



Characteristics	Industrial quality (I)	Industrial plus quality (I+)	Visible quality (S)
Application area	The purely constructive solid wood panels are planked with other materials.	Visible components for industrial and commercial buildings, but not recommended for residential areas.	The solid wood panel is suitable for the visible living area.
Offer	Class 1	Class 2	Class 3
Lamination width top layer	Max. 250 mm	Max. 250 mm	≤ 150 mm
Wood moisture	12 % (+/- 2 %)	12 % (+/- 2 %)	10 % (+/- 2 %)
Wood type	Spruce, fir and pine allowed	One wood typ in the top layer	One wood typ in the top layer
Edge gluing (in all layers)	Complete, acceptably joints up to max. 3 mm	Complete	Complete
Bluing, discolouration	Unlimited	≤ 20 % of surface	≤ 5 % of surface
Resin galls	Permitted	Permitted	Permitted
Ingrown bark	Permitted	Permitted	not permitted
Rough edge	max. 2 x 50 cm	Not permitted	Not permitted
Pith	Permitted	Permitted	Permitted individually
Insect damage	Insect holes permitted up to average 2 mm	Not permitted	Not permitted
Branches grown firmly together	Unlimited	Permitted	Permitted
Black branches	Unlimited	≤ 30 mm permitted	≤ 15 mm permitted
Branches fallen out	Unlimited	≤ 30 mm permitted	≤ 15 mm permitted
Revision work	Calibrated and planed	Calibrated and sanded	Sanded fibre course
Crack formation	Limited acc. to strength grading	Limited acc. to strength grading	Permitted individually
	As with all structural timber products, cracks and joints resulting from drying out to later equilibrium moisture content levels applicable at the time of use are product-specific and cannot be avoided.		