

# VENEER GRADING REQUIREMENTS

Grade:	Dead Knot:	Live Knots:	Holes:	Resin Pockets	Wane (Bark)	Splits	Cracks	Patches	Blue Stain	Comments
	Dead branches inside the tree. Most easily recognised by outer ring of dark bark. Fall easily out of veneer.	Knots that were alive at felling. A live knot lacks the dark ring of a dead knot and stays in the veneer more readily.	As the term implies, Holes are holes in the veneer. Most often the result of missing dead knots.	Resin pockets occur when a split inside a tree fills with resin. Seen as a cavity filled or lined with resin.	Wane (bark) brown coloured underbark surface with or without actual bark on any face or edge	Splits are total separation of the fibres in a sheet of veneer eg ripped sheet of veneer. They can cause overlaps.	Cracks are a partial separation of the fibres in a sheet of veneer. They do not cause overlaps.	Patches are machine punched repairs in the veneer sheet to remove suitable defects.	A fungal growth seen as blotchy patches blue to black in colouration.	<b>Width to be measured across the grain</b>
<b>A</b>	No Dead Knots Permitted	No Live Knots Permitted	No Knots Holes Permitted	No Resin Pockets Permitted	No Bark Permitted	Not exceeding 1.5mm across - no longer than 300mm to a point. Must be filled. Not more than 2 per sheet. <b>Unfilled splits not permitted.</b>	Not exceeding 1.5mm across - no longer than 300mm to a point at each end. Must be filled. Not more than 2 per sheet. <b>Unfilled cracks not permitted.</b>	No patches permitted	No Blue stains permitted	To measure for Defects: Imagine a <b>300mm straight line</b> placed anywhere across the width of the veneer, you can have <b>no more than 75mm</b> of defects on that line.
<b>B</b>	No Dead Knots Permitted	Not exceeding 20mm Across. 4 per sheet	Not exceeding 20mm across 4 per sheet.	No Resin Pockets Permitted	No Bark Permitted	Not exceeding 1.5mm across - no longer than 500mm to a point. Must be filled. Not more than 2 per sheet. <b>Unfilled splits not permitted.</b>	Not exceeding 1.5mm across - no longer than 500mm to a point at each end. Must be filled. Not more than 2 per sheet. <b>Unfilled cracks not permitted.</b>	No patches permitted	No Blue stains permitted	To measure for Defects: Imagine a <b>300mm straight line</b> placed anywhere across the width of the veneer, you can have <b>no more than 75mm</b> of defects on that line.
<b>C</b>	Not exceeding 50mm across. NO LIMIT	Not exceeding 50mm across. NO LIMIT	Not exceeding 50mm across. NO LIMIT <b>MUST be filled.</b>	Not exceeding 25mm across. NO LIMIT	Not exceeding 25mm across. NO LIMIT	Not exceeding 9mm across - no longer than half the sheet. Must be filled. No Limit. <b>Unfilled splits not permitted.</b>	No Deep Ridges	Not exceeding 75mm across. NO LIMIT Stacking of 2 patches on top of each other running with the grain is permitted.	Blue stains permitted	To measure for Defects: Imagine a <b>300mm straight line</b> placed anywhere across the width of the veneer, you can have <b>no more than 120mm</b> of defects on that line.
<b>D</b>	Dead Knots permitted No more than <b>120mm</b> in total in a <b>300mm line</b> across the grain. No limit on quantity	Live Knots permitted No more than <b>120mm</b> in total in a <b>300mm line</b> across the grain. No limit on quantity	75mm Across x 200mm Long - <b>Unfilled.</b> NO LIMIT	Resin Pockets permitted No more than <b>120mm</b> in total in a <b>300mm line</b> across the grain No limit on quantity	75mm Across x 200mm Long. NO LIMIT – also 1 x either end @ 120mm across the grain.	5mm across by full sheet, 3 per sheet – Or 15mm across by 1/2 of sheet, - Or 25mm across by 1/3 of sheet. No Limits.	Cracks permitted	Not exceeding 120mm across. NO LIMIT Stacking of 2 patches on top of each other running with the grain is permitted.	Blue stains permitted	To measure for Defects: Imagine a <b>300mm straight line</b> placed anywhere across the width of the veneer, you can have <b>no more than 120mm</b> of defects on that line.
<b>CASE</b>	No Limits	No Limits	No Limits	No Limits	No Limits	No Limits	No Limits	No Limits	No Limits	All sheets that do not meet D Grade. Only to be used in Non-Structural products.