

## Hardwood Plywood and Veneer Association

### HPVA Grading For Hardwood Plywood:

Characteristics vary according to species, but there is a basic grading structure which is followed for all species described in the current Voluntary Standard. The most uniform color and grain is at the top of the scale for face grade.

Grade	Sub Grade	Applications & Descriptions
Face Grade	AA	The best quality face grade for high end uses such as architectural paneling, doors and cabinets, case goods, and quality furniture.
	A	Where AA is not required but excellent appearance is very important as in cabinets and furniture.
	B	Where the natural characteristics and appearance of the species are desirable.
	C,D, and E	Provide sound surfaces but allow unlimited color variation; grades C, D, and E, respectively, allow repairs in increasing size ranges. Applications: where surface will be hidden or a more natural appearance is desired.
	Specialty	Appearance characteristics are not standardized and are subject to agreement between the individual buyer and seller, as in factory finished wall paneling. Usually, effects such as those created by wormy chestnut, bird's eye maple, and English brown oak are considered specialty grade.
Back Grade	1,2,3,and 4	Back grades are designed by numbers: 1,2,3, and 4. Requirements of grade 1 are most restrictive, with grade 2, 3, and 4 being progressively less restrictive. Grade 1 and 2 provide sound surfaces with all openings in the veneer repaired except for vertical worm holes not larger than 1.6mm(1/16' . Grades 3 and 4 permit some open defects; however, grade 3 can be obtained with repaired splits, joints, bark pockets, laps, and knotholes to achieve a sound surface if specified by the buyer. Grade 4 permits knotholes up to 102mm (4' ,in diameter and open splits and joints limited by width and length.
Veneer Inner Ply Grade	J , K , L, and M	Four inner ply grades are described with the following letter designations: J,K L, and M. Grade J is the most restrictive, allowing minimal size openings. Grades K, L, and M are progressively less restrictive. The least restrictive grade (M) is usually reserved for piles not adjacent to faces and allows round and similar shaped openings not to exceed 63.5mm (2 1/2' and elongated openings up to 25.4mm(1' as visible on the edges or ends of panels.