



1. Quality requirements for oak strips

- Cutting:** Wood texture should be reasonably even. The edges should be sharp, parallel and rectangular.
- Wood:** Fresh strips without any mold, sawdust, spacer marks or failures occurred in the storage. Strip ends obligatory protected against shaking with paraffin.
- Quality:** **All classes free from following defects:** bark, dull edges, intergrown bark, cracks, knots on the edges and ends, slop of grain internal sap, rot, heart, pith, fungus, stains, wormholes, mechanical defects
- CLASS I:** Four sides clean and free of defects.
Acceptable: single, intergrown and light knots with diameter up to 3mm.
- CLASS II:** **Acceptable:** on “a” side (width 55 mm), single, intergrown and light knots with diameter up to 5mm; on “b” side acceptable diameter of a knot is 10 mm. On a “b” side - sound sap: up to the half of the width and up to the half of the height.
- CLASS III:** **Acceptable:** on “a” side (width 55 mm) single, intergrown and light knots with diameter up to 10 mm; ; on “b” side acceptable diameter of a knot is 15 mm. Sound intergrown sap. On “a” side external sap up to the 1/3 of the width, on “b” side without the limit.



SPECIFICATION OF DIMMENSIONS OF THE OAK STRIPS.

Freshly sawn strips.

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|------------------|------------------------------|
| 1. Cutting size: | 29 x 55 x 270 ÷ 520 co 50 mm |
| Invoicing size: | 26 x 50 x 250 ÷ 500 |
| 2. Cutting size: | 36 x 55 x 270 ÷ 520 co 50 mm |
| Invoicing size: | 32 x 50 x 250 ÷ 500 |
| 3. Cutting size: | 42 x 55 x 270 ÷ 520 co 50 mm |
| Invoicing size: | 38 x 50 x 250 ÷ 500 |
| 4. Cutting size: | 55 x 55 x 270 ÷ 520 co 50 mm |
| Invoicing size: | 50 x 50 x 250 ÷ 500 |

SPECIFICATION OF DIMMENSIONS OF THE OAK STRIPS (LONG).

Freshly sawn strips.

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|------------------|---------------------------------------|
| 1. Cutting size: | 29 x 55 x 700 ÷ 2300 mm co 200 mm |
| Invoicing size: | 26 x 50 x 600 ÷ 2200 mm |
| 2. Cutting size: | 36 x 55 x 1000 - 1100- 2000 - 2100 mm |
| Invoicing size: | 32 x 50 x 900 - 1000- 1900 - 2000 mm |
| 3. Cutting size: | 42 x 55 x 1000 ÷ 2300 mm co 200 mm |
| Invoicing size: | 38 x 50 x 900 ÷ 2200 mm |
| 4. Cutting size: | 55 x 55 x 1700 ÷ 2300 mm co 200 mm |
| Invoicing size: | 50 x 50 x 1600 ÷ 2200 mm |

Tolerance:

thickness - 0 + 2

width - 0 + 2

length - 0 + 5



2. Quality requirements for oak planks.

1. **Subject.** Subject of the quality requirements are oak planks used in solid floor production.
2. **Sizes.** Cutting sizes and invoicing sizes as per “chart 1”.
3. **Quality classes.** According to quality requirements (“chart 2”) we distinguish following classes:
 - class I (classic)
 - class II (natur)
 - class III (rustical)

To qualify a plank to appropriate class please consider better surface of a plank – “a” side.

4. **Machining.** Planks should have sharp edges. Thickness and width should be uniform on entire length of a plank. Machining imperfections should not exceed allowed tolerances (as per “chart 1”).

Chart 1.

Wood species	Invoicing sizes [mm]	Cutting sizes [mm]					
		Thickness		Width		Length	
Oak	26/145/600-2400	29	+2	155	+2	700	+5
			-0		-0	1000	
	26/175/600-2400			190		1300	
						1600	-0
						1900	
						2500	

Allowed curvature on side – up to 1mm per running meter.

Allowed curvature on surface - up to 5mm per running meter.



Chart 2.

Class	Quality requirements
Class I (classic)	<p>Allowed:</p> <ul style="list-style-type: none"> - single, healthy knots max. 3 mm diameter. (sporadically) - any grain layout - external sap on the “b” side up to the 1/3 of the thickness. <p>Not allowed:</p> <ul style="list-style-type: none"> - sap on “a” side - discolouration - falling out, rotten and open knots - rot - slop of grain - intricate grain layout - knot nests - worm holes
Class II (natur)	<p>Allowed:</p> <ul style="list-style-type: none"> - single, healthy knots max. 10 mm diameter. - black knots up to 5 mm diameter - all knots with diameter more than 5 mm must be located at least 30 mm from the edge - any grain layout - external sap on the “b” side up to the 1/3 of the thickness.. <p>Not allowed:</p> <ul style="list-style-type: none"> - sap on “a” side - discolouration - falling out, rotten and open knots - rot - slop of grain - intricate grain layout - knot nests - worm holes
Class III (rustical)	<p>Allowed:</p> <ul style="list-style-type: none"> - healthy knots max. 40 mm diameter - black knots max. 25 mm diameter - knot holes max.15 mm diameter - any grain layout - surface cracks up to 15 % of the plank length and maximum 5 mm deep - heart stains - big colour differences



	<ul style="list-style-type: none">- intergrown bark- sap <p><i>Not allowed:</i></p> <ul style="list-style-type: none">- rot- wormholes
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NOT ACCEPTABLE IN ANY CLASS:

- end grain cracks
- bullets and metal pieces
- blue stain
- fungus

Important:

Planks with 2400 mm length must amount to minimum 30% of the load
Planks with length up to 1000 mm may amount to maximum 10% of the load.



3. Quality requirements for oak plank „Saget”.

Cutting: Wood texture should be reasonably even. The edges should be sharp, parallel and rectangular.

Wood: Fresh strips without any mold, sawdust, spacer marks or failures occurred in the storage. Strip ends obligatory protected against shaking with paraffin.

Quality: **All classes free from following defects:** bark, dull edges, intergrown bark, cracks, knots on the edges and ends, slop of grain, rot, heart, pith, fungus, stains, wormholes, mechanical defects

Side A/Top/ Acceptable: sound sap wood up to the 20% of the width of the plank. Sound knots up to 50 mm, falling out and cracked knots, knot holes up to 8 mm (must be located at least 25 mm from the side edges and 100 mm from end grain edges, sound internal sap

Side B/Bottom/ Acceptable: sound sap wood up to 100% of the surface. Sound knots up to 50 mm, falling out and cracked knots, knot holes up to 8 mm (must be located at least 25 mm from the side edges and 100 mm from end grain edges, sound internal sap, sporadically open heart.

Dimmensional specification

No	Cutting size	Invoicing size	Pcs.
1	30x78;115;155x1300	26x70;105;145x1200	
2	30x78;115;155x1600	26x70;105;145x1500	
3	30x78;115;155x2100	26x70;105;145x2000	
4	30x78;115;155x2600	26x70;105;145x2500	
5	42x78;115;155x2100	36x70;105;145x2000	
6	42x78;115;155x2600	36x70;105;145x2500	



4. Quality requirements for oak planks class ‘CHINKA’.

1. **Subject.** Subject of the quality requirements are oak planks used in solid floor production.
2. **Sizes.** Cutting sizes and invoicing sizes as per “chart 1”.
3. **Quality requirements:** as per „chart 2”

5. **Machining.** Planks should have sharp edges. Thickness and width should be uniform on entire length of a plank. Machining imperfections should not exceed allowed tolerances (as per “chart 1”).

Chart 1.

Species	Invoicing sizes [mm]	Cutting sizes [mm]					
		Thickness		Width		Length	
Oak	25/120/600	29	+2	130	+2	700	+5
	25/120/1200		-0		-0		1300



Chart 2

Class	Quality requirements
Chinka	<p>Acceptable:</p> <ul style="list-style-type: none">- sound knots up to 50 mm- dark knots up to 30 mm- knot holes up to 20 mm- minimum distance from the edge for knots is 30 mm- any grain layout- surface cracks up to 15 % of the plank length and maximum 5 mm deep (end grain cracks not acceptable)- heart stains- big colour differences- intergrown bark- sap- knot nests- slop of grain <p>Not acceptable:</p> <ul style="list-style-type: none">- rot- wormholes- knots on the edges / sides



5. Quality requirements for trimmed oak planks

1. **Subject.** Subject of the quality requirements are trimmed oak planks used in solid floor production.

2. **Sizes.** Cutting sizes and invoicing sizes as per “chart 1”.

3. **Quality requirements:** as per „chart 2”

4. **Machining.** Planks should have sharp edges. Thickness and width should be uniform on entire length of a plank. Machining imperfections should not exceed allowed tolerances (as per “chart 1”).

Chart 1.

Species	Invoicing sizes [mm]	Cutting sizes [mm]					
		Thickness		Width		Length	
Oak	26/145/1800- 2400-3000- 3600-4200	29	+2	155	+2	1900	+5
	-0		-0		2500		
	26/175/1800- 2400-3000- 3600-4200			190		3100	-0
						3700	
						4300	

Allowed curvature on side – up to 1mm per running meter.

Allowed curvature on surface - up to 5mm per running meter.



Chart 2

Class	Quality requirements
Chinka	<p>Acceptable:</p> <ul style="list-style-type: none">- sound knots up to 40 mm- dark knots up to 25 mm- knot holes up to 15 mm- sound knots on the edges- dark knots on the edges up to 15mm diameter- any grain layout- surface cracks up to 15 % of the plank length and maximum 5 mm deep (end grain cracks not acceptable)- heart stains- big colour differences- intergrown bark- sap- heart max in 10% of planks <p>Not acceptable:</p> <ul style="list-style-type: none">- rot- wormholes- end grain cracks- bullets and metal pieces- blue stain- fungus