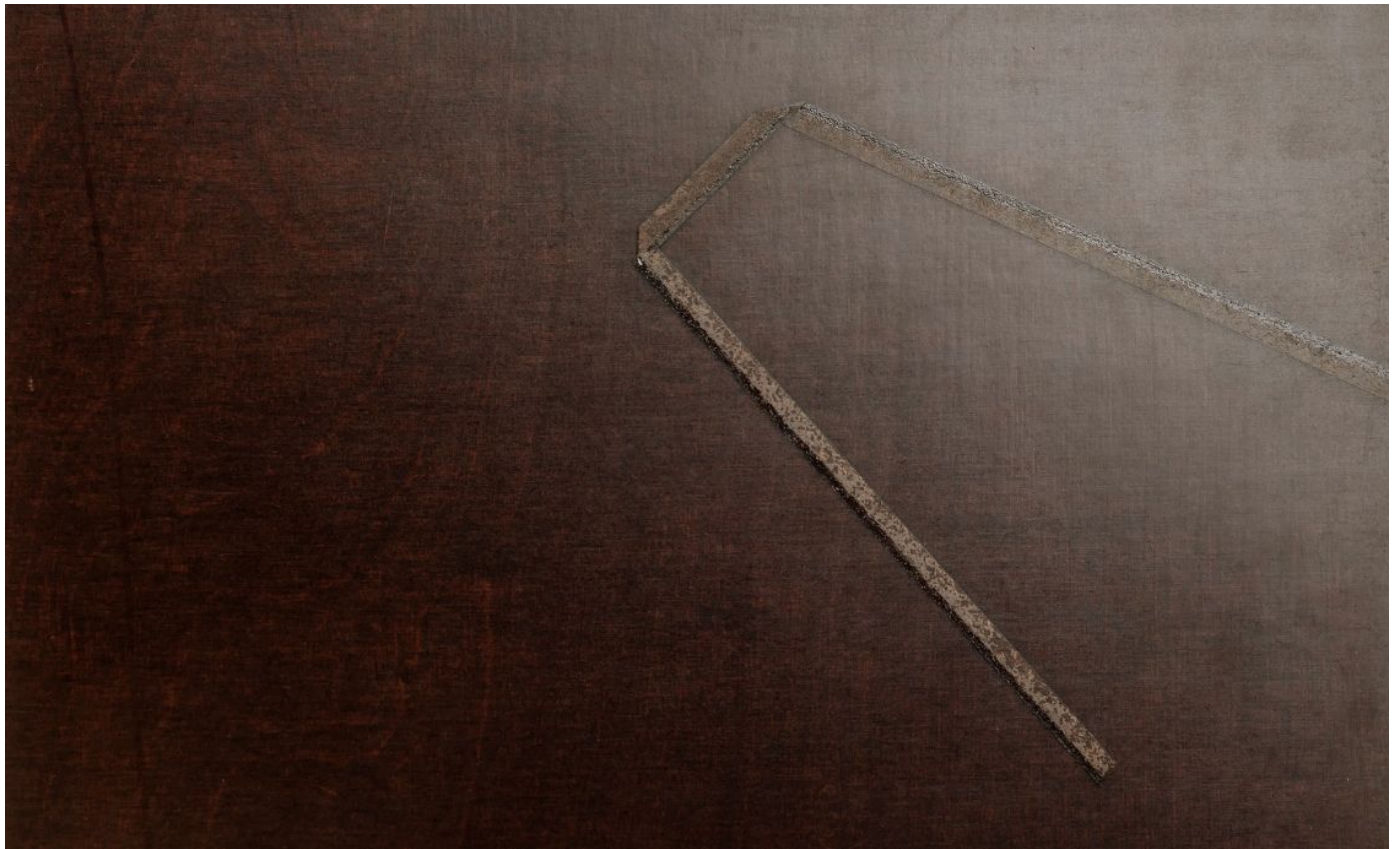
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Film folds			
A			
I	 10% of surface area		
II			



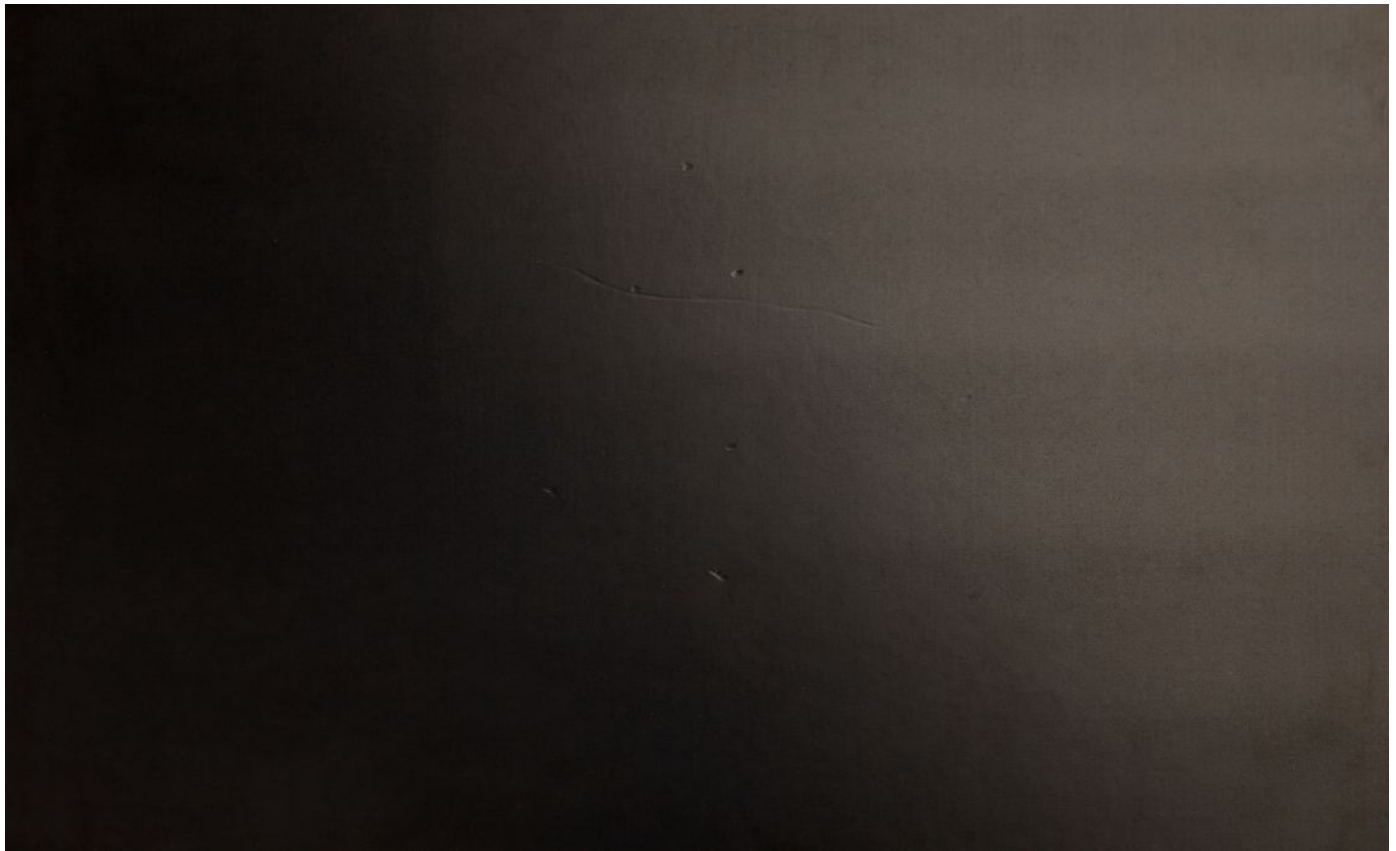
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Film overlaps as dark strips			
A	 If grade A on both faces, permitted on one face firmly glued 10 mm in width	 On pattern face. Permitted on reverse face firmly glued 10 mm in width	 If grade A on both faces, permitted on one face firmly glued 10 mm in width
I	 Without limitations firmly glued 20 mm in width	 On pattern face. Permitted on reverse face firmly glued 20 mm in width	 If grade I on both faces, permitted on one face firmly glued 20 mm in width
II			



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Glued laminate residues on the surface			
A	 If grade A on both faces, permitted on one face: 3 pcs, if residues are (1 cm²) in the same color as surface	 Permitted on reverse face: 3 pcs, if residues are (1 cm²) in the same color as surface	 If grade A on both faces, permitted on one face: 3 pcs, if residues are (1 cm²) in the same color as surface
I	 10 cm²/m² if residues are in the same color as surface	 10 cm²/m² if residues are in the same color as surface	 10 cm²/m² if residues are in the same color as surface
II			



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Imprints, if film is not damaged			
A	 If grade A on both faces, permitted on one face: 1 cm²/m², if the width of an imprint 3 mm and the sum of the length 30 mm/m²	 Permitted on reverse face: 1 cm²/m² if the width of an imprint 3 mm and the sum of the length 30 mm/m²	 If grade A on both faces, permitted on one face: 1 cm²/m², if the width of an imprint 3 mm and the sum of the length 30 mm/m²
I	 2.5 cm²/m², if the width of an imprint 5 mm and the sum of the length 50 mm/m²	 2.5 cm²/m², if the width of an imprint 5 mm and the sum of the length 50 mm/m²	 2.5 cm²/m², if the width of an imprint 5 mm and the sum of the length 50 mm/m²
II			



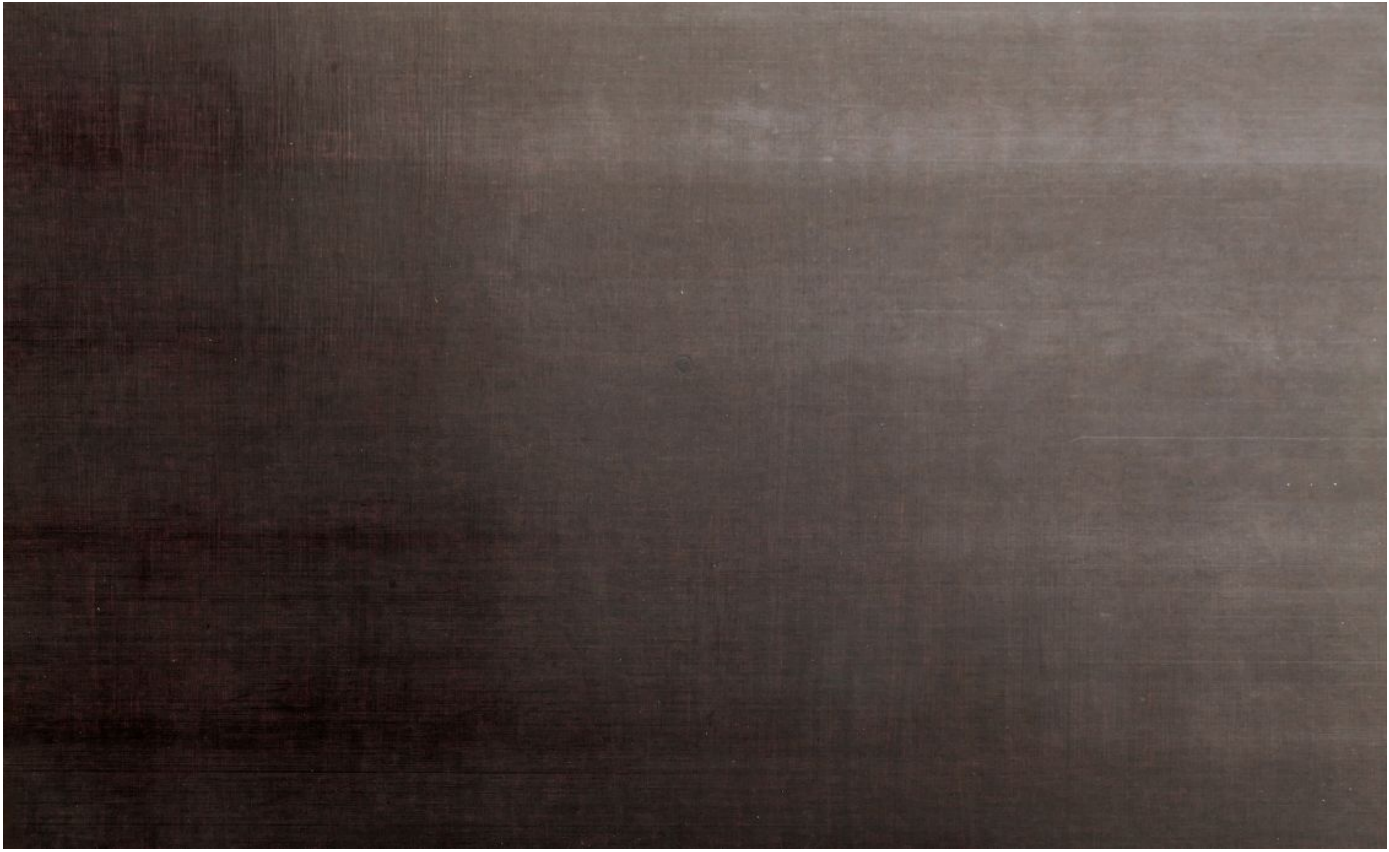
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Lack of film or film delamination after laminating			
A			
I			
II	 On a 1/3 of the sheet on one face	 On a 1/3 of the sheet on one face	 On a 1/3 of the sheet on one face



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Lack of veneer on edges			
A			
I	 Permitted in one layer of veneer with a depth 3 mm. Edges shall be firm if standard size	 Permitted in one layer of veneer with a depth 3 mm. Edges shall be firm if standard size	 Permitted in one layer of veneer with a depth 3 mm. Edges shall be firm if standard size
II	 Edges shall be firm	 Edges shall be firm	 Saplākšņa malām jābūt stingrām



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Matt surface			
A			
I	 > 50% of surface area		
II			



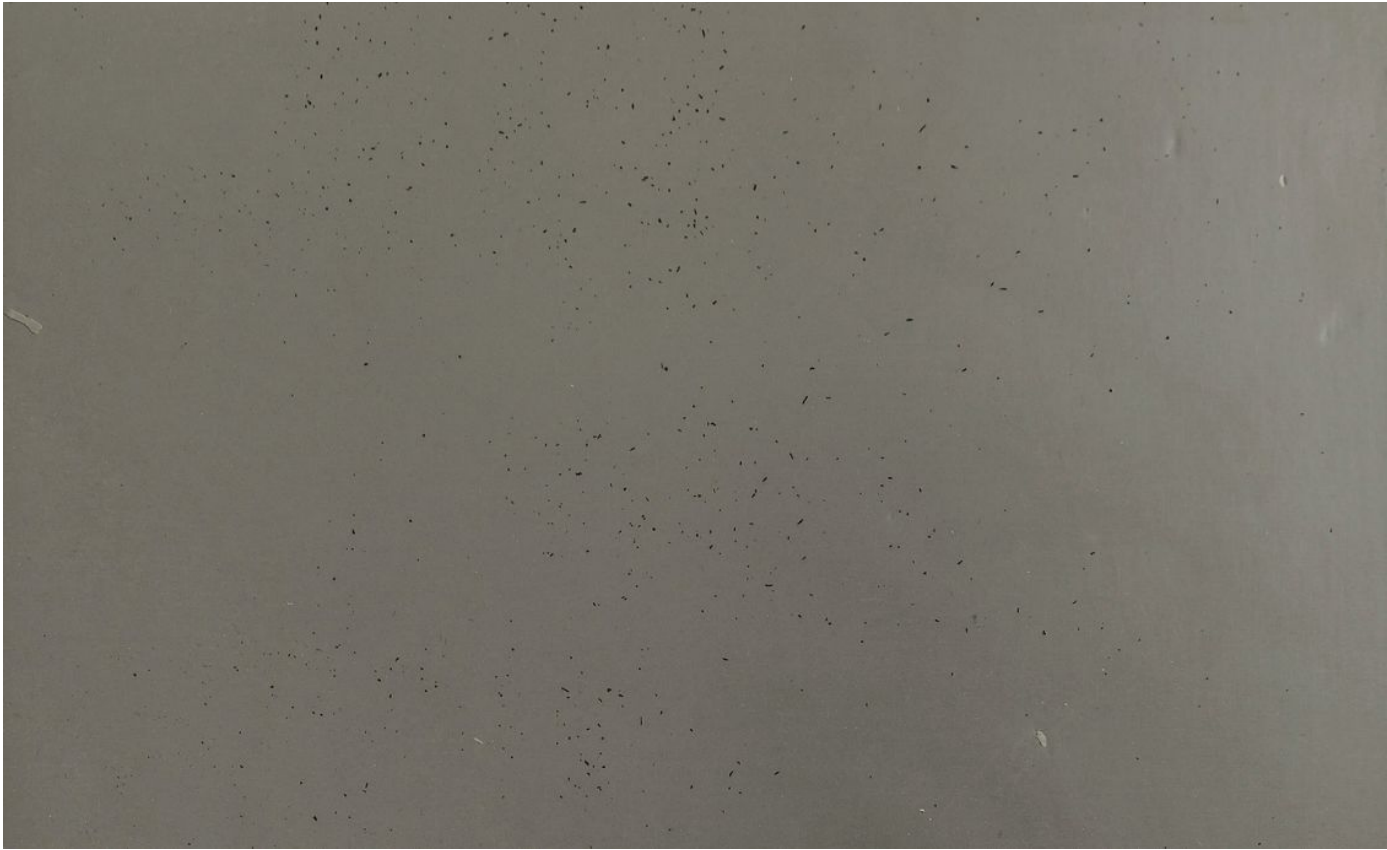
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Mechanical defects			
A			
I			
II			
			

GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Minor rough spots			
A	 If grade A on both faces, permitted on one face: 25 cm² over the surface, with separate spots 5 cm²	 Permitted on reverse face: 25 cm² over the surface, with separate spots 5 cm²	 If grade A on both faces, permitted on one face: 25 cm² over the surface, with separate spots 5 cm²
I	 125 cm² over the surface	 125cm² over the surface	 125cm² over the surface
II			

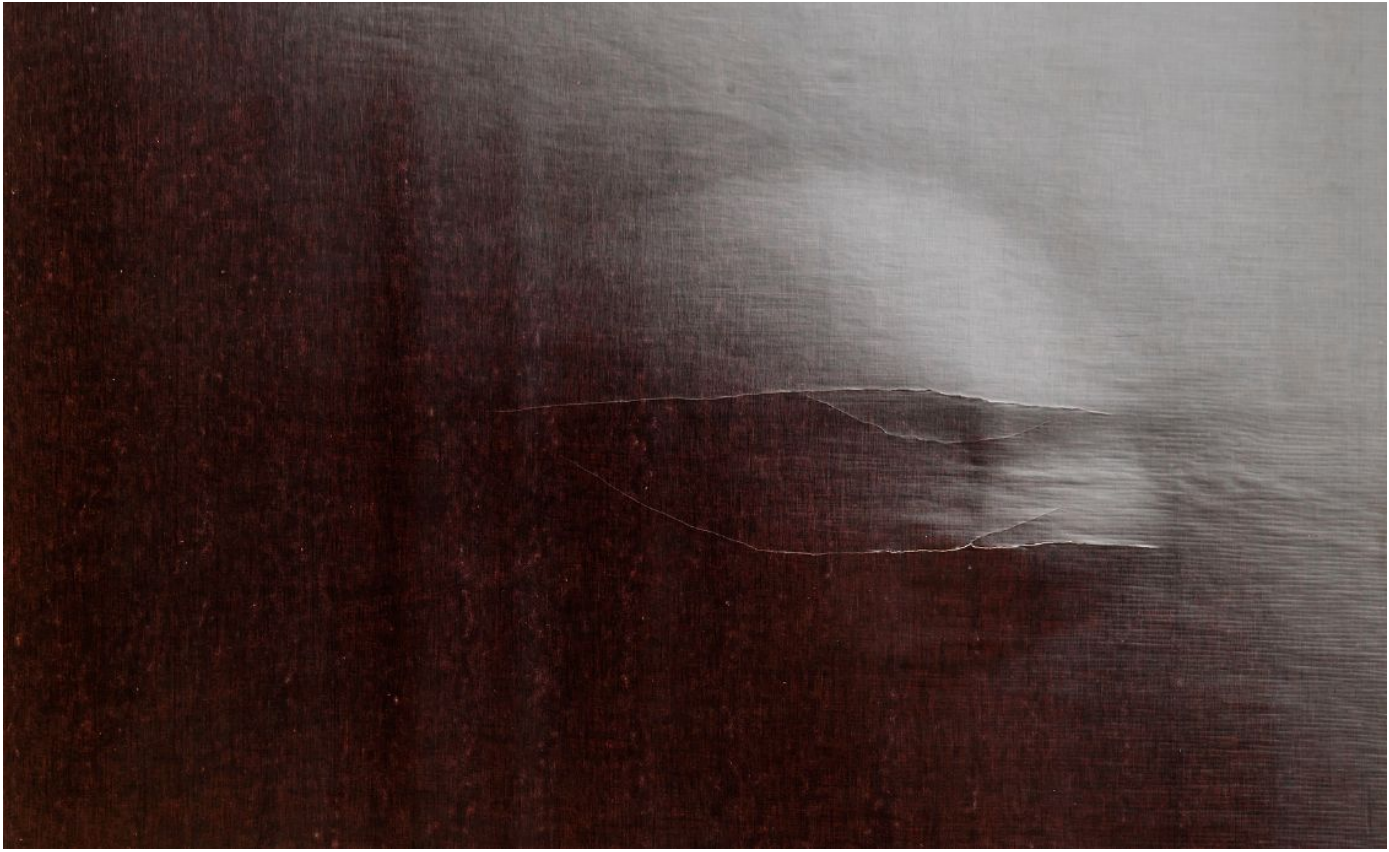


GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Notches			
A			
I			
II	 One with a length 10 cm	 One with a length 10 cm	 One with a length 10 cm
			

GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Other color dust pressed on the surface			
A	 If grade A on both faces, permitted on one face: 5% of surface area	 Permitted on reverse face: 5% of surface area	 If grade A on both sides, then permitted on one side: 5% of surface area
I	 10% of surface area	 10% of surface area	 10% of surface area
II			



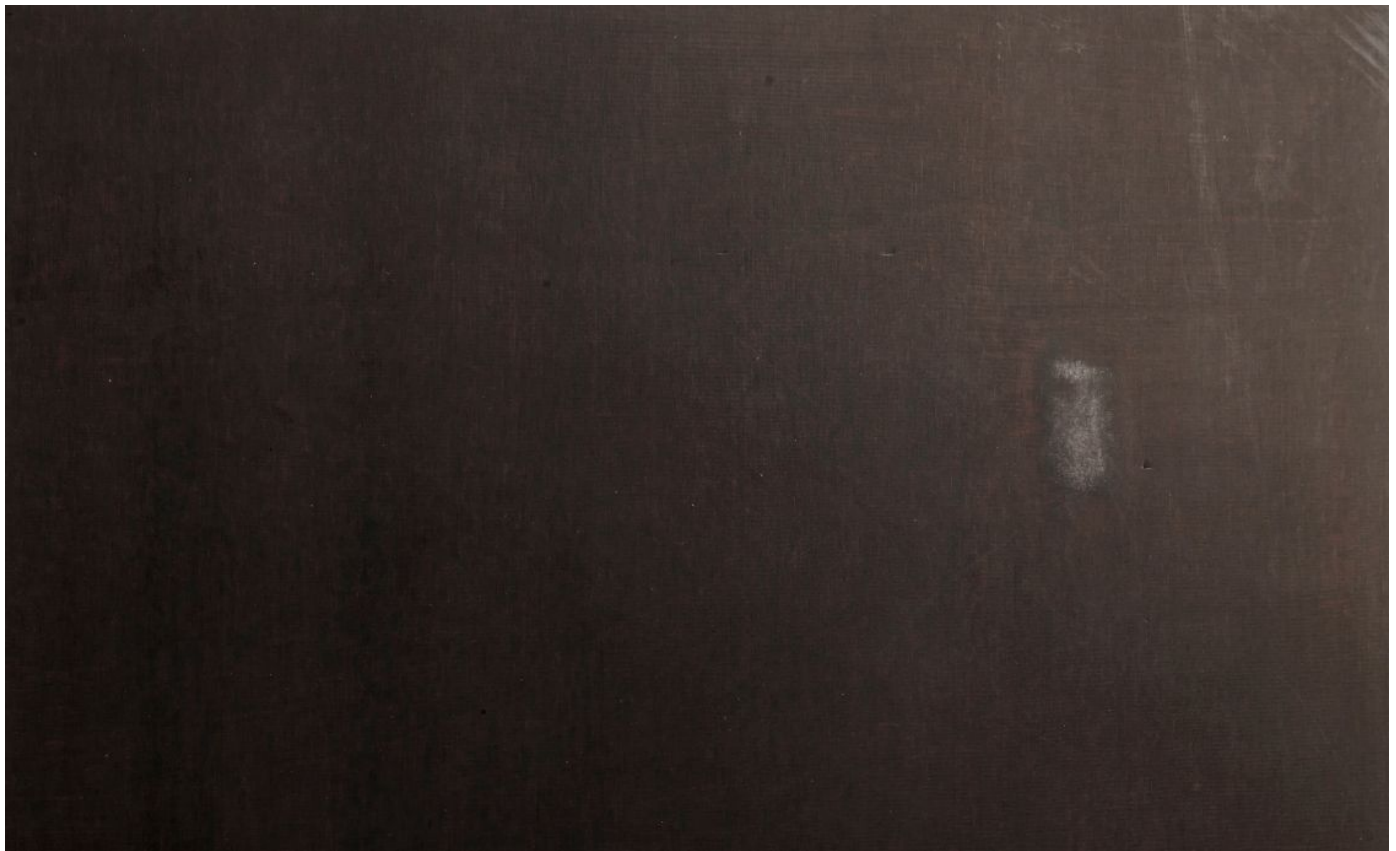
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Plywood delamination			
A			
I			
II	 100 cm²/m²	 100 cm²/m²	 100 cm²/m²



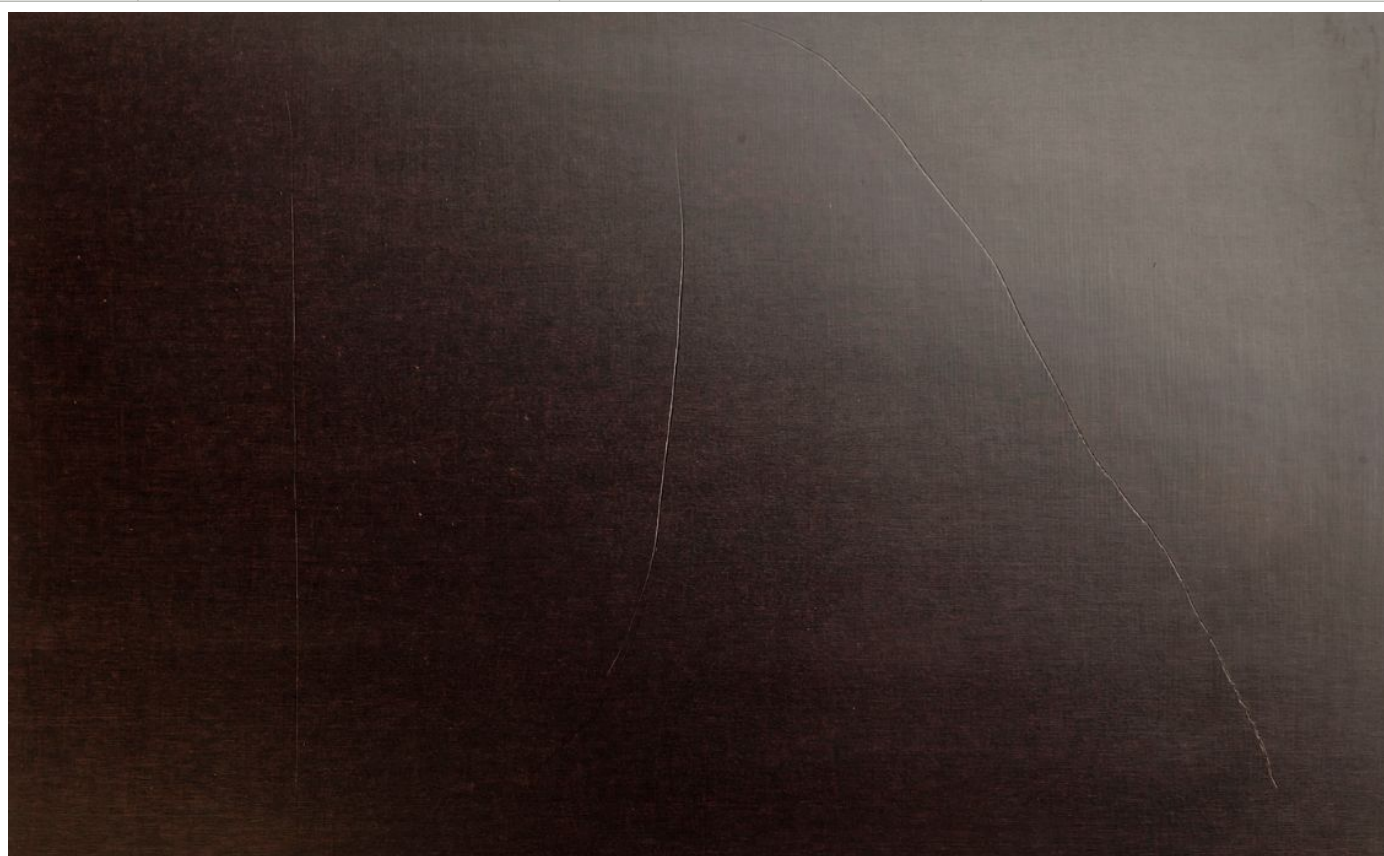
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Ridges, bumps			
A	 If grade A on both faces, permitted on one face. Spots: Ø 15 mm, 1 pc/m² or unlimited, if Ø 5 mm	 Permitted on reverse face. Spots: Ø 10 mm, 1 pc/m² or unlimited, if Ø 5 mm	 If grade A on both faces, permitted on one face. Spots: Ø 10 mm, 1 pc/m² or unlimited, if Ø 5 mm
I	 Strips: 10 mm in width, 300 mm in length and 1 pc/width m; 5 mm in width, unlimited length, 1 pc/width m. Spots: Ø 20 mm, 1 pc/m² or unlimited, if Ø 10 mm	 Strips: 5 mm in width, 300 mm in length and 1 pc/width m; 3 mm in width, unlimited length, 1 pc/width m. Spots: Ø 15 mm, 1 pc/m² or unlimited, if Ø 5 mm	 Strips: 3 mm in width, 200 mm in length and 1 pc/width m. Spots: Ø 15 mm, 1 pc/m² or unlimited, if Ø 5 mm
II			



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Scorched laminate as strips and spots			
A	 If grade A on both faces, permitted on one face: Strips: 5 mm in width, 1 pc/width m; Spots: Ø 20 mm, 1 pc/m² or unlimited, if Ø 10 mm	 Permitted on reverse face: Strips: 5 mm in width, 1 pc/width m; Spots: Ø20mm, 1 pc/m² or unlimited, if Ø10mm	 If grade A on both faces, permitted on one face: Strips: 5 mm in width, 1 pc/width m; Spots: Ø 20 mm, 1 pc/m² or unlimited, if Ø 10 mm
I	 Strips: 10 mm in width, 1 pc/width m; Spots: Ø 30 mm, 1 pc/m² or unlimited, if Ø 10 mm	 Strips: 10 mm in width, 1 pc/width m; Spots: Ø 30 mm, 1 pc/m² or unlimited, if Ø 10 mm	 Strips: 10 mm in width, 1 pc/width m; Spots: Ø 30 mm, 1 pc/m² or unlimited, if Ø 10 mm
II			



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Scratches			
A	 If grade A on both faces, permitted minor scratches on one face (2 pcs), if the laminate is not scratched through	 Permitted minor scratches on reverse face (2 pcs), if the laminate is not scratched through	 If grade A on both faces, permitted minor scratches on one face (2 pcs), if the laminate is not scratched through
I	 If the laminate is not scratched through	 If the laminate is not scratched through	 If the laminate is not scratched through
II			



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Total number of defects			
A	There shall be no defects on one face. Reverse face 2 categories of defects	There shall be no defects on one face. Reverse face 2 categories of defects	There shall be no defects on one face. Reverse face 2 categories of defects
I	One face 2 categories of defects. Reverse face 5 categories of defects	One face 2 categories of defects. Reverse face 5 categories of defects	One face 2 categories of defects. Reverse face 5 categories of defects
II	Unlimited	Unlimited	Unlimited

* If the machined panel is smaller than the minimum unit defined in the table (1 m², 1 meter of width), then from the point of view of quality assessment its size shall be equated to 1 m² or 1 meter of width.

* The provided information is for reference only. Wood is a living material, therefore each panel is unique and differences are possible.

* Please note that the table will be regularly updated. The latest version will always be available on www.finieris.com website.