

VEH grade designation:

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

§15 Grading specifications for planed profiles in indoor areas (wall/ceiling/flooring)

(1) The grading specifications apply to the following softwood varieties: spruce, fir, pine, larch, Douglas fir, abbreviated as follows:

Sp spruce
Fi fir
Pi pine
La larch
Do Douglas fir

(2) For hardwood planed profiles, the following standards apply mutatis mutandis:
 EN 14951
 EN 13629

(3) Origin: European, Nordic/Siberian

April, 2016

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VEH A	VEH B
Knots	
<p>✓ permitted Completely intergrown healthy knots of any number.</p> <p><i>Sp/Fi</i>: Size max. 25% of board or moulded board width. Intergrowing knots up to max. 15 mm diameter. <i>Pi/Do</i>: Size max. 10% of board width +30 mm. In 50% of goods, partly intergrown knots up to max. 10% of board width +30 mm. <i>La</i>: Size max. 25% of board width. Partly intergrown, bark-surrounded and dead knots, size up to 20% of moulded board width.</p> <p>Black pin knots up to max. 5 mm diameter (incl. in groups).</p> <p>⊘ not permitted Loose and fallen-out knots; in max. 15% of goods, these may be plugged with an end-grain dowel made from the same species of wood (from a branch). For one metre of length, an end-grain dowel is permitted 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 max. 10% of board or moulded board width +50 mm.</p> <p>⊘ not permitted Loose and fallen-out knots; these may be plugged with an end-grain dowel made from the same species of wood (from a branch).</p>
Chipped off parts (incorrectly machined areas)	
<p>✓ permitted In max. 15% of the goods, so long as the overlap of two profiled boards is not impaired. With edge knots, size of the chipped-off area comparable to a knot.</p> <p><i>Sp/Fi</i>: Max. 10 mm diameter <i>Pi/La/Do</i>: Max. 15 mm diameter</p>	<p>✓ permitted Size of the chipped-off parts max. 40% of the knot area. Overlap of two profiled boards must not be impaired in the case of edge knots.</p>
Compression wood (boxwood)	
<p>✓ permitted In max. 15% of the goods, so long as overall impression is not impaired.</p>	<p>✓ permitted</p>
Distortion	
<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 (continuation)	
<p>✓ permitted In 15% of the goods, size up to 5 mm x 50 mm or 250 mm². Up to 1 per running metre; any distribution along the length of the board allowed. The following resin galls are not taken into account: <i>Sp/Fi</i>: 2 mm x 20 mm <i>Pi/La/Do</i>: 3 mm x 30 mm</p>	<p>✓ permitted Size up to 10 mm x 100 mm or corresponding size in mm². Up to 3 pcs per running metre; any distribution along the length of the board allowed. Resin galls up to 3 mm x 30 mm are not taken into consideration.</p>
Cracks	
<p>✓ permitted In 15% of the goods, no continuous surface cracks (hair cracks) on the visible surface. Traversing end cracks must not be longer than 30 mm.</p> <p>Continuous end cracks not longer than the board width with: <i>Sp/Fi/Pi/Do</i>: Max. 20% of goods. <i>La</i>: Max. 40% of goods</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>

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VEH A	VEH B
Pith	
<p>✓ permitted <i>Sp/Fi</i>: In max. 15% of goods, on the visible surface up to max. 15% of board length and 4 mm width. <i>Pi/Do</i>: In max. 25% of goods, on the visible surface up to max. 30% of board length and 5 mm width. <i>La</i>: In max. 15% of goods, on the visible surface up to max. 30% of board length and 5 mm width.</p>	<p>✓ permitted</p>
Colour	
<p>✓ permitted Discolouring on the reverse of the board. <i>Pi/Do</i>: Resinous areas around the knots. <i>La</i>: Slight colour variation (e.g. water marks).</p> <p>⊘ not permitted Discolouring on the visible side. <i>Pi/Do</i>: Other resinous marks on the visible side.</p>	<p>✓ permitted Slight discolouring on the visible surface (e.g. red and blue stains). Discolouring on the back of the board. <i>Pi/Do</i>: Resinous boards <i>La</i>: Slight colour variation due to water marks permitted.</p>
Fungal decay	
<p>⊘ not permitted Exception see 'Colour' point.</p>	<p>✓ permitted Hard red stripe, size see 'Colour' point. ⊘ not permitted Other fungal decay, exception see point 'Colour'.</p>
Insect infestation	
<p>⊘ not permitted</p>	<p>⊘ not permitted</p>
Tree edge	
<p>✓ permitted On the reverse side, if tongue and groove are not affected.</p>	<p>✓ permitted On the reverse of the board if tongue and groove are not affected on 3/4 of the length.</p>
Bark pockets	
<p>✓ permitted In max. 15% of goods, size up to 15 mm diameter or corresponding size in mm².</p>	<p>✓ permitted Knot sized or corresponding size in mm².</p>
Splint	
<p>✓ permitted In max. 15% of goods, splint on up to 20% of visible area.</p>	<p>✓ permitted</p>

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