

# B-BB Grading Rules



A WORLD OF EXPERIENCE  
IN ASIAN PANEL PRODUCTS



Panda Panel Agencies Ltd

**GENERAL GRADING RULES – CHINESE RED FACED POPLAR PLYWOOD & RED FACED HARDWOOD THROUGHOUT PLYWOOD**

**GRADE B/BB**

| Particulars                  | Face                                                                        | Back                                                                       |
|------------------------------|-----------------------------------------------------------------------------|----------------------------------------------------------------------------|
| Sound live knots             | Max diameter 13mm<br>Not clustered Max 4 per panel                          | Max diameter 25mm<br>Max 5 per panel                                       |
| Dead or unsound knots        | Not permitted                                                               | Not permitted                                                              |
| Open knot holes              | Not permitted                                                               | Not permitted                                                              |
| Pin knots                    | Permitted if tight and not clustered                                        | Permitted                                                                  |
| Sound burls                  | Permitted if smooth                                                         | Permitted                                                                  |
| Dry pitch pockets            | Not permitted                                                               | Permitted if well filled,<br>Max size 100 x 4mm, Max 2 per panel           |
| Minor natural Discolouration | Permitted if not conspicuous                                                | Permitted if only slightly conspicuous                                     |
| Stains / mineral streaks     | Permitted if not conspicuous                                                | Permitted if only slightly conspicuous                                     |
| Decay                        | Not permitted                                                               | Not permitted                                                              |
| Cross split                  | Hairline, max 100mm in length<br>Permitted, Max 1 per panel                 | As per face                                                                |
| Open split                   | Hairline, max 100mm in length<br>Permitted, Max 3 per panel<br>(unfilled)   | As per face                                                                |
| Filled splits                | Max size 150 x 3.0mm, max 2 at each End, well filled and matched for colour | Max size 300 x 5.0mm, max 2 at each end well filled and matched for colour |

|                                                                 |                                                                                               |                                                                                               |
|-----------------------------------------------------------------|-----------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------|
| Putty smear                                                     | Permitted if not conspicuous                                                                  | Permitted if not severe                                                                       |
| Pinworm holes / tracks                                          | Not permitted                                                                                 | Occasional pinworm holes permitted if Scattered, well filled and matched for colour           |
| Pin holes                                                       | Not permitted                                                                                 | Permitted if not conspicuous                                                                  |
| Vine marks                                                      | Max size 100 x 4.0mm, max 2 per Panel if level and smoothly sanded                            | Permitted if occasional if level and smoothly sanded                                          |
| Rough cut                                                       | Permitted if smoothly sanded                                                                  | Permitted if smoothly sanded                                                                  |
| Torn grain                                                      | Permitted if very slight                                                                      | Permitted if slight                                                                           |
| Patches                                                         | Not permitted                                                                                 | Permitted if not conspicuous, max 3 per Panel.                                                |
| Shims                                                           | Not permitted                                                                                 | Permitted if not conspicuous and do not exceed 300 x 5.0mm long grain.                        |
| Veneer joints                                                   | Max 1 per panel, well made, parallel to edges and well matched for colour and grain direction | Max 2 per panel, well made, parallel to edges and well matched for colour and grain direction |
| Tape or glue residue                                            | Not permitted                                                                                 | Permitted if slight and smoothly sanded                                                       |
| Knife marks                                                     | Not permitted                                                                                 | Max 0.7mm if smooth and not Conspicuous                                                       |
| Sanding                                                         | Smooth, free from conspicuous Streaks or chatter                                              | Smooth                                                                                        |
| Bark                                                            | Not permitted                                                                                 | Permitted if very slight                                                                      |
| Mechanical defects (oil stains, chain marks, sanding burns etc) | Not permitted                                                                                 | Permitted if not conspicuous                                                                  |
| Wet pitch                                                       | Not permitted                                                                                 | Not conspicuous                                                                               |
| Press marks                                                     | Not permitted                                                                                 | Not permitted                                                                                 |
| Core voids                                                      | Permitted, max 5mm wide filled with veneer                                                    |                                                                                               |
| Core gaps                                                       | Permitted, max 200 x 5.0mm, smooth and not severe                                             |                                                                                               |

**Note:** The aforementioned grading rules are not based on any specific grading rules and are a combination of BSI, IHPA & JPIC grading rules which are open to different interpretations.

Furthermore, these rules are intended to be used as general guidelines only and no responsibility will be accepted for qualities which do not comply with these guidelines.