

Plywood — Tolerances for dimensions

The European Standard EN 315:2000 has the status of a
British Standard

ICS 79.060.10

National foreword

This British Standard is the official English language version of EN 315:2000. It supersedes BS EN 315:1993 which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee B/541, Wood based panels, which has the responsibility to:

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Summary of pages

This document comprises a front cover, an inside front cover, the EN title page, pages 2 to 5 and a back cover.

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Amendments issued since publication

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English version

Plywood - Tolerances for dimensions

Contreplaqué - Tolérances sur dimensions

Sperrholz - Maßtoleranzen

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Foreword

This European Standard has been prepared by Technical Committee CEN/TC 112, Wood-based panels, the Secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by January 2001, and conflicting national standards shall be withdrawn at the latest by January 2001.

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This European Standard supersedes EN 315:1993.

Compared to the version EN 315:1993 the following modification has been made:

- Thickness tolerances for panels with a nominal thickness > 25 mm have been added.

1 Scope

This European Standard specifies dimensional tolerances of plywood panels (length, width, thickness) and tolerances for squareness and edge straightness.

NOTE: Some uses of plywood can require narrower tolerances: see specific standards for types or performance standards.

2 Normative references

This European Standard incorporates, by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references, the latest edition of the publication referred to applies.

EN 322, *Wood-based panels – Determination of moisture content*

EN 324-1, *Wood-based panels – Determination of dimensions of boards – Part 1: Determination of thickness, width and length*

EN 324-2, *Wood-based panels – Determination of dimensions of boards – Part 2: Determination of squareness and edge straightness*

3 Moisture content of panels

Moisture content is measured according to EN 322.

Tolerances are fixed with regard to the following moisture content reference: $(10 \pm 2) \%$.

4 Tolerances for length and width

Length and width are measured according to EN 324-1.

Tolerances on nominal size: $\pm 3,5$ mm.

5 Tolerances for thickness

Thickness is measured according to EN 324-1.

Table 1 - Tolerances for thickness

Nominal thickness (<i>t</i>) mm	Unsanded panels		Sanded panels	
	Thickness tolerance within one panel mm	Tolerances on nominal thickness mm	Thickness tolerance within one panel mm	Tolerances on nominal thickness mm
≥ 3	1,0	+ (0,8 + 0,03 <i>t</i>)	0,6	+ (0,2 + 0,03 <i>t</i>)
≤ 12		- (0,4 + 0,03 <i>t</i>)		- (0,4 + 0,03 <i>t</i>)
> 12	1,5	+ (0,8 + 0,03 <i>t</i>)	0,6	+ (0,2 + 0,03 <i>t</i>)
≤ 25		- (0,4 + 0,03 <i>t</i>)		- (0,4 + 0,03 <i>t</i>)
> 25	1,5	+ (0,8 + 0,03 <i>t</i>)	0,8	+ (0,0 + 0,05 <i>t</i>)
≤ 30		- (0,4 + 0,03 <i>t</i>)		- (0,4 + 0,05 <i>t</i>)
> 30	1,5	+ (0,8 + 0,03 <i>t</i>)	0,8	+ (0,0 + 0,03 <i>t</i>)
		- (0,4 + 0,03 <i>t</i>)		- (0,4 + 0,03 <i>t</i>)

6 Tolerance for straightness of edges

The straightness of edges is measured according to EN 324-2.

Tolerance: 1 mm/m.

7 Tolerance for squareness

Squareness is measured according to EN 324-2.

Tolerance: 1 mm/m.

Bibliography

EN 326-1, *Wood-based panels – Sampling, cutting and inspection – Part 1: Sampling and cutting of test pieces and expression of test results*

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