
INTERNATIONAL STANDARD



1072

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Solid wood parquet – General characteristics

Parquet en bois massif – Caractéristiques générales

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FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO Member Bodies). The work of developing International Standards is carried out through ISO Technical Committees. Every Member Body interested in a subject for which a Technical Committee has been set up has the right to be represented on that Committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the Technical Committees are circulated to the Member Bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 1072 was drawn up by Technical Committee ISO/TC 99, *Semi-manufacturers of timber*, and circulated to the Member Bodies in September 1973.

It has been approved by the Member Bodies of the following countries :

Austria	Germany	Poland
Bulgaria	Hungary	Romania
Chile	Ireland	South Africa, Rep. of
Czechoslovakia*	Italy	Thailand
Egypt, Arab Rep. of	Netherlands	U.S.S.R.
France	New Zealand	Yugoslavia

* with the exception of sub-clauses 4.1.2 and 4.1.3.

The Member Bodies of the following countries expressed disapproval of the document on technical grounds :

Australia
Norway

This International Standard cancels and replaces ISO Recommendation R 1072-1969, of which it constitutes a technical revision.

Solid wood parquet – General characteristics

1 SCOPE AND FIELD OF APPLICATION

1.1 This International Standard specifies the manufacturing characteristics (cross-section, dimensions, permissible deviations, etc.), the inspection and delivery conditions and the marking of solid wood parquet strips with rectangular face of any species of wood.

1.2 The classification according to specific characteristics, wood defects and possible exceptions is laid down, for the different species of wood, in the relevant International Standards.

2 REFERENCES

ISO/R 2036, *Marking of the different species of wood utilized in the manufacture of wood flooring – Code of symbols.*

ISO . . . , *Wood parquet and raw parquet blocks – Terms and definitions.*¹⁾

3 MANUFACTURE

3.1 The finished strips shall have the dimensions and the profile specified in 4.1.

The faces shall be flat. Contiguous faces and edges shall form parallel sharp edges.

The ends shall be perpendicular to the edges within a tolerance of 0,4 %.

3.2 The face shall be smooth and the manufacturing faults limited (see the relevant International Standards for the classification of parquet strips of different wood species).

3.3 Unless otherwise agreed, the strip edges and ends should have the same profile.

3.4 The joining of the tongues and the grooves, in the case of strips with integrated tongue, shall be done without resistance and without excessive clearance.

3.5 In the case of strips with detachable tongue, the tongue shall enter the groove with a slight resistance and without clearance.

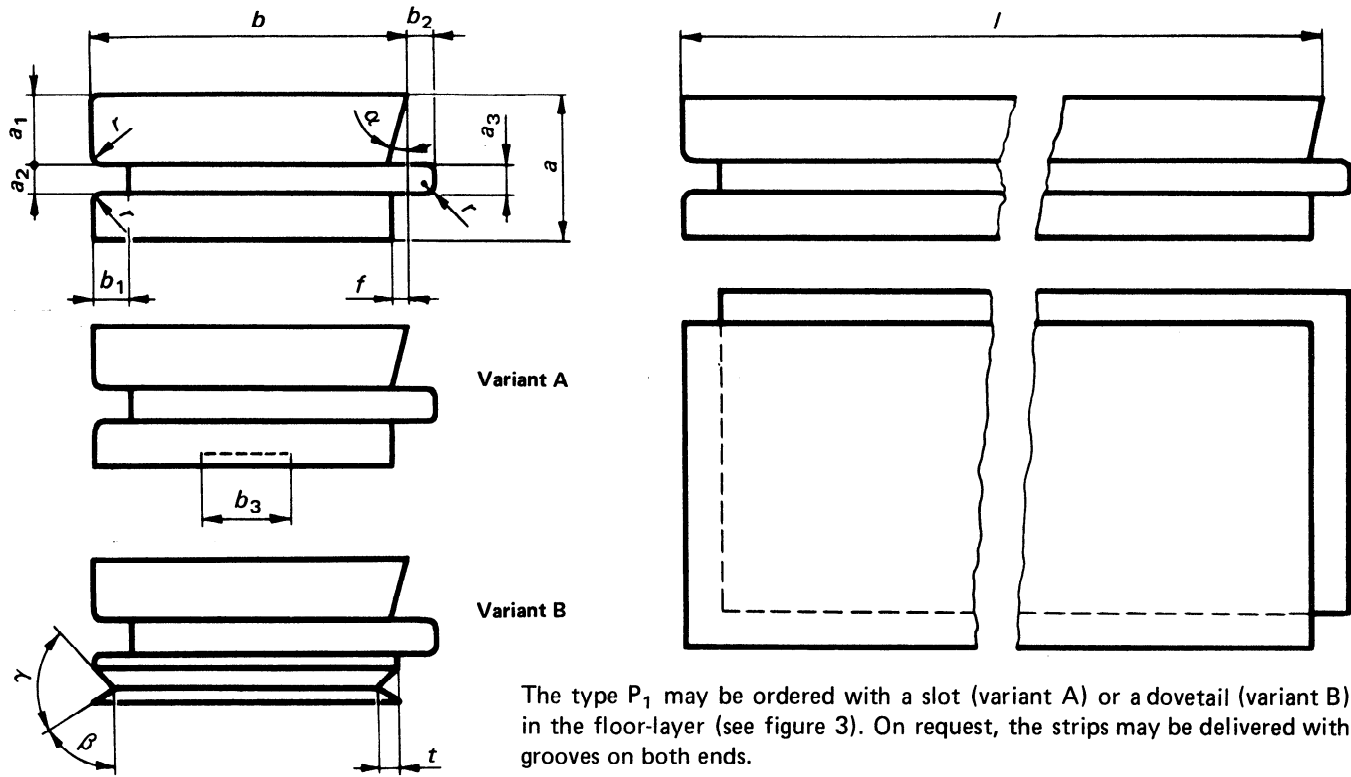
4 REQUIRED CHARACTERISTICS

4.1 Geometrical characteristics

The solid wood parquet strips are manufactured in three different profiles, called respectively : types P₁ (variants A and B), P₂ and P₃, having the dimensional characteristics given for each of them in tables 1, 2, 3 and 4 and shown in figures 1, 2 and 3.

1) In preparation.

4.1.1 Type P₁



The type P₁ may be ordered with a slot (variant A) or a dovetail (variant B) in the floor-layer (see figure 3). On request, the strips may be delivered with grooves on both ends.

FIGURE 1 – Type P₁ strip

TABLE 1 – Dimensional characteristics of type P₁

Denomination	Unit of measure	Symbol	Dimensions			Tolerances
			16	19	22	
Thickness of parquet strip	mm	<i>a</i>	16	19	22	± 0,2
Thickness of wear-layer	mm	<i>a</i> ₁	7	8,5	10	± 0,1
Height of groove	mm	<i>a</i> ₂	5	5	5	+ 0,2* 0
Thickness of tongue	mm	<i>a</i> ₃	5	5	5	0* - 0,2
Depth of groove	mm	<i>b</i> ₁	6	6	6	± 0,3
Width of tongue	mm	<i>b</i> ₂	5	5	5	± 0,3
Width of slot in back	mm	<i>b</i> ₃	0,25 <i>b</i>			–
Rounding-off radius of groove and tongue	mm	<i>r</i>	0,5 to 1			–
Recess of floor-layer (tongue side)	mm	<i>f</i>	1	1	1	± 0,2
Depth of recess	mm	<i>t</i>	–	4	4	± 0,2
Height of slot in back	mm	<i>h</i>	2	3	3	± 0,2
Bevel of wear-layer (tongue side)	deg	<i>α</i>	3			± 30'
Bevel of floor-layer	deg	<i>β</i>	30			± 1
Dovetail angle	deg	<i>γ</i>	67			± 2

* If required or specified.

4.1.2 Type P₂

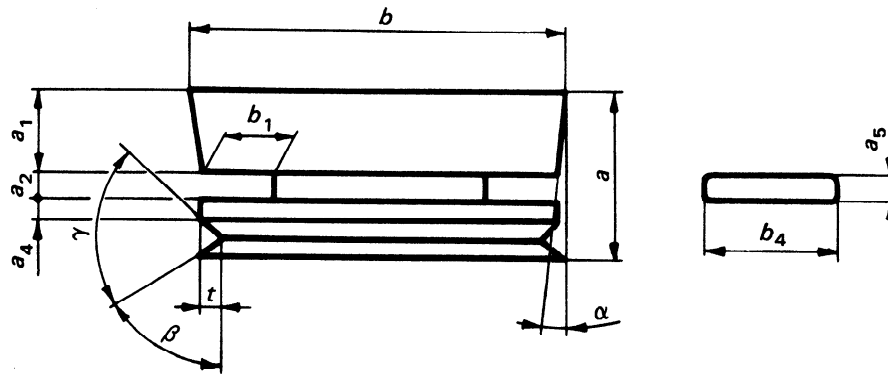


FIGURE 2 – Type P₂ strip

TABLE 2 – Dimensional characteristics of type P₂

Denomination	Unit of measure	Symbol	Dimensions		Tolerances
Thickness of parquet strip	mm	a	19	22	$\pm 0,2$
Thickness of wear-layer	mm	a_1	9	11	$\pm 0,1$
Height of groove	mm	a_2	3	3	$\pm 0,1$
Thickness of top part of floor-layer	mm	a_4	3	3	$\pm 0,2$
Thickness of detachable tongue	mm	a_5	3		$\begin{matrix} 0 \\ -0,1 \end{matrix}$
Depth of groove	mm	b_1	10	10	$\pm 0,5$
Width of detachable tongue	mm	b_4	18		$\begin{matrix} 0 \\ -1 \end{matrix}$
Depth of recess	mm	t	4	4	$\pm 0,2$
Bevel of wear-layer	deg	α	1		$\pm 20'$
Bevel of floor-layer	deg	β	30		± 1
Dovetail angle	deg	γ	67		± 2

4.1.3 Type P₃

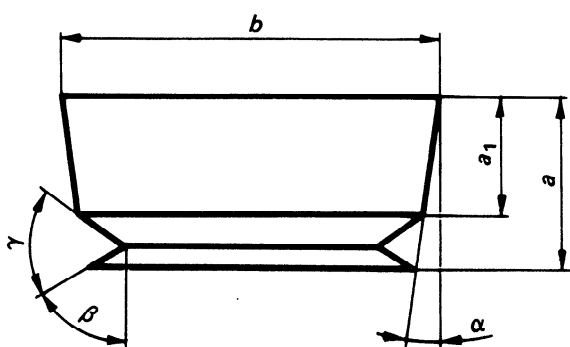


FIGURE 3 – Type P₃ strip

TABLE 3 – Dimensional characteristics of type P₃

Denomination	Unit of measure	Symbol	Dimensions	Tolerances
Thickness of parquet strip	mm	a	22	$\pm 0,2$
Thickness of floor-layer	mm	a_1	15	$\pm 0,1$
Bevel of wear-layer	deg	α	1	$\pm 20'$
Bevel of floor-layer	deg	β	30	± 1
Dovetail angle	deg	γ	67	± 2

TABLE 4 – Width and length of strips

Dimensions in millimetres

Type	Width <i>b</i>			Length <i>l</i>		
	nominal	varying by steps of	tolerances	nominal	varying by steps of	tolerances
P ₁ and P ₃	from 30 to 100	5	± 0,2	200 or more unless otherwise agreed	50	for strips manufactured in view of realizing works of settled dimensions ± 0,2
P ₂	from 45 to 100					

4.1.4 Width and length of strips

The width and the length of strips are given in table 4.

NOTE – The width and the length of parquet strips are determined by the width and the length of the face.

Beech wood strips having widths greater than 70 mm can be delivered by agreement between the interested parties.

4.2 Moisture

4.2.1 Unless otherwise agreed on the order, or specified in the relevant International Standards for classification of parquet strips of different wood species, the moisture at delivery from the manufacturing works shall be between 8 and 13 %, on dry mass.

4.2.2 The reference moisture for the dimensions is 11 % on dry mass.

NOTE – This reference moisture is not inconsistent with the moisture limits laid down above. It is intended only to let the manufacturers provide for the increase or the reduction of strip dimensions during machining operations and depending upon the moisture content of the wood at the time of manufacture, so that, for a moisture content of 11 %, the strip dimensions shall be within the permitted tolerances.

5 DESIGNATION

The parquet strips shall be designated by stating successively :

- the symbol of the wood species according to ISO/R 2036;
- their type;
- the nominal dimensions (thickness X width X length), expressed in millimetres;
- the grade;
- the number of the International Standard referring to the respective species of wood.

Examples :

a) Designation of oak parquet strips, type P₁, 22 mm thick, 50 mm wide and 300 mm long (fixed length), of the first grade :

Parquet strip QUER P₁ 22 X 50 X 300★★★
ISO 1324

b) the same in the variant "A" :

Parquet strip QUER P₁/A 22 X 50 X 300★★★
ISO 1324

c) the same in various lengths between 350 and 950 mm :

Parquet strip QUER P₁ 22 X 50 X 350 ... 950★★★
ISO 1324

6 INSPECTION CONDITIONS

6.1 Inspection rules

The inspection of the characteristics of parquet strips shall be carried out under the conditions established below, on strips of a representative sample taken from the batch.

6.2 Batch

6.2.1 Unless otherwise agreed, a batch of parquet strips is an aggregate of strips of the same wood species, type, nominal thickness and grade, presented in a single delivery.

A sample shall be taken from every batch.

6.2.2 A sample is made up of whole bundles of strips of representative dimensions of the average of the batch, taken at random from the batch; the number of strips in a sample should be at least that specified in table 5.

TABLE 5 – Number of strips in sample

Number of strips in the batch	Number of strips in the sample	Permitted number of rejected strips in the sample
from 1 to 65	7 *	0
from 66 to 180	15	1
from 181 to 300	35	2
from 301 to 500	50	3
from 501 to 800	75	4
from 801 to 1 300	110	6
from 1 301 to 3 200	150	8
from 3 201 to 8 000	225	11
from 8 001 to 22 000	300	14
from 22 001 to 110 000	450	20
from 110 001 to 550 000	750	31
over 550 000	1 500	56

* When the number of strips to be taken is equal to or greater than the number of strips in the batch, the inspections shall be carried out on each strip in the batch.

6.3 Nature of inspections

All the strips making up a sample shall be inspected individually in respect of the wood species, the nominal dimensions, the profile, the defects and the appearance. The defects permitted for each grade shall be inspected according to the relevant International Standards for the classification of the strips of different species of wood.

The moisture content shall be checked according to 6.4.1.

6.4 Inspections

6.4.1 Moisture

The moisture content shall be checked on a test specimen cut from the middle of a strip taken at random from every third bundle of the sample, but at least on three strips, each taken from a different bundle. Unless otherwise agreed, the moisture content shall be determined with an electrical contact device.

In case of disagreement, the gravimetric method shall be binding.

6.4.2 Dimensions and profile

All inspections other than those for moisture content shall be carried out on all the strips of the sample.

The dimensions shall be checked with measuring instruments capable of recording to the prescribed degree of accuracy.

The width and the length shall be checked on the face, along directions parallel and perpendicular to the longitudinal axis of the strip.

6.4.3 Defects and appearance

The dimensions of measurable defects shall be measured with adequate measuring instruments.

Non-measurable defects, and general appearance, shall be examined with the naked eye.

6.5 Acceptance and rejection

If, after checking the characteristics other than the moisture content, the number of rejected strips in the sample examined does not exceed the number shown in table 5 for the size of this sample, the batch shall be regarded as complying with the requirements of this International Standard.

In other cases, the batch shall be rejected; a rejected batch may be presented, after reclassification, to a new check.

If the moisture content is not according to the specifications of 4.2.1, the batch shall be rejected.

7 DELIVERY

The parquet strips shall be delivered in bundles.

7.1 Making-up of bundles

7.1.1 Strips of the same length

The bundles shall be made up of ten strips or of a multiple of ten strips of the same wood species, type, nominal dimensions and grade.

7.1.2 Strips of different lengths

The bundles shall be made up of strips of the same wood species, type, thickness, width and grade.

7.1.3 The bundles of type P₁ strips shall be made up of strips with "left-hand" tongue and with "right-hand" tongue in equal parts. On express order, the bundles may be made up only of strips with "left-hand" tongue or of strips with "right-hand" tongue or each in a variable percentage.

7.2 Moisture content

The moisture content of parquet strips shall comply, at delivery from the manufacturing works, with the specifications laid down in 4.2.1.

8 MARKING

8.1 Unless otherwise agreed between the parties, the marking of parquet strips at delivery from the manufacturing works, is compulsory.

8.2 The marking shall be carried out legibly by applying a stamp with a water-proof and slightly penetrating product to the bottom-side of one of the external strips of each bundle.

The stamp must contain the items given in clause 5.

Examples :

For oak parquet strips, type P₁ 22 mm thick, 50 mm wide

and 300 mm long, of the first grade, the marking shall be the following :

QUER
P₁
22 X 50 X 300
★★★
ISO 1324

For oak parquet strips, type P₁, 22 mm thick, 50 mm wide and having different lengths totaling 10,25 m, of the first grade the marking shall be the following :

QUER
P₁
22 X 50 X 10,25
★★★
ISO 1324

8.3 At the purchaser's request, the indications of the country and the trade mark may be inscribed in addition to the indications specified in clause 5.

Example :

For oak parquet strips, type P₁, 22 mm thick, 50 mm wide and 300 mm long, of the first grade, manufactured in Romania, by CEIL, the marking shall be the following :

QUER
P₁
22 X 50 X 300
★★★
R
CPL
ISO 1324