

Dimensional tolerances

The indicated tolerances may not be kept by second quality boards.

N.B.: The indicated values of tolerances comply with EN 634-1.

PROPERTY	TOLERANCE
Thickness of the unsanded boards – nominal thickness 8 or 10 mm	±0.7 mm
Thickness of the unsanded boards – nominal thickness 12 or 14 mm	±1.0 mm
Thickness of the unsanded boards – nominal thickness 16 or 18 mm	±1.2 mm
Thickness of the unsanded boards – nominal thickness 20 to 40 mm	±1.5 mm
Thickness of sanded boards	±0.3 mm
Length and width of the board 3350×1250 mm	±5.0 mm
Length and width of the divided board (smaller than 3350×1250 mm)	±3.0 mm
Straightness of the edges	1.5 mm/m
Rectangularity	2.0 mm/m

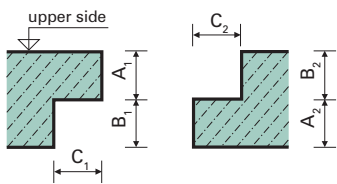
Appearance

PROPERTY	ZUGELASSENE WERTE	
	FIRST QUALITY	SECOND QUALITY
Rectangularity	up to 2 mm/1 m of length	up to 4 mm/1 m of length
Edges impairment	up to depth 3 mm	up to depth 30 mm
Outthrusts in the surface	height up to 0.5 mm, width up to 10 mm	height up to 1 mm
Recessions	depth up to 1 mm, width up to 10 mm	depth up to 2 mm
Various	Thin edges, bark in the surface, pressed-in cement, peeled-off edges, corners and edges damaged by the saw blades.	

Services

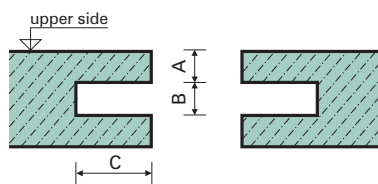
The tolerances are set in a way to guarantee correct assembly of boards.

Semigroove



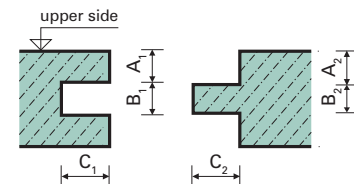
Dimension	Tolerance	Dimension	Tolerance
A ₁	-1 / 0	A ₂	-1 / 0
B ₁	0 / +1.5	B ₂	0 / +1.5
C ₁	0 / +2	C ₂	-2 / 0

Groove



Dimension	Tolerance
A	-0,5 / +0.5
B	0 / +1.5
C	0 / +2

Tongue and groove

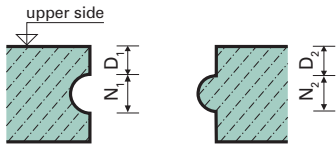


Dimension	Tolerance	Dimension	Tolerance
A ₁	±0.5	A ₂	±0.5
B ₁	0 / +0.5	B ₂	-0.5 / 0
C ₁	0 / +2	C ₂	-2 / 0

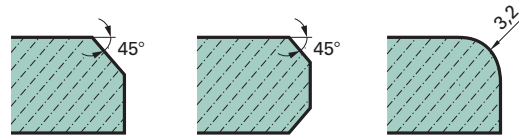
All dimension in mm.

Technical Specifications of the CETRIS®-Boards

Rounded tongue and groove



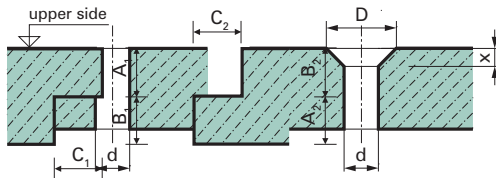
Chamfered and rounded edges



Dimension	Tolerance	Dimension	Tolerance
D ₁	±0.5	D ₂	±0.5
N ₁	0 / +0.5	N ₂	-0.5 / 0

Tolerance
Tolerance of machining ±0.5 mm

Holes



Tolerance of hole positions ±5 mm.

Hole	Hole diameter		Countersink depth x (mm)	Board thickness (mm)
	d (mm)	D (mm)		
Straight	4.5 – 8.0 ±0.5	–	–	8 – 40
Straight	10.0 – 12.0 ±1.0	–	–	8 – 40
Countersunk	4.5 ±0,5	9.5 ±0.5	2.5 ±0.5	12 – 40
Countersunk	5.5 ±0.5	10.0 ±0.5	2.5 ±0.5	12 – 40
Countersunk	6.5 ±0.5	17.0 ±1.0	5.0 ±1.0	12 – 40

Coating

Painted boards shall be evenly covered with paint. Colour stability is guaranteed for 3 years (corresponding to the warranty by the paint supplier).

Colour tones can be chosen from RAL or NCS colour tables. Practicability of the chosen colour tone should be consulted with us.

The samples of a chosen colour tone are coated (sprayed) manually. Appearance of the samples can differ from the delivered machine-coated (rolled) boards (e.g. by structure and covering power of the coating). The samples serve as approximate information about the color tone only.

All dimensions in mm.