

VEH grade designation:

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

§17 Grading specifications for planned profiles in indoor areas (wall/ceiling/flooring)

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

Sp spruce
Fi fir
Pi pine
La larch
Do Douglas fir
WRC Western Red Cedar

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

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VEH A	VEH B
Knots	
<p>✓ permitted Completely intergrown healthy knots and splay knots of any number.</p> <p>Sp/Fi: Size max. 25% of board or moulded board width. Intergrown knots up to max. 15 mm diameter.</p> <p>Pi/Do: Size max. 10% of board width +30 mm. In 50% of goods, partly intergrown knots up to max. 10% of board width +30 mm.</p> <p>La: 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>Up to a profile width of 80 mm, completely intergrown healthy knots and splay knots up to 1 piece per running meter across the entire profile width are allowed.</p> <p>✗ not permitted Loose and fallen-out knots.</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>Up to a profile width of 80 mm, completely intergrown healthy knots and splay knots are allowed in any number across the entire profile width.</p> <p>✗ not permitted Loose and fallen-out knots.</p>
Wooden dowel	
<p>✗ not permitted</p>	<p>✓ permitted Loose and fallen-out knots may be filled with a wooden dowel of the same species of wood or filled with a filler.</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>Sp/Fi/WRC: Max. 10 mm diameter Pi/La/Do: 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 3 mm x 30 mm or corresponding size to 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: Sp: 2 mm x 20 mm Pi/La/Do: 3 mm x 30 mm</p>	<p>✓ permitted Size up to 5 mm x 80 mm or corresponding size to 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>

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VEH A	VEH B
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. Continuous end cracks not longer than the board width with: Sp/Fi/Pi/Do/WRC: Max. 20% of goods. La: 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>
Pith	
<p>✓ permitted Sp/Fi/WRC: In max. 15% of goods, on the visible surface up to max. 15% of board length and 4 mm width. Pi/Do: In max. 25% of goods, on the visible surface up to max. 30% of board length and 5 mm width. La: In max. 15% of goods, on the visible surface up to max. 30% of board length and 5 mm width.</p>	<p>✓ permitted</p>
Discolouration	
<p>✓ permitted Reverse of the board. Pi/Do: Resinous areas around the knots. La/WRC: Slight colour variation (e.g. water marks). ✗ not permitted Visible side. Pi/Do: Other resinous marks on the visible side.</p>	<p>✓ permitted Slight discolouring on the visible surface. Discolouring on the back of the board. Pi/Do: Resinous boards La/WRC: Slight colour variation due to water marks permitted.</p>
Discolouration due to fungal decay	
<p>✗ not permitted</p>	<p>✓ permitted Hard red stripe and blue discolouration covering up to 20% of the visible surface. ✗ not permitted Other fungal decay.</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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