

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%

§18 Grading specifications for planed profiles in outdoor areas (terrace/façade)

- (1) The grading specifications apply to all kinds of softwood varieties and in particular to 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 planed profiles, the following standards apply mutatis mutandis:
 EN 14915
 EN 13629

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VEH A	VEH B
Knots	
<p>✓ permitted Completely intergrown healthy knots and splay 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, distributed anywhere along the length of the board, size up to 20% of the board width.</p> <p><i>Pi/La/WRC</i>: 2 per running metre.</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, as well as for wood type pine, the aforementioned knot sizes apply +20 mm.</p> <p>⊘ not permitted Loose and fallen-out knots.</p>	<p>✓ permitted Completely intergrown knots and splay knots, partly intergrown knots, bark-surrounded knots of any number.</p> <p>Partly intergrown splay knots and dead (not intergrown) knots up to 2 pieces per running metre distributed arbitrarily over the board length.</p> <p>Blackpin 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>Up to a profile width of 80 mm, healthy and completely intergrown knots and splay knots are permitted in any number across the entire profile width.</p> <p>⊘ permitted Loose and fallen out knots..</p>
Wooden dowel	
⊘ not permitted	⊘ not permitted
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>
Compression wood (boxwood)	
<p>✓ permitted 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	
<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 galls 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 galls up to 3 mm x 40 mm are not taken into account.</p>

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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 the non-visible surface In max. 15% of the goods, on the visible surface up to a maximum of 30% of board length and up to a maximum of 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. Splint 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). Splint is not classed as discolouration.</p>
Splint	
<p>✓ permitted Visible side virtually splint-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 decay	
<p>⊗ not permitted Exceptions, see point 'Colour'.</p>	<p>⊗ not permitted Exceptions, see point 'Colour'.</p>
Insect infestation	
<p>⊗ not permitted</p>	<p>⊗ not permitted</p>
Tree edge	
<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>

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VEH Quality guidelines for planed profiles
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