

Association of the European Planing Mill Industry

VEH Edition Special

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Quality guidelines for planed profiles.



§6 Grading according to timber quality characteristics

- (1) Planed profiles are divided into two quality categories and labelled as 'VEH A' or 'VEH B'. Planed profiles which do not correspond to these grading specifications are identified as class C (no VEH label).
- (2) Mixed grading is permitted. In any subsequent inspection, at least 60 pieces of every 100 pieces in a row have to conform to grade VEH A (for VEH Top) and at least 30 pieces of every 100 pieces in a row have to conform to grade A (for VEH AB); any other cases must be assigned to grade VEH B. In this instance, inspection of fewer than 100 pieces shall not be allowed.
- (3) VEH grade designation:

Designation	Proportion of grade	
	A	B
VEH A	100%	–
VEH Top	60%	40%
VEH AB	30%	70%
VEH B	–	100%

4.2. Planed profiles for outdoor areas

§16 Grading specifications for planed profiles in outdoor areas according to VEH quality regulations 2015 (terrace/façade)

- (1) The grading specifications apply to all kinds of softwood varieties and in particular to spruce, fir, pine, larch, Douglas fir, abbreviated as follows:

Sp.....spruce

Th.....Thermowood

Pi.....pine

La.....larch

Do.....Douglas fir

- (2) For hardwood planed profiles, the following standards apply mutatis mutandis:

EN 14915

EN 13629

- (3) Origin: European and Nordic/Siberian

VEH A	VEH B
Knots	
<p>✓ permitted Completely intergrown healthy knots of any number Size max. 25% of board or moulded board width.</p> <p>Partly intergrown, bark-surrounded and dead knots up to 1 per running metre; any distribution along the length of the board allowed.</p> <p>Size up to 20% of board width. Black pin knots up to a diameter of 5 mm are permitted and are not taken into account. In the case of boards made from rift-sawn or semi-rift sawn wood, the aforementioned knot sizes apply +20 mm.</p> <p>⊘ not permitted Loose and fallen-out knots. End-grain dowel not permitted.</p>	<p>✓ permitted Completely intergrown knots, partly intergrown knots, bark-surrounded knots of any number. Splay knots and dead (not intergrown) knots up to 1 per running metre; any distribution along the length of the board allowed. Black pin knots of up to 5 mm diameter are permitted and are not taken into account.</p> <p>b > 100 mm: knot size max. 10% of board or moulded board width +40 mm. b < 100 mm: knot size max. 60% of board or moulded board width.</p> <p>⊘ not permitted Loose and fallen-out knots. End-grain dowel not permitted.</p>
Chipped-off parts and incorrectly machined areas	
<p>✓ permitted In max. 15% of goods chipped-off parts or fallen-out knots up to max. 15 mm diameter.</p>	<p>✓ permitted Chipped-off parts or fallen out knots up to max. 30 mm diameter.</p>

VEH A	VEH B
Compression wood (boxwood)	
<p>✓ permitted So long as overall impression is not impaired.</p>	<p>✓ permitted</p>
Distortion	
<p>✓ permitted Bowed and twisted boards, as long as expert laying is still ensured</p>	<p>✓ permitted Bowed and twisted boards, as long as expert laying is still ensured</p>
Resin pockets	
<p>✓ permitted Size up to 3 mm x 40 mm or area of 120 mm². Number: up to 1 per running metre, any distribution along the length of the board allowed.</p> <p>Resin pockets up to 1 mm x 20 mm are not taken into account.</p>	<p>✓ permitted Size up to 5 mm x 60 mm or area of 300 mm². Number: up to 3 per running metre, any distribution along the length of the board allowed.</p> <p>Resin pockets up to 3 mm x 40 mm are not taken into account.</p>

VEH A	VEH B
Fissures (cracks)	
<p>✓ permitted Interrupted surface cracks on the visible surface (hair cracks). In max. 20% of goods, traversing end cracks not longer than the board width.</p> <p>⊘ not permitted Ring shakes</p>	<p>✓ permitted Interrupted surface cracks on the visible surface. Traversing end cracks, not longer than 1.5 times the width of the piece.</p> <p>⊘ not permitted Ring shakes</p>
Pith	
<p>✓ permitted In max. 15% of the goods, on the visible surface up to a maximum of 30% of board length and 5 mm width.</p>	<p>✓ permitted</p>
Colour	
<p>✓ permitted Discolouring on the back of the board. Slight discolouring on the visible side in max. 30% of goods. Sapwood is not classed as discolouration.</p>	<p>✓ permitted Slight discolouring on the visible surface (e.g. red and blue stains). Discolouring on the back of the board. With Siberian larch: slight colour differences (e.g. water marks). Sapwood is not classed as discolouration.</p>

VEH A	VEH B
Sapwood	
<p>✓ permitted Visible side virtually sapwood-free. On reverse up to 50% of board width in up to max. 30% of goods.</p>	<p>✓ permitted On the reverse, the heartwood must extend at least across the entire length of the board. Max. 30% of visible surface in max. 50% of goods.</p>
Fungal attack	
<p>⊘ not permitted Exceptions, see point 'Colour', p.22.</p>	<p>⊘ not permitted Exceptions, see point 'Colour', p.22.</p>
Insect attack	
<p>⊘ not permitted</p>	<p>⊘ not permitted</p>
Wane	
<p>✓ permitted On the reverse, as long as expert laying is still ensured.</p> <p>⊘ not permitted On the visible side.</p>	<p>✓ permitted On the reverse, as long as expert laying is still ensured.</p> <p>⊘ not permitted On the visible side.</p>
Bark pockets	
<p>⊘ not permitted</p>	<p>✓ permitted Knot sized or corresponding size in mm².</p>