

# INTERNATIONAL STANDARD

# ISO 1954

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## Plywood — Tolerances on dimensions

*Contreplaqué — Tolérances sur dimensions*



Reference number  
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# Contents

	Page
<b>Foreword</b> .....	<b>iv</b>
<b>1 Scope</b> .....	<b>1</b>
<b>2 Normative references</b> .....	<b>1</b>
<b>3 Moisture content of panels</b> .....	<b>1</b>
<b>4 Tolerances</b> .....	<b>1</b>
4.1 General .....	1
4.2 Tolerances on length and width .....	1
4.3 Tolerances on thickness .....	1
4.4 Tolerance on straightness of edges .....	2
4.5 Tolerance on squareness .....	2

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established 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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

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Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: Foreword - Supplementary information.

The committee responsible for this document is ISO/TC 89, *Wood-based panels*, Subcommittee SC 3, *Plywood*.

This second edition cancels and replaces the first edition (ISO 1954:1999), Clauses 3, 4, and 5 of which have been technically revised.

# Plywood — Tolerances on dimensions

## 1 Scope

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

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 9426, *Wood-based panels — Determination of dimensions of panels*

ISO 16979, *Wood-based panels — Determination of moisture content*

## 3 Moisture content of panels

Moisture content shall be measured in accordance with ISO 16979. Unless otherwise stated by contract, dimensional tolerances are applicable at a reference moisture content of  $(10 \pm 2)$  %.

Statistically valid factors may be used to adjust measurements that can be taken, for practical purposes, at different moisture content (e.g. as-manufactured state or as-received state).

## 4 Tolerances

### 4.1 General

Unless otherwise specified in other applicable standards, specifications, and/or contract terms, the tolerances given in [4.2](#) to [4.5](#) shall apply.

NOTE Some plywood products and uses can require narrower tolerances.

### 4.2 Tolerances on length and width

Length and width shall be measured in accordance with ISO 9426.

Tolerances on nominal size:  $\pm 1,5$  mm/m with a maximum of  $\pm 3,5$  mm.

### 4.3 Tolerances on thickness

Thickness shall be measured in accordance with ISO 9426.

Tolerances on nominal thickness are specified in [Table 1](#).

Table 1 — Tolerances on nominal thickness

Dimensions in millimetres

Nominal thickness $t$	Unsanded, touch-sanded, or scraped panels		Sanded panels	
	Thickness tolerance within one panel	Tolerance on nominal thickness	Thickness tolerance within one panel	Tolerance on nominal thickness
$t \leq 3$	0,5	+0,4 -0,2	0,3	$\pm 0,2$
$3 < t \leq 7$	0,7	+0,5 -0,3	0,5	$\pm 0,3$
$7 < t \leq 12$	1,0	+(0,8 + 0,03 $t$ ) -(0,4 + 0,03 $t$ )	0,6	+(0,2 + 0,03 $t$ ) -(0,4 + 0,03 $t$ )
$12 < t \leq 25$	1,5			+(0,2 + 0,03 $t$ ) -(0,3 + 0,03 $t$ )
$t > 25$	1,5	+(0,8 + 0,03 $t$ ) -(0,4 + 0,03 $t$ )	0,8	+(0,2 + 0,03 $t$ ) -(0,3 + 0,03 $t$ )

#### 4.4 Tolerance on straightness of edges

Straightness of panel edges shall be measured in accordance with ISO 9426.

Tolerance: 1 mm/m.

#### 4.5 Tolerance on squareness

Squareness shall be measured in accordance with ISO 9426.

Tolerance: 1 mm/m.



