
INTERNATIONAL STANDARD



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Broadleaved wood raw parquet blocks — Classification of oak parquet blocks

Frises brutes en bois feuillus pour parquets — Classement des frises de chêne

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FOREWORD

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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 3398 was drawn up by Technical Committee ISO/TC 99, *Semi-manufactures of timber*, and was circulated to the member bodies in May 1974.

It has been approved by the member bodies of the following countries :

Austria	Ireland	South Africa, Rep. of
Bulgaria	Netherlands	Spain
France	Norway	Thailand
Germany	Poland	Turkey
Hungary	Romania	Yugoslavia

The member bodies of the following countries expressed disapproval of the document on technical grounds :

Czechoslovakia
Italy
U.S.S.R.

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1 SCOPE AND FIELD OF APPLICATION

This International Standard establishes the classification, by quality, of oak raw parquet blocks used for manufacturing different types of wood parquets.

2 REFERENCE

ISO 3397, *Broadleaved wood raw parquet blocks – General characteristics*.

3 MANUFACTURE, CHARACTERISTICS, DELIVERY CONDITIONS

The regulations for the manufacture, the characteristics and the delivery conditions are fixed by ISO 3397.

4 CLASSIFICATION

4.1 Raw parquet blocks shall not contain more defects than those allowed in 4.4, for each grade.

4.2 Raw parquet blocks are divided into three grades :

I
II
M¹⁾

4.3 Raw parquet blocks containing more defects than those allowed for the last grade (M) shall not be delivered under the designation "ISO oak raw parquet blocks", nor under any other designation which may lead to confusion with one of the grades given.

4.4 The three grades shall correspond to the conditions stated in tables 1, 2 and 3.

5 TYPE OF PARQUET BLOCK SAWING

The type of sawing (quarter, half-quarter, slab) of the parquet blocks of the above grades may be the subject of special agreements in the orders.

1) Grade M is mainly intended for the manufacture of mosaic parquet.

TABLE 1 — General characteristics

Wood or sawing defects	Grades		
	I	II	M
Doat and decay	none		
Straightness of grain	appreciably straight grain and parallel to the axis of the piece	slope of grain not exceeding 10 %	
Texture	regular	all textures permitted	
Bow	permitted only in one plane, if the deflection does not exceed 1 % of the length of the piece		
Spring	permitted if the deflection does not exceed 0,5 % of the length of the piece		
Twist	none		
Saw marks	permitted up to a depth of 0,5 mm		

TABLE 2 — Face

Wood defects		Grades		
		I	II	M
Medullary sheath (sound heart)		none	permitted in the form of discontinuous rays, if they are not cleft	
Sound sapwood and false sapwood		none	permitted only on one arris, if it does not exceed 5 mm of the width of the piece	permitted unlimited
Colouring		very slight permitted, stains are excluded	permitted, if they do not result from adulterations due to biological agents	
Shakes	shallow and checks	permitted, not exceeding 1 mm in depth		
	through	permitted on ends, not exceeding in length the increment given for the length of the piece		
Inbark and frost cracks		none		
Knots	very small	permitted in unlimited number provided that their diameter does not exceed : — 2 mm for sound knots — 1 mm for black knots		
	intergrown or partially intergrown	none	permitted on the piece, spaced at 30 mm and more, not exceeding in diameter 10 mm	15 mm
	black, dead or burst	none		permitted on the piece, not exceeding 10 mm in diameter
Knot cluster		none	permitted : 1	
Wormholes		none		permitted
Wane (dull edges)		none		
Curl		none	slight permitted	permitted

TABLE 3 — Back, ends and edges

Wood defects		Grades		
		I	II	M
Medullary sheath (sound heart)		none	permitted in the form of discontinuous rays, if they are not cleft	permitted
Sound sapwood and false sapwood		permitted on the whole width of the piece, not exceeding 5 mm 10 mm of the thickness		permitted unlimited
Shakes	shallow and checks	1 mm	permitted, not exceeding in depth 4 mm	1 mm
	through	permitted on ends, not exceeding in length the increment given for the length of the piece		
Knots	intergrown or partially intergrown	10 mm	permitted, not exceeding the diameter of 20 mm	15 mm
	black, dead or burst	none	permitted on the piece, not exceeding the diameter of 15 mm	10 mm on edges excluded
Knot clusters		permitted		permitted : 1
Wormholes		none		permitted
Wane (dull edges)		none	permitted on a width smaller than 10 mm, on not more than 10 % of the width of the piece	none
Curl		none	permitted	
Defects not mentioned		none	permitted, provided that they do not impair the strength and the durability of the pieces	none

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