
INTERNATIONAL STANDARD



3399

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Broadleaved wood raw parquet blocks — Classification of beech parquet blocks

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

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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 3399 was drawn up by Technical Committee ISO/TC 99, *Semi-manufactures of timber*, and circulated to the Member Bodies in May 1974.

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

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

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

Czechoslovakia
U.S.S.R.

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1 SCOPE AND FIELD OF APPLICATION

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

2 REFERENCE

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

3 MANUFACTURE, CHARACTERISTICS, DELIVERY CONDITIONS

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

3.2 Unless otherwise requested, the wood shall be steamed before delivery.

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 two grades :

I
II

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

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

5 TYPE OF PARQUET BLOCKS 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.

TABLE 1 – General characteristics

Wood or sawing defects	Grades	
	I	II
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
Medullary sheath (sound heart)		none	
Redheartwood		none	sound permitted
Colouring		very slight differences of colouring permitted, veins of deep colour excluded	slight differences of colouring permitted in the form of veins and stacking spots if the wood is sound
Shakes	shallow and checks	permitted, not exceeding in depth 1 mm	
	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, not exceeding 15 mm in diameter
	black, dead or burst	none	permitted, if not in clusters, not exceeding 7 mm in diameter
Wormholes		none	
Wane (dull edges)		none	
Curl		none	

TABLE 3 — Back, ends and edges

Wood defects		Grades	
		I	II
Medullary sheath (sound heart)		none	permitted in the form of discontinuous rays, if they are not cleft
Redheartwood		permitted if sound	
Shakes	shallow and checks	permitted, not exceeding 4 mm in depth	
	through	permitted on ends, not exceeding in length the increment given for the length of the piece	
Knots	sound, of normal colour, even darker	permitted, not exceeding 20 mm in diameter	permitted, provided that the diameter does not exceed 1/2 of the width of the piece
	black, intergrown, dead or burst	permitted provided that the diameter does not exceed 15 mm 25 mm and the depth 1/2 of the thickness of the piece	
Wane (dull edges)		maximum permitted : in length and in width 20 % in length 30 % in depth in width 20 % 10 % of the thickness of the piece	
Curl		none	
Defects not mentioned		permitted, provided that they do not impair the strength and the durability of the pieces	

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