

## 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
<b>Knots</b>	
<p><b>✓ permitted</b>  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><b>Pi/La/WRC:</b> 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><b>✗ not permitted</b>  Loose and fallen-out knots.</p>	<p><b>✓ permitted</b>  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><math>b &gt; 100 \text{ mm}</math>: knot size max. 10% of board or moulded board width +40 mm.  <math>b &lt; 100 \text{ mm}</math>: 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><b>✗ not permitted</b>  Loose and fallen out knots..</p>
<b>Wooden dowel</b>	
<b>✗ not permitted</b>	<b>✗ not permitted</b>
<b>Chipped-off parts and incorrectly machined areas</b>	
<p><b>✓ permitted</b>  In max. 15% of goods chipped-off parts or fallen-out knots up to max. 15 mm diameter.</p>	<p><b>✓ permitted</b>  Chipped-off parts or fallen out knots up to max. 30 mm diameter.</p>
<b>Compression wood (boxwood)</b>	
<b>✓ permitted</b> So long as overall impression is not impaired.	<b>✓ permitted</b>
<b>Distortion</b>	
<p><b>✓ permitted</b>  Crooked and twisted boards, as long as expert laying is still ensured.</p>	<p><b>✓ permitted</b>  Crooked and twisted boards, as long as expert laying is still ensured.</p>
<b>Resin galls</b>	
<p><b>✓ permitted</b>  Size up to 3 mm x 40 mm or area of 120 mm<sup>2</sup>. Number: up to 1 per running metre, any distribution along the length of the board allowed.  Resin galls up to 1 mm x 20 mm are not taken into account.</p>	<p><b>✓ permitted</b>  Size up to 5 mm x 60 mm or area of 300 mm<sup>2</sup>. Number: up to 3 per running metre, any distribution along the length of the board allowed.  Resin galls up to 3 mm x 40 mm are not taken into account.</p>

# Planned profiles for outdoor areas

## §18 Grading specifications for planned 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 planned profiles, the following standards apply mutatis mutandis:  
EN 14915  
EN 13629

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VEH A	VEH B
<b>Cracks</b>	
<p><b>✓ permitted</b>  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><b>✗ not permitted</b>  Ring shakes</p>	<p><b>✓ permitted</b>  Interrupted surface cracks on the visible surface. Traversing end cracks, not longer than 1.5 times the width of the piece.</p> <p><b>✗ not permitted</b>  Ring shakes</p>
<b>Pith</b>	
<p><b>✓ permitted in the non-visible surface</b>  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><b>✓ permitted</b></p>
<b>Colour</b>	
<p><b>✓ permitted</b>  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><b>✓ permitted</b>  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>
<b>Splint</b>	
<p><b>✓ permitted</b>  Visible side virtually splint-free.  On reverse up to 50% of board width in up to max. 30% of goods.</p>	<p><b>✓ permitted</b>  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>
<b>Fungal decay</b>	
<p><b>✗ not permitted</b>  Exceptions, see point 'Colour'.</p>	<p><b>✗ not permitted</b>  Exceptions, see point 'Colour'.</p>
<b>Insect infestation</b>	
<p><b>✗ not permitted</b></p>	<p><b>✗ not permitted</b></p>
<b>Tree edge</b>	
<p><b>✓ permitted</b>  On the reverse, as long as expert laying is still ensured.</p> <p><b>✗ not permitted</b>  On the visible side.</p>	<p><b>✓ permitted</b>  On the reverse, as long as expert laying is still ensured.</p> <p><b>✗ not permitted</b>  On the visible side.</p>
<b>Bark pockets</b>	
<p><b>✗ not permitted</b></p>	<p><b>✓ permitted</b>  Knot sized or corresponding size in mm<sup>2</sup>.</p>

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VEH Quality guidelines for planned profiles  
8<sup>th</sup> edition, 2026