

Japan Plywood Inspection Corporation Standards (JPIC 日本合板検査会)

PLYWOOD FOR GENERAL USES

Standard of inspection, method of inspection, grades, standards of grades and methods of determining grades.

Grading:

Quality	Item	a	b	c	d
Knot (Pin Knot is Excluded), Bark Pocket or Pitch Pocket	Total Number of Knots, Bark Pocket and Pitch Pocket (Bark Pocket and Pitch Pocket Having 1/8 in. or Less of Maximum Diameter are Excluded)	Total number shall not exceed a quotient resulted from dividing the surface area in sq.ft. by 5 sq.ft. For China, the total number shall not exceed two multiples of above quotient. (If the quotient has any fraction, the quotient shall read as its integer plus "1")	Total number shall not exceed two multiples of a quotient resulted from dividing the surface area in sq.ft. For China, the total number shall not exceed three multiples of above quotient. (If the quotient has any fraction, the quotient shall read as its integer plus "1")	Not limited	Not limited
	Sound Knot	1/2 in. or less of maximum diameter	3/4 in. or less of maximum diameter	2 in. or less of maximum diameter	Not limited
	Dead Knot	1/8 in. or less of maximum diameter	1/4 in. or less of maximum diameter	1/2 in. or less of maximum diameter	1—1/2 in. or less of maximum diameter
	Knot Hole	1/8 in. or less of maximum diameter and it shall be mended skillfully	1/4 in. or less of maximum diameter and it shall be mended skillfully	1/2 in. or less of maximum diameter and it shall be mended skillfully	1—1/2 in. or less of maximum diameter
	Bark Pocket or Pitch Pocket	1/4 in. or less of maximum diameter. Or 1/16 in. or less of width and 3/4 in. or less of length.	1/2 in. or less of maximum diameter. Or 1/8 in. or less of width and 3/4 in. or less of length.	3 in. or less of maximum diameter	Not limited
Pin Knot	It shall not impair slightly appearance.	It shall not impair slightly appearance so remarkably	Not Limited	Not Limited	
Discoloration	Very Slightly	Slight	Not conspicuous	Not conspicuous	
Decay	None	None	None	Very Slight	
Split	It shall be filled skillfully. 1/32 in. or less of width; and	It shall be filled skillfully. 1/16 in. or less of width; and	It shall be filled. 1/8 in. or less of width; and length shall not exceed	1/4 in. or less of width and length shall not exceed 20	

	length shall not exceed 5 percent of the piece length	length shall not exceed 10 percent of the piece length	15 percent of the piece length	percent of the piece length. But the filled one shall not exceed 1/2 in. of width and length of 25 percent of the piece length.
Cross Break	None	None	Length shall not exceed 10 percent of the piece width	Length shall not exceed 20 percent of the piece width
Worm Hole	1/16 in. or less of maximum diameter. Those shall be mended skillfully and shall not be clustered	1/8 in. or less of maximum diameter. Those shall be mended skillfully and shall not be clustered	1/4 in. or less of maximum diameter. Those shall be mended	3/4 in. or less of maximum diameter. Not limited for the mended ones
False Heartwood (Applicable only to Beech)	Colors shall be well matched	Colors shall be matched	Not Limited	Not Limited
Sound Burl	Very Slight	Slight	Not Conspicuous	Not Limited
Rough Cut , Torn Grain, Brashness	3 percent or less of the surface area, Very slight	Do	5 percent or less of the surface area, slight	10 percent or less of the surface area, Not conspicuous
Shim	Length shall not exceed 10 percent of the piece length, Colors and grains shall be matched. Gap is not acceptable	Colors and grains shall be matched. Gap is not acceptable	Colors shall be matched. Gap is not acceptable	Not Limited
Joint	Colors and grains shall be matched in conformity to the condition of joint. Gap is not acceptable. Joint running slatendicular shall not be conspicuous	Colors and grains shall be matched in conformity to the condition of joint. Gap shall not exceed 1/64 in. of width and length of 10 percent of the piece length. It shall be mended skillfully. Joint running slatendicular shall be scarcely conspicuous	Colors and grains shall be almost matched in conformity to the condition of joint. Gap shall not exceed 1/32 in. of width. It shall be mended. Joint running slatendicular shall be scarcely conspicuous.	Gap shall not exceed 1/8 in. of width
Blister	None	None	None	None
Wrinkle	None	None	None	Slight
Flaw and Depression	None	None	Very slight	Not conspicuous
Hole (worm hole is excluded)	1/16 in. or less of maximum diameter. It shall be mended	1/8 in. or less of maximum diameter. It shall be mended	1/4 in. or less of maximum diameter. It shall be mended	1—1/2 in. or less of maximum diameter.

	skillfully	skillfully		
Finishing	Good Finish	Do	Almost good finish	Do
Insufficient Removal of Tape	None	Do	Do	Slight
Perforation and other process(Applicable only to the processed plywood)	Good Finish	Do	Do	Not Rough
Finishing of transparent coating which does not obscure the grain or texture.(Applicable only to plywood finished by transparent coating)	Good Finish	Do	Do	
Other Defects	Very slight	Slight	Do	Not limited