

**Designation of sorting grades of the
Association of the European Planing Mill Industry**

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

Sorting specifications	VEH A, spruce and fir (European, Nordic)	VEH B, spruce and fir (European, Nordic)
Knots	<p>permitted: Any number of completely intergrown knots, up to a size of 1/4 of the width of the profiled board maximum. Intergrown knots up to a diameter of max 15 mm.</p> <p>Black pin knots up to a diameter of 5 mm (also in groups).</p> <p>not permitted: Loose and fallen-out knots; may for 15% of the goods, however, be plugged with an end-grain dowel made from a branch of the same species of wood. For one metre of length, one end-grain dowel allowed, with any distribution along the board allowed.</p>	<p>permitted: Completely intergrown knots, partly intergrown knots, bark-surrounded knots, splay knots and dead (not intergrown) knots, size up to 10 % of board width + 50 mm.</p> <p>not permitted: Loose and fallen-out knots; they may, however, be plugged with end-grain dowels made from a branch of the same species of wood.</p>
Chipped off parts (incorrectly machined areas)	<p>permitted: In 15% of the goods, unless overlap of two profiled boards is impaired.</p> <p>Size of the chipped-off area in the case of arris knots comparable to a knot with a diameter of 10 mm.</p>	<p>permitted: Size of the chipped-off parts up to 40% of the knot area.</p>
Compression wood	<p>permitted: In 15% of the goods unless overall impression is impaired.</p>	<p>permitted</p>
Crookedness	<p>permitted: Crooked and twisted boards, as long as expert laying is still ensured.</p>	<p>permitted: Crooked and twisted boards, as long as expert laying is still ensured.</p>
Resin galls	<p>permitted: In 15% of the goods, size up to 0,5 x 5 cm or corresponding size in mm².</p> <p>Up to 1 per running metre; any distribution along the length of the board allowed.</p> <p>Resin galls of less than 0.2 x 2 cm are not taken into consideration.</p>	<p>permitted: Size up to 1 x 10 cm or corresponding size in mm².</p> <p>Up to 3 pcs. per running metre; any distribution along the length of the board allowed.</p> <p>Resin galls up to 0.3 x 3 cm are not taken into consideration.</p>
Cracks	<p>permitted: In 15% of the goods; interrupted surface cracks (hair cracks) on the visible surface.</p> <p>Traversing end cracks must not be longer than 30 mm. In 20% of the goods, continuous end cracks not longer than the width of the piece.</p> <p>not permitted: ring shakes</p>	<p>permitted: Interrupted surface cracks on the visible surface.</p> <p>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 15% of the goods, on the visible surface up to a maximum of 15% of board length and 4 mm width.</p>	<p>permitted</p>
Colour	<p>permitted:</p> <p>Discolouring on the back of the board.</p> <p>not permitted: Discolouring on the visible surface.</p>	<p>permitted: Slight discolouring on the visible surface (e.g. red and blue stains). Discolouring on the back of the board.</p>
Fungal decay	<p>not permitted: For exception see colour.</p>	<p>permitted: Hard red stripe; size see colour.</p> <p>not permitted: Other fungal decay, exception see colour.</p>
Insect infestation	<p>not permitted</p>	<p>not permitted</p>
Tree edge	<p>permitted: On the back side, if tongue and groove are not affected.</p>	<p>permitted: On the back of the board if on 3/4 of the length tongue and groove are not affected .</p>
Bark pockets	<p>permitted: In 15% of the goods, size up to a diameter of 15 mm or corresponding size in mm².</p>	<p>permitted: Knot sized or corresponding size in mm².</p>

Sorting specifications	VEH A, larch (European, Siberian)	VEH B, larch (European, Siberian)
Knots	<p>permitted: Any number of completely intergrown, healthy knots, size max. 1/4 of profiled board width.</p> <p>Partly intergrown knots, knots surrounded by bark, and dead knots, size up to 1/5 of profiled board width.</p> <p>Black pin knots up to a diameter of 5 mm (also in groups).</p> <p>not permitted: Loose and fallen-out knots, may for 15% of the goods, however, be plugged with an end-grain dowel made from a branch off the same species of wood. For one metre of length, one end-grain dowel allowed, with any distribution along the board allowed.</p>	<p>permitted: Intergrown knots, partly intergrown knots, bark-surrounded knots, splay knots and dead (not intergrown) knots, size up to 10% of the profiled board width + 50 mm.</p> <p>not permitted: Loose and fallen-out knots, that may, however, be plugged with an end-grain dowel made from a branch of the same species of wood.</p>
Chipped off parts (incorrectly machined areas)	<p>permitted: In 15% of the goods, size of the chipped-off areas in the case of arris knots comparable to a knot with a diameter of 15 mm.</p> <p>Overlap of two profiled boards must not be impaired in the case of arris knots.</p>	<p>permitted: Size of the chipped-off parts up to 40% of the knot area.</p> <p>Overlap of two profiled boards must not be impaired in the case of arris knots.</p>
Compression wood	<p>permitted: In 15% of the goods, unless overall impression is impaired.</p>	<p>permitted</p>
Crookedness	<p>permitted: Crooked and twisted boards, as long as expert laying is still ensured.</p>	<p>permitted: Crooked and twisted boards, as long as expert laying is still ensured.</p>
Resin galls	<p>permitted: In 15% of the goods, size up to 0,5 x 5 cm or corresponding size in mm².</p> <p>Up to 1 per running metre; any distribution along the length of the board allowed.</p> <p>Resin galls of less than 0.3 x 3 cm are not taken into consideration.</p>	<p>permitted: Size up to 1 x 10 cm or corresponding size in mm².</p> <p>Up to 3 pcs. per running metre; any distribution along the length of the board allowed.</p> <p>Resin galls up to 0.3 x 3 cm are not taken into consideration.</p>
Cracks	<p>permitted: In 15% of the goods, interrupted surface cracks (hair cracks) on the visible surface.</p> <p>Traversing end cracks must not be longer than 30 mm. in 40% of the goods; continuous end cracks not longer than the width of the piece.</p> <p>not permitted: ring shakes</p>	<p>permitted: Interrupted surface cracks on the visible surface.</p> <p>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 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:</p> <p>Discolouring on the back of the board.</p> <p>In Siberian larch: slight colour differences (e.g. water stains).</p> <p>not permitted: Discolouring on the visible surface.</p>	<p>permitted: Slight discolouring on the visible surface (e.g. red and blue stains).</p> <p>Discolouring on the back of the board. Splint on 1/3 of the visible surface permissible. In Siberian larch: slight colour differences (e.g. water stains).</p>
Splint	<p>permitted: In 15% of the goods, splint on 1/5 of the visible surface.</p> <p>not permitted: Splint on the visible surface of strip flooring.</p>	<p>permitted</p>
Fungal decay	<p>not permitted: For exception see colour.</p>	<p>permitted: Hard red strip; size see colour.</p> <p>not permitted: Other fungal decay, exception see colour.</p>
Insect infestation	<p>not permitted</p>	<p>not permitted</p>
Tree edge	<p>permitted: On the back side, if tongue and groove are not affected.</p>	<p>permitted: On the back of the board if on 3/4 of the length tongue and groove are not affected .</p>
Bark pockets	<p>permitted: In 15% of the goods, size up to a diameter of 15 mm or corresponding size in mm².</p>	<p>permitted: Knot sized or corresponding size in mm².</p>

Sorting specifications	VEH A, pine (European, Siberian and Nordic)	VEH B, pine (European, Siberian and Nordic)
Knots	<p>permitted: Any number of intergrown, healthy knots, size up to 10% of profiled board width + 30 mm diameter.</p> <p>In 50% of the goods, partly intergrown knots up to a maximum of 10% of profiled board width + 30 mm diameters.</p> <p>Black pin knots up to a diameter of 5 mm (also in groups).</p> <p>not permitted: Loose and fallen-out knots, may for 15% of the goods, however, be plugged with an end-grain dowel made from a branch of the same species of wood. Fore one metre of length, one end-grain dowel allowed; with any distribution along the board permitted.</p>	<p>permitted: Intergrown knots, partly intergrown knots, bark-surrounded knots, splay knots and dead (not intergrown) knots, size up to 10% of the profiled board width + 50 mm.</p> <p>not permitted: Loose and fallen-out knots, that may, however, be plugged with an end-grain dowel made from a branch of the same species of wood.</p>
Chipped off parts (incorrectly machined areas)	<p>permitted: In 15% of the goods, size of the chipped-off areas in the case of arris knots comparable to a knot with a diameter of 15 mm.</p> <p>Overlap of two profiled boards must not be impaired in the case of arris knots.</p>	<p>permitted: Size of the chipped-off parts up to 40% of the knot area.</p> <p>Overlap of two profiled boards must not be impaired in the case of arris knots.</p>
Compression wood	<p>permitted: In 15% of the goods, unless overall impression is impaired.</p>	<p>permitted</p>
Crookedness	<p>permitted: Crooked and twisted boards, as long as expert laying is still ensured.</p>	<p>permitted: Crooked and twisted boards, as long as expert laying is still ensured.</p>
Resin galls	<p>permitted: In 15% of the goods, size up to 0,5 x 5 cm or corresponding size in mm².</p> <p>Up to 1 per running metre; any distribution along the length of the board allowed.</p> <p>Resin galls of less than 0.3 x 3 cm are not taken into consideration.</p>	<p>permitted: Size up to 1 x 10 cm or corresponding size in mm².</p> <p>Up to 3 pcs. per running metre; any distribution along the length of the board allowed.</p> <p>Resin galls up to 0.3 x 3 cm are not taken into consideration.</p>
Cracks	<p>permitted: In 15% of the goods, interrupted surface cracks (hair cracks) on the visible surface.</p> <p>Traversing end cracks must not be longer than 30 mm. In 20% of the goods; continuous end cracks not longer than the width of the piece.</p> <p>not permitted: ring shakes</p>	<p>permitted: Interrupted surface cracks on the visible surface.</p> <p>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 25% 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:</p> <p>Discolouring on the back of the board. Lightwood areas around knots.</p> <p>not permitted: Discolouring on the visible surface. Other lightwood on the visible surface.</p>	<p>permitted: Slight discolouring on the visible surface (e.g. red and blue stains). Discolouring on the back of the board. Lightwood boards.</p>
Splint	<p>permitted</p>	<p>permitted</p>
Fungal decay	<p>not permitted: Exception see colour.</p>	<p>permitted: Hard red stripe, size see colour.</p> <p>not permitted: Other fungal decay, exception see colour.</p>
Insect infestation	<p>not permitted</p>	<p>not permitted</p>
Tree edge	<p>permitted: On the back side, if tongue and groove are not affected.</p>	<p>permitted: On the back of the board if on 3/4 of the length tongue and groove are not affected .</p>
Bark pockets	<p>permitted: In 15% of the goods, size up to a diameter of 15 mm or corresponding size in mm².</p>	<p>permitted: Knot sized or corresponding size in mm².</p>

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