

Filmfaced plywood grades

The quality grade of filmfaced plywood is defined by type and quantity of visible defects.

The limitations described refer to the following Riga Wood filmfaced plywood products:

FORM	PATTERNS	COLORED
TEX		TRANSPARENT
Riga Form (dark brown, black)	Riga Heksa Plus	Riga Form (light brown, silver grey etc.)
Riga Tex (dark brown, black)	Riga Heksa	Riga Mel
	Riga Trans	Riga Preprime
	Riga Dot	Riga Paint
	Riga Foot	
	Riga Diamond	
	Riga Rhomb	
	Riga Smooth Mesh	
	Riga Superwire	
	Riga Frost	
	Riga Timber	










Permitted

Not permitted

Not applicable

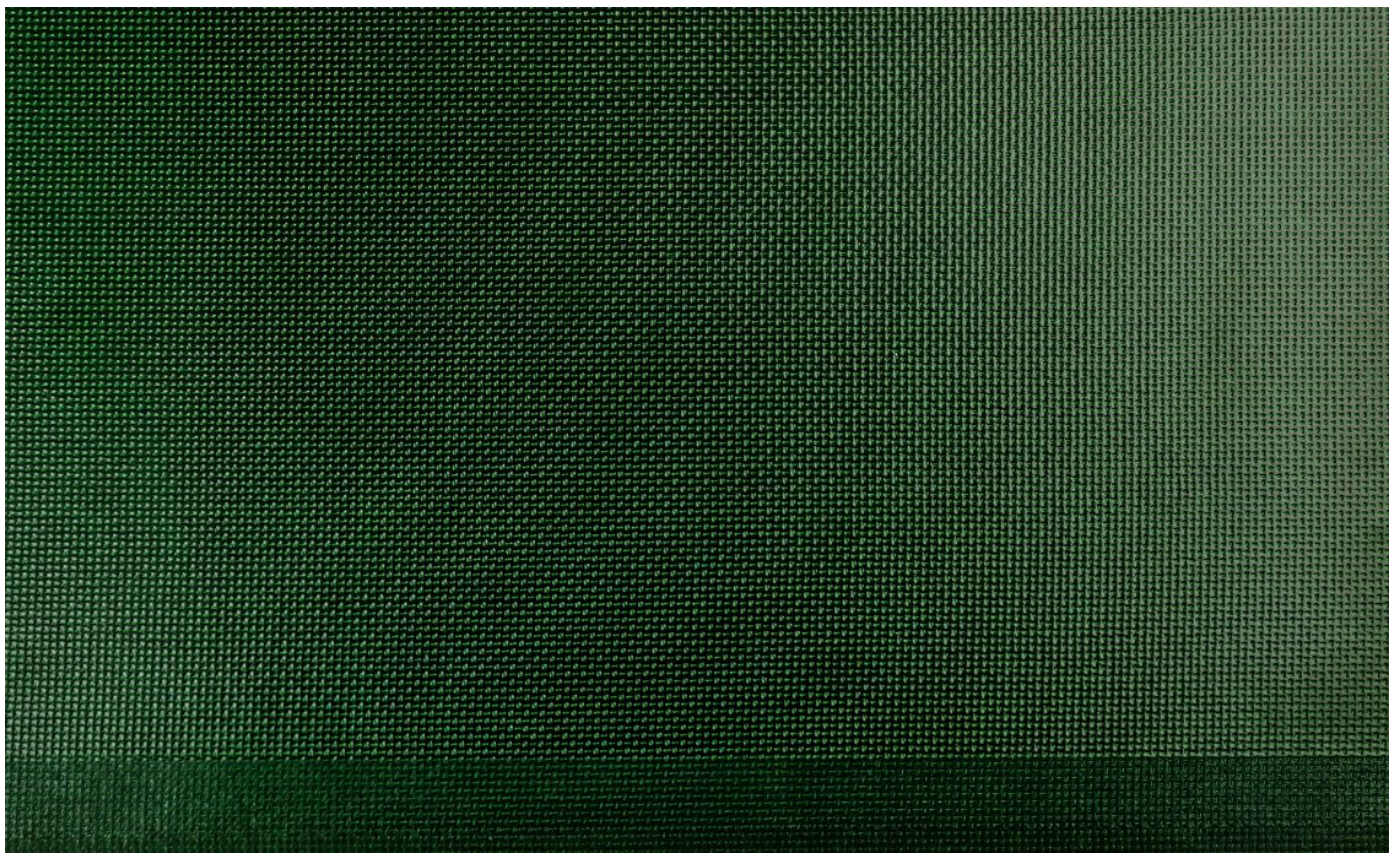
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Damaged pattern, uneven pattern			
A	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
I	<input checked="" type="checkbox"/> Strips: 10 mm in width, 1 pc/width m; Spots: Ø 30 mm, 1 pc/m ² or unlimited, if Ø 10 mm	<input checked="" type="checkbox"/> Strips: 5 mm in width, 1 pc/width m; Spots: Ø 20 mm, 1 pc/m ² or unlimited, if Ø 10 mm	<input type="checkbox"/>
II	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>



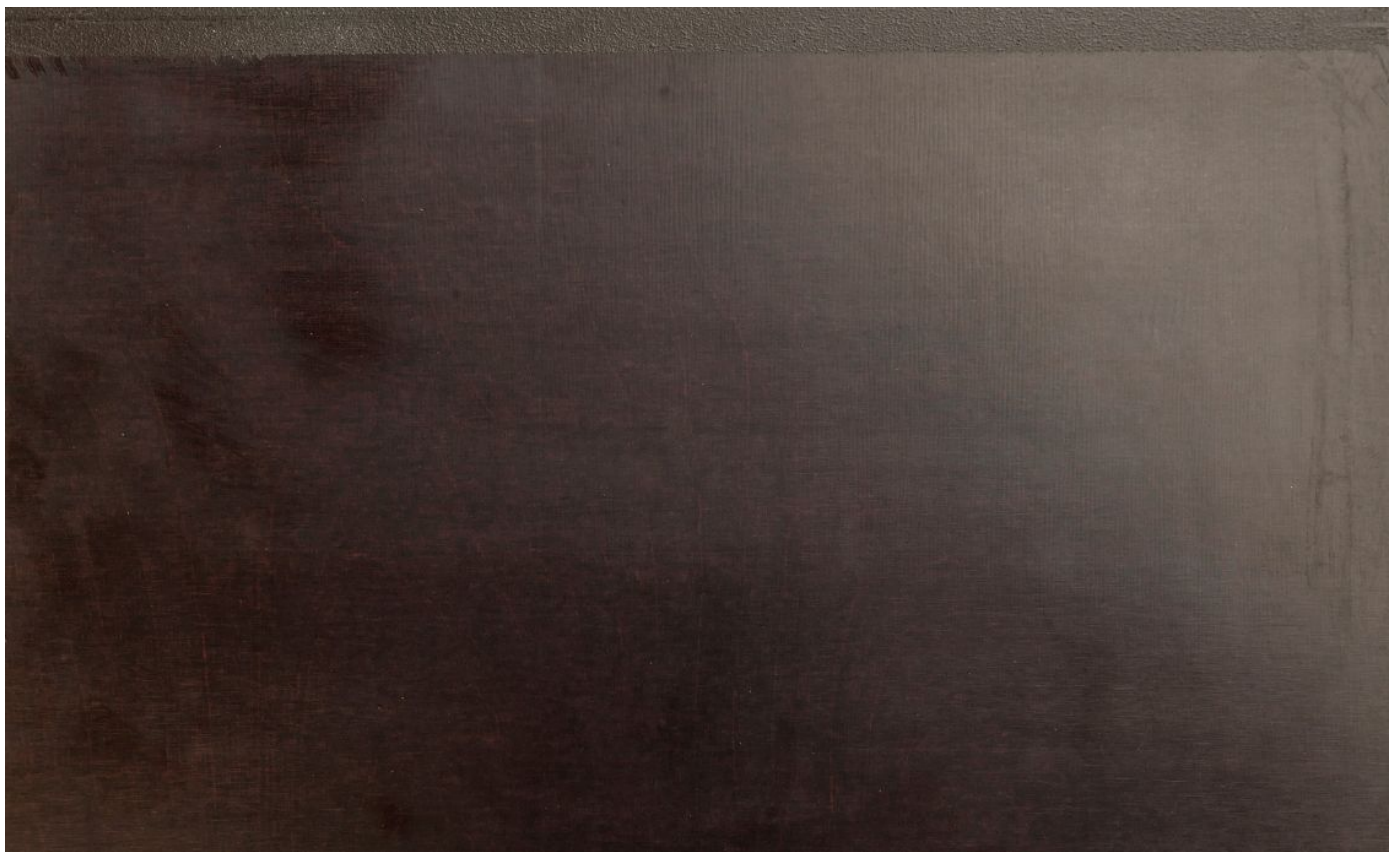
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Diffuse strips on surface (variations in color tone or gloss)			
A	 If grade A on both faces, permitted minor on one face	 Permitted minor on reverse face	 If grade A on both faces, permitted minor on one face
I	 Minor	 Minor	 Minor
II	 	 	



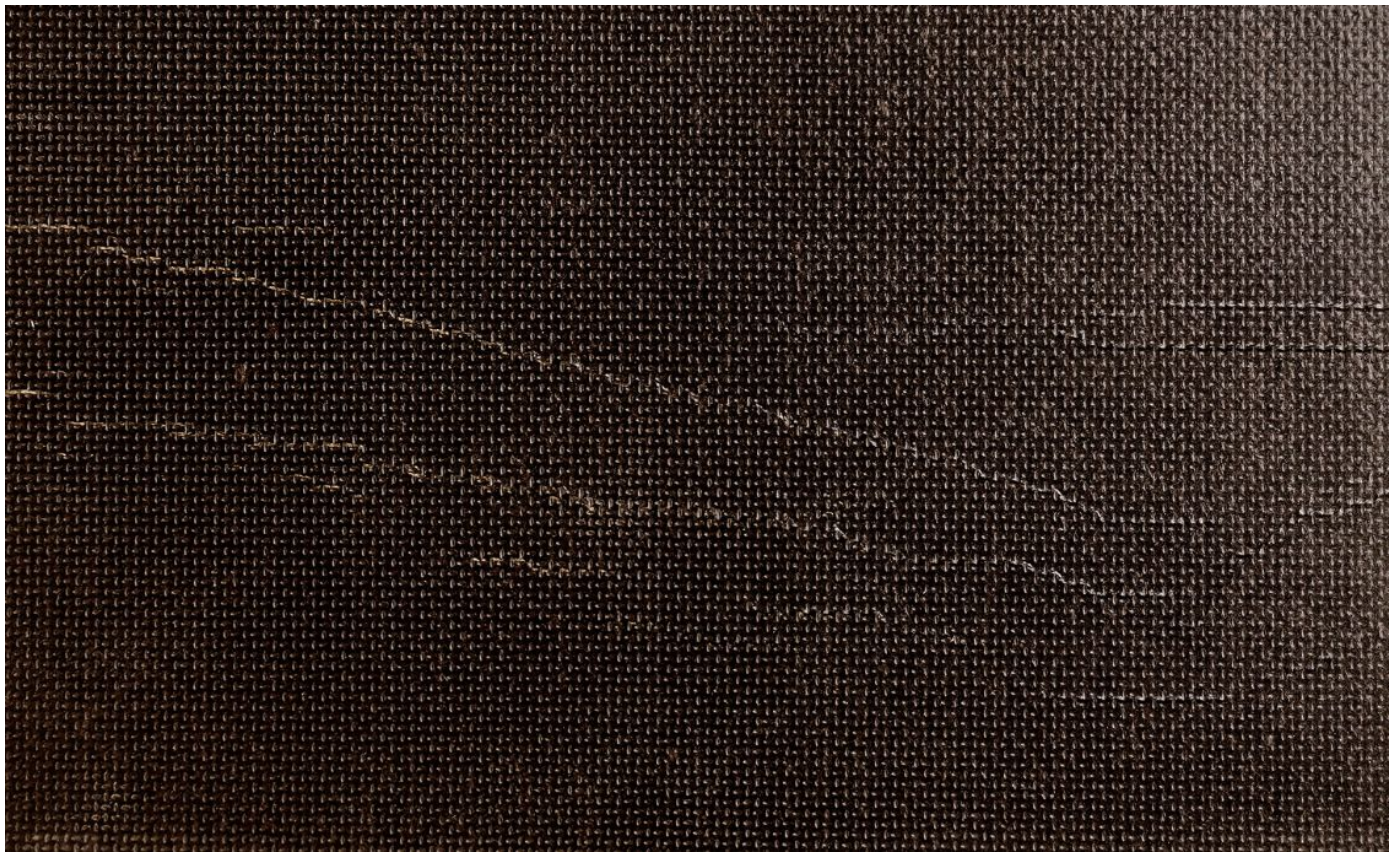
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Displacement of wire mesh or pattern			
A	✘	✘	○
I	✘	✘	○
II	✔	✔	○












GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Edge sealing paint on laminated surface			
A	✓ ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even	✓ ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even	✓ ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even
I	✓ ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even	✓ ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even	✓ ≤ 5 mm paint overlap on the laminated surface. Paint film on the edges shall be even
II	✓	✓	✓



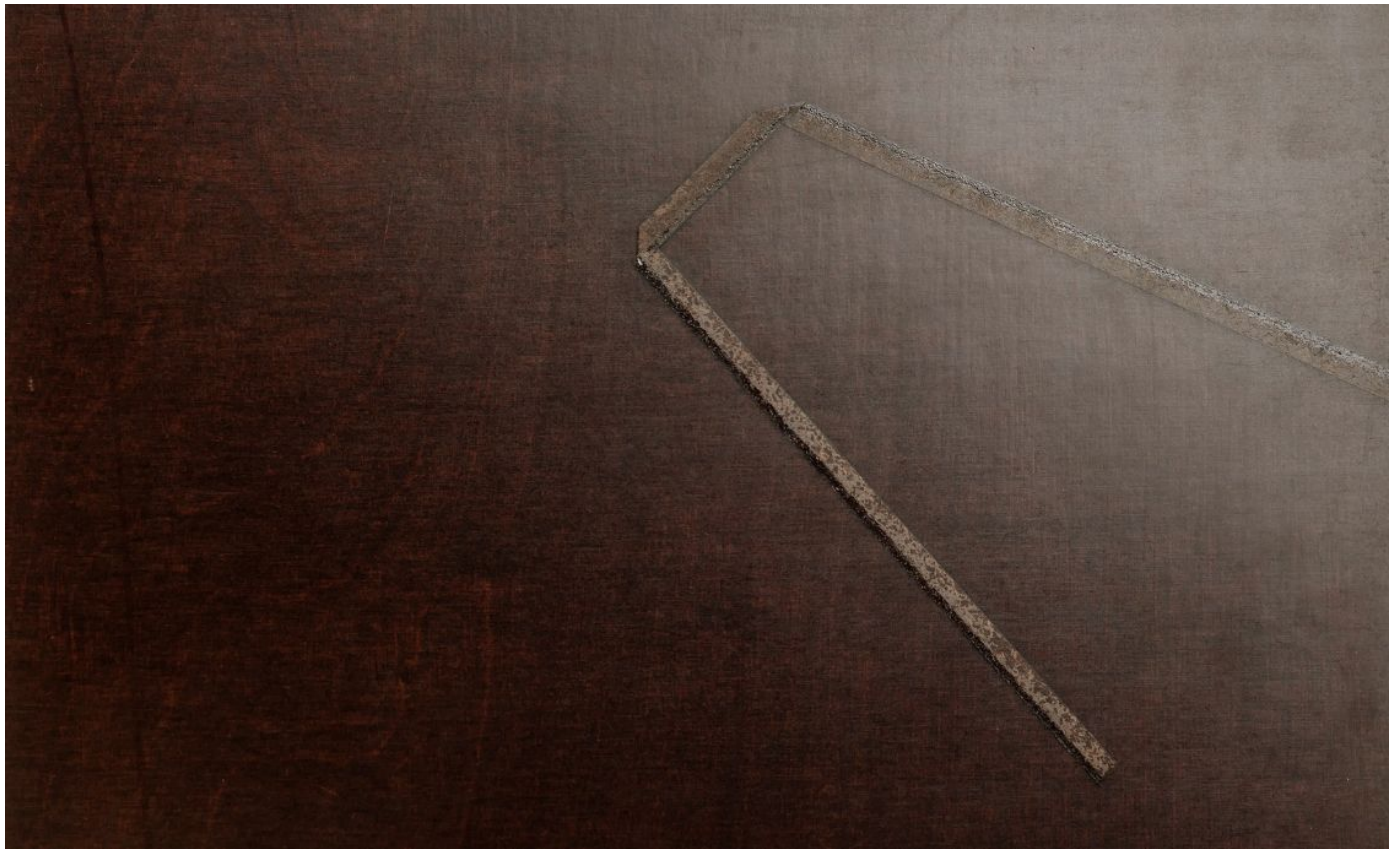
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Film folds			
A	✘	✘	✘
I	✔ 10% of surface area	✘	✘
II	✔	✔	✔












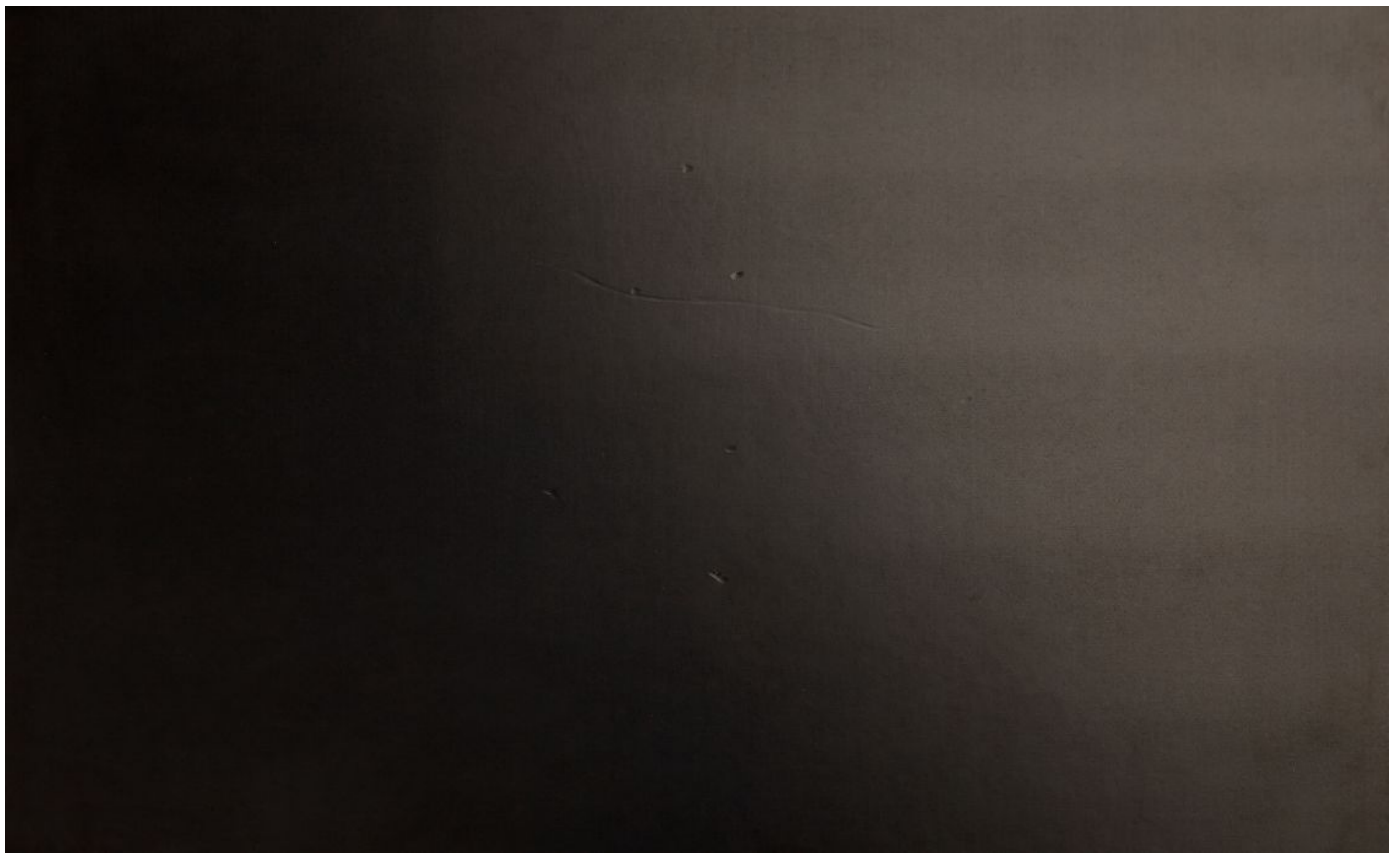
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Film overlaps as dark strips			
A	 If grade A on both faces, permitted on one face firmly glued 10 mm in width	 On pattern face. Permitted on reverse face firmly glued 10 mm in width	 If grade A on both faces, permitted on one face firmly glued 10 mm in width
I	 Without limitations firmly glued 20 mm in width	 On pattern face. Permitted on reverse face firmly glued 20 mm in width	 If grade I on both faces, permitted on one face firmly glued 20 mm in width
II			



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Glued laminate residues on the surface			
A	❌ If grade A on both faces, permitted on one face: 3 pcs, if residues are (1 cm ²) in the same color as surface	❌ Permitted on reverse face: 3 pcs, if residues are (1 cm ²) in the same color as surface	❌ If grade A on both faces, permitted on one face: 3 pcs, if residues are (1 cm ²) in the same color as surface
I	✅ 10 cm ² /m ² if residues are in the same color as surface	✅ 10 cm ² /m ² if residues are in the same color as surface	✅ 10 cm ² /m ² if residues are in the same color as surface
II	✅	✅	✅



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Imprints, if film is not damaged			
A	 If grade A on both faces, permitted on one face: 1 cm ² /m ² , if the width of an imprint 3 mm and the sum of the length 30 mm/m ²	 Permitted on reverse face: 1 cm ² /m ² if the width of an imprint 3 mm and the sum of the length 30 mm/m ²	 If grade A on both faces, permitted on one face: 1 cm ² /m ² , if the width of an imprint 3 mm and the sum of the length 30 mm/m ²
I	 2.5 cm ² /m ² , if the width of an imprint 5 mm and the sum of the length 50 mm/m ²	 2.5 cm ² /m ² , if the width of an imprint 5 mm and the sum of the length 50 mm/m ²	 2.5 cm ² /m ² , if the width of an imprint 5 mm and the sum of the length 50 mm/m ²
II	 	 	



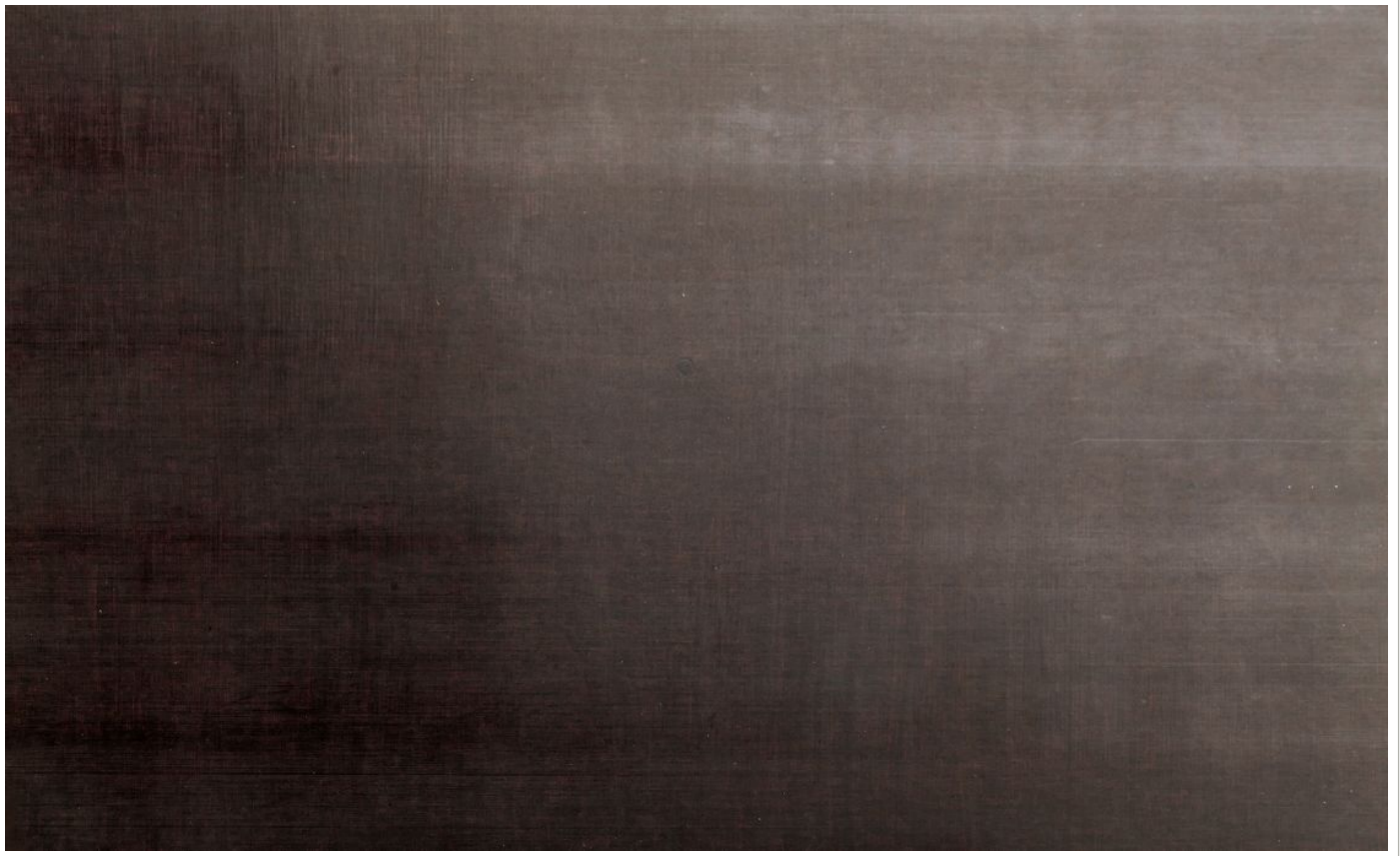
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Lack of film or film delamination after laminating			
A	✘	✘	✘
I	✘	✘	✘
II	✔ On a 1/3 of the sheet on one face	✔ On a 1/3 of the sheet on one face	✔ On a 1/3 of the sheet on one face



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Lack of veneer on edges			
A	✘	✘	✘
I	✔ Permitted in one layer of veneer with a depth 3 mm. Edges shall be firm if standard size	✔ Permitted in one layer of veneer with a depth 3 mm. Edges shall be firm if standard size	✔ Permitted in one layer of veneer with a depth 3 mm. Edges shall be firm if standard size
II	✔ Edges shall be firm	✔ Edges shall be firm	✔ Saplākšņa malām jābūt stingrām












GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Matt surface			
A	✘	✘	✘
I	✔ > 50% of surface area	✘	✘
II	✔	✔	✔



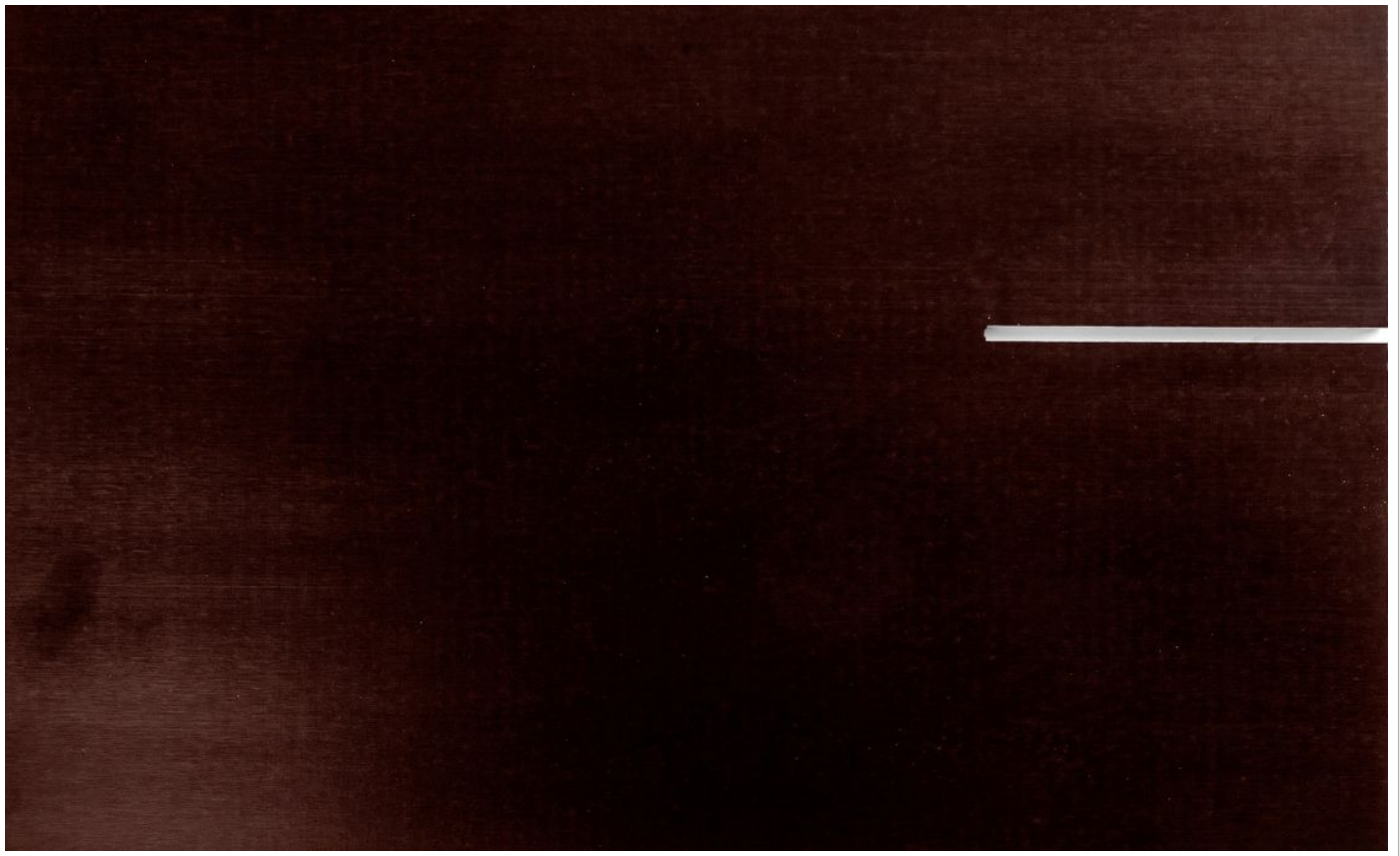
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Mechanical defects			
A	✘	✘	✘
I	✘	✘	✘
II	✔	✔	✔












GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Minor rough spots			
A	 If grade A on both faces, permitted on one face: 25 cm ² over the surface, with separate spots 5 cm ²	 Permitted on reverse face: 25 cm ² over the surface, with separate spots 5 cm ²	 If grade A on both faces, permitted on one face: 25 cm ² over the surface, with separate spots 5 cm ²
I	 125 cm ² over the surface	 125cm ² over the surface	 125cm ² over the surface
II	 	 	



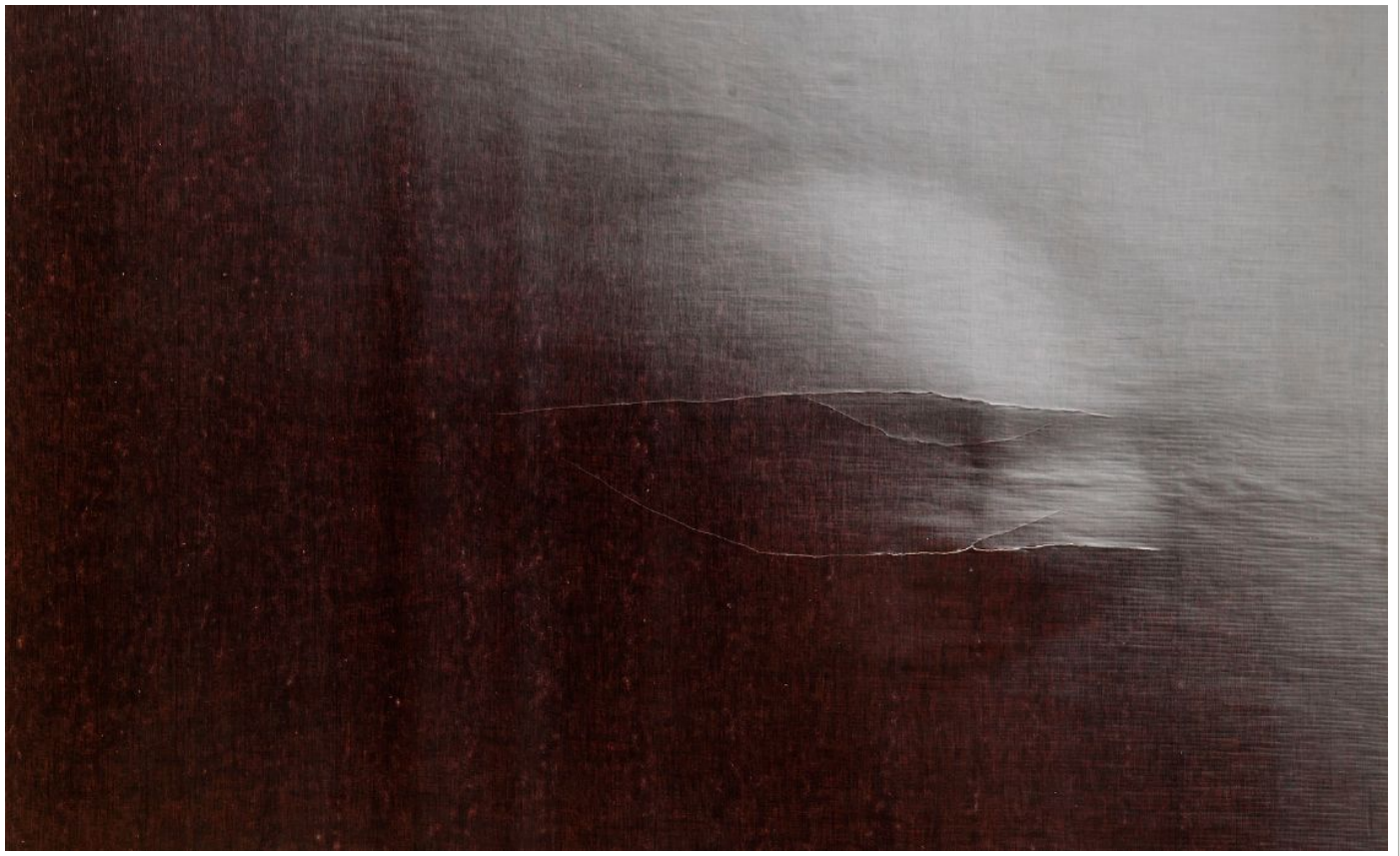
GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Notches			
A	✘	✘	✘
I	✘	✘	✘
II	✔	✔	✔
	One with a length 10 cm	One with a length 10 cm	One with a length 10 cm












GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Other color dust pressed on the surface			
A	 If grade A on both faces, permitted on one face: 5% of surface area	 Permitted on reverse face: 5% of surface area	 If grade A on both sides, then permitted on one side: 5% of surface area
I	 10% of surface area	 10% of surface area	 10% of surface area
II	 	 	



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Plywood delamination			
A	✘	✘	✘
I	✘	✘	✘
II	✔ 100 cm ² /m ²	✔ 100 cm ² /m ²	✔ 100 cm ² /m ²



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Ridges, bumps			
A	 If grade A on both faces, permitted on one face. Spots: Ø 15 mm, 1 pc/m ² or unlimited, if Ø 5 mm	 Permitted on reverse face. Spots: Ø 10 mm, 1 pc/m ² or unlimited, if Ø 5 mm	 If grade A on both faces, permitted on one face. Spots: Ø 10 mm, 1 pc/m ² or unlimited, if Ø 5 mm
I	 Strips: 10 mm in width, 300 mm in length and 1 pc/width m; 5 mm in width, unlimited length, 1 pc/width m. Spots: Ø 20 mm, 1 pc/m ² or unlimited, if Ø 10 mm	 Strips: 5 mm in width, 300 mm in length and 1 pc/width m; 3 mm in width, unlimited length, 1 pc/width m. Spots: Ø 15 mm, 1 pc/m ² or unlimited, if Ø 5 mm	 Strips: 3 mm in width, 200 mm in length and 1 pc/width m. Spots: Ø 15 mm, 1 pc/m ² or unlimited, if Ø 5 mm
II			



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Scorched laminate as strips and spots			
A	✘ If grade A on both faces, permitted on one face: Strips: 5 mm in width, 1 pc/width m; Spots: Ø 20 mm, 1 pc/m ² or unlimited, if Ø 10 mm	✘ Permitted on reverse face: Strips: 5 mm in width, 1 pc/width m; Spots: Ø20mm, 1 pc/m ² or unlimited, if Ø10mm	✘ If grade A on both faces, permitted on one face: Strips: 5 mm in width, 1 pc/width m; Spots: Ø 20 mm, 1 pc/m ² or unlimited, if Ø 10 mm
I	✔ Strips: 10 mm in width, 1 pc/width m; Spots: Ø 30 mm, 1 pc/m ² or unlimited, if Ø 10 mm	✔ Strips: 10 mm in width, 1 pc/width m; Spots: Ø 30 mm, 1 pc/m ² or unlimited, if Ø 10 mm	✔ Strips: 10 mm in width, 1 pc/width m; Spots: Ø 30 mm, 1 pc/m ² or unlimited, if Ø 10 mm
II	✔	✔	✔



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Scratches			
A	<p style="text-align: center;">✘</p> <p>If grade A on both faces, permitted minor scratches on one face (2 pcs), if the laminate is not scratched through</p>	<p style="text-align: center;">✘</p> <p>Permitted minor scratches on reverse face (2 pcs), if the laminate is not scratched through</p>	<p style="text-align: center;">✘</p> <p>If grade A on both faces, permitted minor scratches on one face (2 pcs), if the laminate is not scratched through</p>
I	<p style="text-align: center;">✔</p> <p>If the laminate is not scratched through</p>	<p style="text-align: center;">✔</p> <p>If the laminate is not scratched through</p>	<p style="text-align: center;">✔</p> <p>If the laminate is not scratched through</p>
II	<p style="text-align: center;">✔</p>	<p style="text-align: center;">✔</p>	<p style="text-align: center;">✔</p>



GRADE	FORM	PATTERNS	COLORED
	TEX		TRANSPARENT
DEFECT			
Total number of defects			
A	There shall be no defects on one face. Reverse face 2 categories of defects	There shall be no defects on one face. Reverse face 2 categories of defects	There shall be no defects on one face. Reverse face 2 categories of defects
I	One face 2 categories of defects. Reverse face 5 categories of defects	One face 2 categories of defects. Reverse face 5 categories of defects	One face 2 categories of defects. Reverse face 5 categories of defects
II	Unlimited	Unlimited	Unlimited

* If the machined panel is smaller than the minimum unit defined in the table (1 m², 1 meter of width), then from the point of view of quality assessment its size shall be equated to 1 m² or 1 meter of width.

* The provided information is for reference only. Wood is a living material, therefore each panel is unique and differences are possible.

* Please note that the table will be regularly updated. The latest version will always be available on www.finieris.com website.