

China Friend Limited- Company Grade Inspection Rules

1. Birch Plywood

•Rotary cut birch is the most popular hardwood plywood. Available in select, uniform and natural veneers, birch ranges in color from cream to light brown. Adaptable as a paint or stain grade panel, top quality birch plywood is used for cabinets in many kitchens and in fine furniture. Lower grade panels are often used for shelving and industrial (furniture) products.

•“B” Grade Birch

- Sapwood: yes
- Heartwood: yes
- Color Streaks or Spots: slight
- Color Variation: yes
- Small Conspicuous Burls & Pin Knots Combined Avg. Number: 16-8 to 1/4”
- Conspicuous Burls, Max.: 1/2”
- Sound and Repaired Knots in Comb.: 4
- Repaired Knots: 4 to 1/8”
- Mineral Streaks: slight
- Vine: yes, with grain
- Rough Cut: slight
- Blended Repaired Tapering Hairline Splits: four 1/8”X8”

•“C” Grade Birch

- Sapwood: yes
- Heartwood: yes
- Color Streaks or Spots: yes
- Color Variation: yes
- Small Conspicuous Burls & Pin Knots Combined Avg. Number: no limit
- Conspicuous Burls, Max.: no limit
- Sound and Repaired Knots in Comb.: 8
- Repaired Knots: 4 to 1/2”
- Mineral Streaks: yes
- Vine: yes, with grain
- Rough Cut: two 8” areas
- Blended Repaired Tapering Hairline Splits: four 3/16”X8”

•“D” Grade Birch

- Sapwood: yes
- Heartwood: yes
- Color Streaks or Spots: yes
- Color Variation: yes
- Small Conspicuous Burls & Pin Knots Combined Avg. Number: no limit
- Conspicuous Burls, Max.: no limit
- Sound and Repaired Knots in Comb.: 10
- Repaired Knots: 5 to 3/4”
- Mineral Streaks: yes
- Vine: yes
- Rough Cut: 5% of panel
- Blended Repaired Tapering Hairline Splits: six 1/4”X10”

•“E” Grade Birch

- Sapwood: yes
- Heartwood: yes

- Color Streaks or Spots:** yes
- Color Variation:** yes
- Small Conspicuous Burls & Pin Knots Combined Avg. Number:** no limit
- Conspicuous Burls, Max.:** no limit
- Sound and Repaired Knots in Comb.:** no limit
- Repaired Knots:** 6 to 1”
- Mineral Streaks:** yes
- Vine:** yes
- Rough Cut:** 10% of panel
- Blended Repaired Tapering Hairline Splits:** yes

•**“F” grade Back**

- Please refer to the 4 grade rejected back grade

	1 Back	2 Back	3 Back	4 Back
Sapwood	yes	yes	yes	yes
Heartwood	yes	yes	yes	yes
Color Streaks or Spots	yes	yes	yes	yes
Color Variation	yes	yes	yes	yes
Sound Tight Knots	16 to 3/8”	16 to 3/4”	Max. 16 1/2”-1 1/2	yes
Knotholes	no	all repaired	all 3/8”, 10 to 1”	up to 4”
Repaired Knots	no	8 to 1/2”	no	no
Sound Tight Burls	yes	yes	yes	yes
Mineral/Sap	yes/yes	yes/yes	yes/yes	yes/yes
Rough Cut	two 8” dia. areas	yes	yes	yes
Splits or Joints	six 1/8” x 12” repaired	Six 3/16” x 12” repaired	3/8” x 1/4 length of panel	1” to 1/4” length of panel, 1/2” to 1/2 length of panel, 1/4” to full length

2. Rotary Cut Hard Maple Plywood

- Pleasing tight grained pattern suitable as both a stain and paint grade panel. Often used in combination with birch in cabinets and other fixtures. Color ranges from near white to reddish brown.

	“B” Grade Maple	“C” Grade Maple	“D” Grade Maple
Sapwood	yes	yes	yes
Heartwood	yes	yes	yes
Color Streaks or Spots	slight	yes	yes
Color Variation	yes	yes	yes
Small Conspicuous Burls & Pin Knots	16-8 to 1/4”	no limit	no limit
Combined Avg. Number			
Conspicuous Burls, Max.	1/2”	no limit	no limit
Sound and Repaired Knots in Comb.	4	8	10
Repaired Knots	4 to 1/8”	4 to 1/2”	5 to 3/4”
Mineral Streaks	slight	yes	yes
Vine	yes, with grain	yes, with grain	yes, with grain
Rough Cut	slight	two 8” areas	5% of the panel
Blended Repaired Tapering Hairline Splits:	four 1/8”X8”	four 3/16” X 8”	six 1/4”x10”

3. R/C Red Oak plywood

With its open and abundant heartwood, rotary red oak varies from reddish tan to brown. Its consistent coloration from panel to panel makes it a good choice for a wide variety of furniture, cabinets and fixtures.

•“A” Grade Red Oak

- Up to six 3/32” pin knots
- Scatered small burls
- Slight blending mineral streak to 6”
- Up to 5% sapwood
- Max. of two hairline splits no longer than 1/16”X6” per panel end tapering to a point
- Book matched if spliced

•“B” grade Red Oak

- Max. of six ¼” sound pin knots of which four man be 1/8” repaired
- Blending mineral streaks to 8”
- Up to 20% sapwood
- Max. if two repaired splits no longer than 1/8”X8” per panel end tapering to a point
- May be book, slip or color matched

•“C” grade (2 Face) Red Oak

- Six ½” sound knots of which two may be ¼” repaired
- Mineral streaks to 12”
- Up to 25% sapwood
- Max. of two repaired splits no longer than 3/16”X8” per panel end tapering to a point
- General not book matched but no sharp color contract as the joints

4. Okoume Plywood

Generally clear face with little to no knots. Okoume Plywood is a popular wood for counter tops, laminations, kitchens, and other interior work, as well as for marine applications such as kayaks and canoes. It is a durable and handsome hardwood with a uniform red color.

	BB	CC
Pin Knots and Small Burls, Comb. Avg.	Scattered	No Limit
Sound and Repaired Knots In Comb.	4-	6-
	8 to ¾”	8 to 1”
Repaired Knots	No	Filled, color matched
Color Variation	yes	Yes
Worm Tracks/Wormholes	5 to 1/32”	12 to 1/16”
Rough Cut/Ruptured Grain	no	Sanded smooth
Stains/Mineral Streaks	no	Yes
Cross Bars	no	Max. length 2”
Bar Pockets	Filled, color matched	Filled, color matched
Knife Marks	No	No
Blended Repaired Tapering Hairline Splits	Two 1/16” X 10” or 1/8” x 8”	Three 1/16” X 24” or 1/8” x 14”

5. P/S Red Oak Plywood

Face thickness: 0.3mm hand spliced
 0.4mm- 0.6mm machine spliced

•**“A” Grade Red Oak**

- Max. six 3/32” pin knots
- Occasional small burls
- Slight mineral streaks
- No sapwood unless requested by customers
- Min. 5” component width
- Book matched

•**“B” Grade Red Oak**

- Max. twelve ¼” pin knots
- Scattered small burls
- No sapwood upon customer request
- Occasional color streaks, spots and mineral streaks
- Some color variation
- Min. 4” component width not including outside edges
- Book matched

6. Cherry Plywood- a beautiful close grained wood traditionally used in fine furniture. Its heartwood color ranges from light to medium reddish brown. Transparent finishes bring out the incredibly rich luster.

•**“A” Grade Cherry**

- Max. sixteen 5/32” pin knots
- Occasional small burls, gum spots
- Slight mineral streaks
- No sapwood unless requested by customer
- Some color streaks, spots, color variations
- Min. 5” component widths not including outside edges
- Book matched

•**“B” Grade Cherry**

- Up to 32 pin knots, 16 of which may be ¼”
- Scattered small burls and gum pockets
- No sapwood unless requested by customer
- Color streaks, gum spots and occasional crossbands accepted
- Some color variations
- Min. 4” component widths not including outside edges
- Book matched