

## 8. Platform Grading Specifications (Veneercore)

### Scope

Veneercore platforms are used as substrates in high quality hardwood plywood manufacturing in which face and back veneers typically range in thicknesses from 1/64"-1/32" (0.4mm to .8mm). Consequently, uniformity in thickness and sanding of the platform is imperative.

The ultimate end-use is typically for cut-to-size components, which requires a virtually sound, voidfree construction, with a good glue bond.

### Nominal Thickness

3/16" (4.8mm)	(3 PLY)
5/16" (7.9mm)	(3 PLY)
7/16" (11.1mm)	(3 PLY OR 5 PLY MILL OPTION)
9/16" (14.3mm)	(5 PLY OR 7 PLY MILL OPTION)
11/16" (17.5mm)	(5 PLY OR 7 PLY MILL OPTION)
15/16" (23.8mm)	(5 PLY OR 7 PLY MILL OPTION)
1-1/8" (28.6mm)	(7 PLY OR 9 PLY MILL OPTION)
1-3/16" (30.2mm)	7 PLY OR 9 PLY MILL OPTION)

### Manufactured Sizes

73" X 49" (1855mm X 1245mm)
73" X 61" (1855mm X 1550mm)
85" X 49" (2160mm X 1245mm)
85" X 61" (2160mm X 1550mm)
97" X 49" (2465mm X 1245mm)
97" X 61" (2465mm X 1550mm)
109" X 49" (2770mm X 1245mm)
109" X 61" (2770mm X 1550mm)
121" X 49" (3075mm X 1245mm)
121" X 61" (3075mm X 1550mm)
145" X 49" (3685mm X 1245mm)
145" X 61" (3685mm X 1550mm)

### Invoiced Sizes

6' X 4' (1830mm X 1220mm)
6' X 5' (1830mm X 1525mm)
7' X 4' (2135mm X 1220mm)
7' X 5' (2135mm X 1525mm)
8' X 4' (2440mm X 1220mm)
8' X 5' (2440mm X 1525mm)
9' X 4' (2745mm X 1220mm)
9' X 5' (2745mm X 1525mm)
10' X 4' (3050mm X 1220mm)
10' X 5' (3050mm X 1525mm)
12' X 4' (3660mm X 1220mm)
12' X 5' (3660mm X 1525mm)

Or, as agreed between buyer and seller.

### Manufactured Tolerance

**Thickness:** Nominal thickness to be construed as the average thickness, allowing +/- 0.010" (0.25mm) variance.

**Width:** Minus 0 plus 1/4" (6.3mm)

**Length:** Minus 0 plus 1/4" (6.3mm)

### Squareness

Panels 4' (1220mm) or greater in length and width shall be square within 3/32" (2.4 mm). Panels less than 4'

(1220mm) in length or width shall be square within 1/16" (1.6mm). Squareness shall be determined by measuring the length of the two diagonals of the panel.

### Sanded Finish

Cross bands should be sanded multiple times, with the last sanding using a 120 grit or equivalent. Panels must be uniform in thickness with no low or high areas permitted beyond allowable tolerance +/-0.010" (+/-0.25mm).

### Crossband Grading

**Color face and back**—Pleasingly color matched with no sharp contrasts.

**Burl**—Permitted provided completely smooth (no torn grain).

**Sound and Pin Knot**—Permitted if sanded smooth.

**Knot hole, worm track & wormhole**—Permitted if filled and sanded smooth; maximum diameter 1/2" (12.7mm); no sunken putty.

**Vine streak, stain mineral streak**—Permitted provided that it is sound and smooth.

**Bark and Pitch Pocket**—None allowed.

**Splits Puttied**—1/4" (6.35mm) wide tapering to a point and up to 24" (610mm) long maximum four per panel.

**Putty smears**—Permitted if sanded smooth.

**Interlocked grain**—Permitted if completely smooth (no torn grain)

**Edge glue face joints**—Permitted.

**Core laps**—None allowed.

**Shims**—None allowed.

**Face Patch**—None allowed.

### Core Grade

Solid wood veneers. Width of voids not to exceed the thickness of the core veneer. Short core or center is not permitted.

### Glue

Type I	Exterior, phenolic
Type II	Interior, Urea Formaldehyde
Type II LFE	Interior, Low Formaldehyde
	Emissions per HUD Standards

### Moisture Content

To be within 6 -12% at time of shipment.

**Platform Grading Specification (Veneercore) was Adopted by the IWPA Board of Directors, October 20, 1998, and supercedes revision of March, 1993.**

**TABLE 3.1 SUMMARY OF HARDWOOD FACE GRADE CHARACTERISTICS – Ash, Beech<sup>b</sup>, Birch, Maple and Poplar**  
**Cut** (Plain-Sliced (Flat-Cut), Quarter-Cut, Rotary-Cut – See Table 2 for Common Face Veneer Patterns)

Grade Description	AA				A				B				C	D	E	
	Sap	Heart	Nat.		Sap	Heart	Nat.		Sap	Heart	Nat.					
Sapwood	Yes	No	Yes		Yes	No	Yes		Yes	No	Yes		Yes	Yes	Yes	
Heartwood	No	Yes	Yes		No	Yes	Yes		No	Yes	Yes		Yes	Yes	Yes	
Color Streaks or Spots	Slight		Yes		Slight		Yes		Yes		Yes		Yes	Yes	Yes	
Color Variation	Slight		Yes		Slight		Yes		Yes		Yes		Yes	Yes	Yes	
Sharp Color Contrasts at Joints	Yes if Slip, Plank or Random matched				Yes if Slip, Plank or Random matched				Yes if Slip, Plank or Random matched				Yes	Yes	Yes	
Type of Matching	Yes Specify				Yes Specify				Specify				--	--	--	
Book Matched	--				--				--				--	--	--	
Slip Matched	--				--				--				--	--	--	
Pleasing Matched	--				--				--				--	--	--	
Nominal Minimum Width of Face Components <sup>a</sup>	152 mm	76 mm	152 mm		127 mm	76 mm	127 mm		76 mm	76 mm	102 mm		No Limit	No Limit	No Limit	
Small Conspicuous Burfs & Pin Knots – Combined Avg. Number	2 per 1 m <sup>2</sup>				4 per 1 m <sup>2</sup>				6 per 1 m <sup>2</sup>				No Limit	No Limit	No Limit	
Conspicuous Burfs – Max. Size	6.4 mm				9.5 mm				12.7 mm				No Limit	No Limit	No Limit	
Conspicuous Pin Knots	No				4 per 3 m <sup>2</sup> 3.2 mm 6.4 mm				3 per 1 m <sup>2</sup> 3.2 mm 6.4 mm				No Limit	No Limit	No Limit	
Scattered Sound and Repaired Knots – Combined Avg. Number	No				No				4 per 3 m <sup>2</sup> 9.5 mm 3.2 mm 4 per 3 m <sup>2</sup>				3 per 1 m <sup>2</sup> 12.7 mm 12.7 mm 4 per 3 m <sup>2</sup>	4 per 1 m <sup>2</sup> 25.4 mm 19 mm 2 per 1 m <sup>2</sup>	No Limit 38 mm 25.4 mm 6 per 1 m <sup>2</sup>	
Max. Size – Sound	No				No				Slight				Yes	Yes	Yes	
Max. Size – Repaired	No				No				Slight				Few to	6.4 mm x 50.8 mm	Yes	
Avg. No. – Repaired	No				No				Slight				Slight; Ash, yes	Yes	Yes	
Mineral Streaks	No; Maple, slight				Slight				Slight				Yes	Yes	Yes	
Bark Pockets	No				No				3.2 mm x 25.4 mm				6.4 mm x 50.8 mm	6.4 mm x 50.8 mm	Yes	
Worm Tracks	Slight				Slight				Slight				Yes	Yes	Yes	
Vine Marks	Slight				Slight				Slight				Yes	Yes	Yes	
Cross Bars	Slight				Slight				Yes				Yes	Yes	Yes	
Rough Cut / Ruptured Grain	No				No				Slight				Two 203 mm dia. areas or equivalent	5 % of panel	10% of panel	
Blended Repaired Tapering Hairline Splits	Two 0.8 mm x 76 mm on panel ends only				Two 1.6 mm x 152 mm				Four 3.2 mm x 203 mm				Four 4.8 mm x 203 mm	Six 6.4 mm x 254 mm	Yes	
Repairs	Very Small Blending				Small Blending				Blending				Yes	Yes	Yes	
Quartered	25.4 mm in 305 mm maximum grain slope, 63.5 mm in 305 mm maximum grain sweep				25.4 mm in 305 mm maximum grain slope, 63.5 mm in 305 mm maximum grain sweep				25.4 mm in 305 mm maximum grain slope, 63.5 mm in 305 mm maximum grain sweep				25.4 mm in 305 mm maximum grain slope, 63.5 mm in 305 mm maximum grain sweep			

Unfilled wormholes, open splits, open joints, open bark pockets, or doze not allowed in above grades.

<sup>a</sup> Outside components will be a different size to allow for edge trim loss and certain types of matching.

<sup>b</sup> American or European

TABLE 3.3 SUMMARY OF HARDWOOD FACE GRADE CHARACTERISTICS – Red and White Oak

Cut	Plain-Sliced (Flat-Cut), Quarter-Cut, Rift and Comb grain, Rotary-Cut – See Table 2 for Common Face Veneer Patterns								METRIC	
	AA		A		B		C			D
Grade Description	Red Oak	White Oak	Red Oak	White Oak	Red Oak	White Oak	Red Oak	White Oak		
<b>Color and Matching</b>										
Sapwood	No	No	5% <sup>a</sup>	Yes <sup>a</sup>	10-20% <sup>b</sup>	Yes	Yes	Yes	Yes	Yes
Heartwood	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
Color Streaks or Spots	Yes	Slight	Yes	Slight	Yes	Yes	Yes	Yes	Yes	Yes
Color Variation	Yes	Slight	Yes	Slight	Yes	Yes	Yes	Yes	Yes	Yes
Sharp Color Contrasts at Joints	Yes if Slip, Plank or Random matched	Yes if Slip, Plank or Random matched	Yes if Slip, Plank or Random matched	Yes if Slip, Plank or Random matched	Yes if Slip, Plank or Random matched	Yes if Slip, Plank or Random matched	Yes if Slip, Plank or Random matched	Yes if Slip, Plank or Random matched	Yes if Slip, Plank or Random matched	Yes if Slip, Plank or Random matched
Type of Matching	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
Book Matched	Specify	Specify	Specify	Specify	Specify	Specify	Specify	Specify	Specify	Specify
Slip Matched	--	--	--	--	--	--	--	--	--	--
Pleasant Matched	--	--	--	--	--	--	--	--	--	--
Nominal Minimum Width of Face Components <sup>c</sup>	152 mm	76 mm	127 mm	76 mm	127 mm	76 mm	76 mm	102 mm	No Limit	No Limit
<b>Natural Characteristics</b>										
Small Conspicuous Burls & Pin Knots – Combined Avg. Number	3 per 1 m <sup>2</sup>	4 per 1 m <sup>2</sup>	8 per 1 m <sup>2</sup>	8 per 1 m <sup>2</sup>	8 per 1 m <sup>2</sup>	8 per 1 m <sup>2</sup>	8 per 1 m <sup>2</sup>	8 per 1 m <sup>2</sup>	8 per 1 m <sup>2</sup>	8 per 1 m <sup>2</sup>
Conspicuous Burls – Max. Size	6.4 mm	9.5 mm	12.7 mm	12.7 mm	12.7 mm	12.7 mm	12.7 mm	12.7 mm	12.7 mm	12.7 mm
Conspicuous Pin Knots	No	4 per 1 m <sup>2</sup>	6 per 1 m <sup>2</sup>	3.2 mm	6.4 mm	6 per 1 m <sup>2</sup>	3.2 mm	6.4 mm	No Limit	No Limit
Avg. Number	No	4 per 1 m <sup>2</sup>	6 per 1 m <sup>2</sup>	3.2 mm	6.4 mm	6 per 1 m <sup>2</sup>	3.2 mm	6.4 mm	No Limit	No Limit
Max. Size: Dark Part Total	No	4 per 1 m <sup>2</sup>	6 per 1 m <sup>2</sup>	3.2 mm	6.4 mm	6 per 1 m <sup>2</sup>	3.2 mm	6.4 mm	No Limit	No Limit
Scattered Sound and Repaired Knots – Combined Avg. Number	No	No	4 per 3 m <sup>2</sup>	9.5 mm	3.2 mm	4 per 3 m <sup>2</sup>	9.5 mm	3.2 mm	4 per 1 m <sup>2</sup>	4 per 1 m <sup>2</sup>
Max. Size – Sound	No	No	4 per 3 m <sup>2</sup>	9.5 mm	3.2 mm	4 per 3 m <sup>2</sup>	9.5 mm	3.2 mm	25.4 mm	25.4 mm
Max. Size – Repaired	No	No	4 per 3 m <sup>2</sup>	9.5 mm	3.2 mm	4 per 3 m <sup>2</sup>	9.5 mm	3.2 mm	19 mm	19 mm
Avg. No. – Repaired	No	No	4 per 3 m <sup>2</sup>	9.5 mm	3.2 mm	4 per 3 m <sup>2</sup>	9.5 mm	3.2 mm	2 per 1 m <sup>2</sup>	2 per 1 m <sup>2</sup>
Mineral Streaks	No	Slight, Blending	Few to 305 mm	Slight, Blending	Few to 305 mm	Few to 305 mm	Few to 305 mm	Few to 305 mm	Yes	Yes
Bark Pockets	No	No	3.2 mm x 25.4 mm	No	3.2 mm x 25.4 mm	Few to 305 mm	Few to 305 mm	Few to 305 mm	6.4 mm x 50.8 mm	6.4 mm x 50.8 mm
Worm Tracks	No	No	Slight	No	Slight	Slight	Slight	Slight	Yes	Yes
Vine Marks	No	No	Slight	Slight	Slight	Slight	Slight	Slight	Yes	Yes
Cross Bars	Slight	Slight	Slight	Slight	Slight	Slight	Slight	Slight	Yes	Yes
<b>Manufacturing Characteristics</b>										
Rough Cut / Ruptured Grain	No	No	No	No	Slight	Slight	Slight	Slight	Slight	Two 203 mm dia. areas or equivalent
Blended Repaired Tapering	Two 0.8 mm x 76 mm on panel ends only	Two 0.8 mm x 76 mm on panel ends only	1.6 mm x 152 mm	1.6 mm x 152 mm	3.2 mm x 203 mm	3.2 mm x 203 mm	3.2 mm x 203 mm	3.2 mm x 203 mm	4.8 mm x 203 mm	Six 6.4 mm x 254 mm
Hairline Splits	Very Small Blending	Very Small Blending	Small Blending	Small Blending	Blending	Blending	Blending	Blending	Yes	Yes
Repairs	Slight, Blending	Slight, Blending	Slight, Blending	Slight, Blending	Slight, Blending	Slight, Blending	Slight, Blending	Slight, Blending	Yes	Yes
Ray Fleck <sup>d</sup>	Slight, Blending	Slight, Blending	Slight, Blending	Slight, Blending	Slight, Blending	Slight, Blending	Slight, Blending	Slight, Blending	Yes	Yes
Rift and Comb Grain	Rift permits 25.4 mm in 305 mm maximum grain slope, Comb permits 12.7 mm in 305 mm maximum grain slope, or doze not allowed in above grades.	Rift permits 25.4 mm in 305 mm maximum grain slope, Comb permits 12.7 mm in 305 mm maximum grain slope, or doze not allowed in above grades.	Rift permits 25.4 mm in 305 mm maximum grain slope, Comb permits 12.7 mm in 305 mm maximum grain slope, or doze not allowed in above grades.	Rift permits 25.4 mm in 305 mm maximum grain slope, Comb permits 12.7 mm in 305 mm maximum grain slope, or doze not allowed in above grades.	Rift permits 25.4 mm in 305 mm maximum grain slope, Comb permits 12.7 mm in 305 mm maximum grain slope, or doze not allowed in above grades.	Rift permits 25.4 mm in 305 mm maximum grain slope, Comb permits 12.7 mm in 305 mm maximum grain slope, or doze not allowed in above grades.	Rift permits 25.4 mm in 305 mm maximum grain slope, Comb permits 12.7 mm in 305 mm maximum grain slope, or doze not allowed in above grades.	Rift permits 25.4 mm in 305 mm maximum grain slope, Comb permits 12.7 mm in 305 mm maximum grain slope, or doze not allowed in above grades.	Rift permits 25.4 mm in 305 mm maximum grain slope, Comb permits 12.7 mm in 305 mm maximum grain slope, or doze not allowed in above grades.	Rift permits 25.4 mm in 305 mm maximum grain slope, Comb permits 12.7 mm in 305 mm maximum grain slope, or doze not allowed in above grades.

<sup>a</sup> Sap allowed in rotary only unless otherwise specified. <sup>b</sup> 10% sap allowed in rift, comb, quarter-cut and plain-sliced; 20% sap allowed in rotary. <sup>c</sup> Outside components will be a different size to allow for edge trim loss and certain types of matching. <sup>d</sup> Unless otherwise specified, quarter-cut permits unlimited.

**TABLE 3.5 SUMMARY OF HARDWOOD FACE GRADE CHARACTERISTICS – Walnut and Cherry**  
**Cut** Plain-Sliced (Flat-Cut), Quarter-Cut, Rotary-Cut – See Table 2 for Common Face Veneer Patterns

Grade Description	AA	A	B	C	D	E
Sapwood	No	No <sup>a</sup>	No <sup>a</sup>	Yes	Yes	Yes
Heartwood	Yes	Yes	Yes	Yes	Yes	Yes
Color Streaks or Spots	Slight	Slight	Yes	Yes	Yes	Yes
Color Variation	Slight	Slight	Yes	Yes	Yes	Yes
Sharp Color Contrasts at Joints	Yes if Slip, Plank or Random matched	Yes if Slip, Plank or Random matched	Yes if Slip, Plank or Random matched	Yes	Yes	Yes
Type of Matching						
Book Matched	Yes Specify	Yes Specify	Specify Specify Yes	--	--	--
Slip Matched	--	--	--	--	--	--
Pleasant Matched						
Nominal Minimum Width of Face Components <sup>b</sup>	152 mm 76 mm 152 mm	127 mm 76 mm 127 mm	76 mm 76 mm 102 mm	No Limit	No Limit	No Limit
Small Conspicuous Buris & Pin Knots – Combined Avg. Number	3 per 1 m <sup>2</sup>	8 per 1 m <sup>2</sup>	22 per 1 m <sup>2</sup>	No Limit	No Limit	No Limit
Conspicuous Buris – Max. Size	6.4 mm	9.5 mm	12.7 mm	No Limit	No Limit	No Limit
Conspicuous Pin Knots <sup>c</sup>						
Avg. Number	3 per 1 m <sup>2</sup>	6 per 1 m <sup>2</sup>	11 per 1 m <sup>2</sup>	No Limit	No Limit	No Limit
Max. Size – Sound	3.2 mm	3.2 mm	3.2 mm			
Max. Size – Repaired	6.4 mm	6.4 mm	6.4 mm			
Scattered Sound and Repaired Knots – Combined Avg. Number	No	No	4 per 3 m <sup>2</sup>	3 per 1 m <sup>2</sup>	4 per 1 m <sup>2</sup>	No Limit
Max. Size – Sound			9.5 mm	12.7 mm	25.4 mm	38 mm
Max. Size – Repaired			3.2 mm	12.7 mm	19 mm	25.4 mm
Avg. No. – Repaired			4 per 3 m <sup>2</sup>	4 per 3 m <sup>2</sup>	2 per 1 m <sup>2</sup>	6 per 1 m <sup>2</sup>
Mineral Streaks	Slight	Slight	Yes	Yes	Yes	Yes
Bark Pockets	No	No	Few to 3.2 mm x 25.4 mm	Few to 6.4 mm x 50.8 mm	6.4 mm x 50.8 mm	Yes
Worm Tracks	No	No	Slight	Few	Yes	Yes
Vine Marks	Slight	Occasional	Yes	Yes	Yes	Yes
Cross Bars	Slight	Occasional	Yes	Yes	Yes	Yes
Rough Cut / Ruptured Grain	No	No	Slight	Slight	Two 203 mm dia. areas or equivalent	5% of panel
Blended Repaired Tapering	Two 0.8 mm x 76 mm on panel ends only	Two 1.6 mm x 152 mm	Four 3.2 mm x 203 mm	Four 4.8 mm x 203 mm	Six 6.4 mm x 254 mm	Yes
Hairline Splits	Very Small Blending	Small Blending	Blending	Yes	Yes	Yes
Repairs						
Gum Spots	Occasional gum spots in Cherry	Occasional gum spots in Cherry	Gum spots and gum streaks in Cherry	Gum spots and gum streaks in Cherry	Gum spots and gum streaks in Cherry	Gum spots and gum streaks in Cherry
Quartered	25.4 mm in 305 mm maximum grain slope	63.5 mm in 305 mm maximum grain sweep				

Unfilled wormholes, open splits, open bark pockets, or doze not allowed in above grades.

<sup>a</sup> Sap is allowed in grades A and B; however, the percentage must be agreed upon between buyer and seller. <sup>b</sup> Outside components will be a different size to allow for edge trim loss and certain types of matching. <sup>c</sup> For Walnut and Cherry, conspicuous pin knots means sound knots 6.4 mm or less in diameter with dark centers larger than 1.6 mm. Blending pin knots are sound knots 6.4 mm or less in diameter with dark centers of 1.6 mm or less and are allowed in all grades of Walnut and Cherry.