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ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION

R 1072

GENERAL MANUFACTURING CHARACTERISTICS OF SOLID WOOD PARQUET STRIPS WITH RECTANGULAR FACE

1st EDITION

May 1969

For each individual country the only valid standard is the national standard of that country.

Printed in Switzerland

Also issued in French and Russian. Copies to be obtained through the national standards organizations.

BRIEF HISTORY

The ISO Recommendation R 1072, *General manufacturing characteristics of solid wood parquet strips with rectangular face,* was drawn up by Technical Committee ISO/TC 99, *Semi-manufactures of timber,* the Secretariat of which is held by the Oficiul de Stat Pentru Standarde (OSS).

Work on this question led to the adoption of a Draft ISO Recommendation.

In December 1965, this Draft ISO Recommendation (No. 885) was circulated to all the ISO Member Bodies for enquiry. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Argentina	Czechoslovakia	Romania
Australia	France	Switzerland
Austria	Germany	Turkey
Belgium	Hungary	U.A.R.
Brazil	Italy	U.S.S.R.
Bulgaria	Netherlands	
Colombia	Poland	

Two Member Bodies opposed the approval of the Draft :

Paraguay
Yugoslavia

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in May 1969, to accept it as an ISO RECOMMENDATION.

ISO Recommendation R 1072 May 1969

GENERAL MANUFACTURING CHARACTERISTICS OF SOLID WOOD PARQUET STRIPS WITH RECTANGULAR FACE

1. SCOPE

This ISO Recommendation sets down the terminology, the manufacturing characteristics (cross-section, dimensions, admissible deviations, etc.) and the inspection and delivery conditions of solid wood parquet strips with rectangular face made from any species of wood.

The classification according to specific characteristics, wood defects and possible exceptions is set down, for the different species of wood, in particular ISO Recommendations intended for classification.

2. DEFINITIONS

2.1 Terminology*

2.1.1 *Solid wood parquet.* Aggregate of parquet strips assembled in a horizontal plane and forming the upper part of a floor.

2.1.2 *Solid wood parquet strip.* Element of manufactured wood with smooth upper face, uniform thickness and uniform cross-section, destined to make a parquet by jointing to other similar elements.

2.1.3 *Face-side.* Face of the parquet strip intended to remain visible after laying.

2.1.4 *Back (Bottom-side).* Face opposed to the face-side.

2.1.5 *Integrated tongue.* Continous protruding part machined in the thickness of the parquet strip and intended to be engaged in the groove of the adjacent strip.

2.1.6 *Detachable tongue.* Assembling element serving to join two continuous parquet strips provided with grooves only.

2.1.7 *Groove.* Continuous slot cut in the thickness of a strip and intended to receive either an integrated or a detachable tongue.

2.1.8 *"Right-hand" tongue.* A strip is said to have "right-hand" tongue when, looking on the strip with the face-side upwards and the edge tongue of the latter facing the observer, the end tongue is to the right.

* For forms and definitions referring to parts of sawn timber, see ISO Recommendation R 1032, *Coniferous sawn timber – Sizes – Terms and definitions.*

2.1.9 *"Left-hand" tongue.* A strip is said to have "left-hand" tongue when, looking on the strip with the face-side upwards and the edge tongue of the latter facing the observer, the end tongue is to the left (see Fig. 1 below).

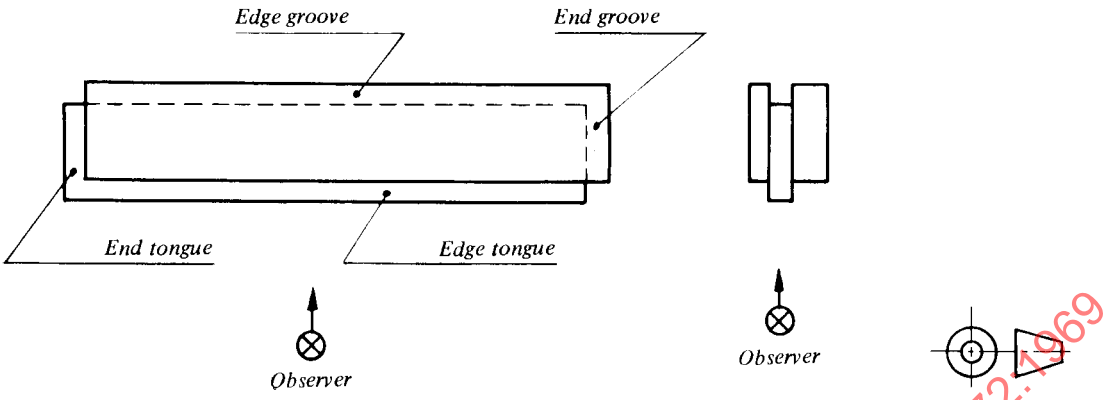

FIG. 1

2.1.10 *Wear-layer.* That part of a strip thickness between the face-side and the upper plan of the groove (see Fig. 2 below).

2.1.11 *Floor-layer.* That part of a strip thickness between the lower plan of the groove and the bottom-side (see Fig. 2 below).

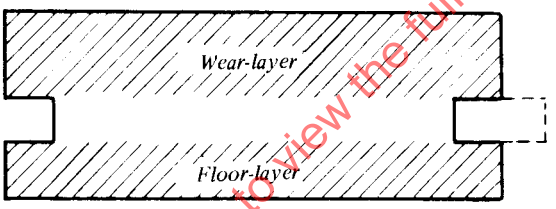

FIG. 2

2.2 Designation

Parquet strips are designated by stating successively

(1) the type;

(2) the dimensions (thickness X width X length, expressed in millimetres);

(3) the symbol of the wood species according to the code established by ISO Recommendation R ....* *Code for the marking of the different species of wood of semi-manufactured timber.*

Examples of designation

(*a*) Designation of oak parquet strips, type P_1, 22 mm thick, 50 mm wide and 300 mm long (fixed length) of the first class of quality :

Parquet strip P_1 22 X 50 X 300 QUER XXX;

(*b*) the same, in the variant "A" :

Parquet strip P_1/A 22 X 50 X 300 QUER XXX;

(*c*) the same, in various lengths between 350 and 950 mm :

Parquet strip P_1 22 X 50 X 350 ... 950 QUER XXX.

* At present at the stage of draft proposal.

3. MANUFACTURE

The finished strips should have the dimensions and the cross-section specified in section 4.

The faces should be flat. Contiguous faces and edges should form parallel sharp edges.

The ends should be perpendicular to the edges within 0.4 % allowance.

The face-side should be smooth and the manufacturing faults limited (see ISO Recommendation R ...,* for the classification of wood species).

Unless otherwise agreed upon, the strip edges and ends should have the same pattern.

The joining of the tongue and the groove, in the case of strips with integrated tongue, should be possible without resistance and without excessive clearance.

In the case of strips with detachable tongues, the tongues should enter the grooves with a slight resistance and without clearance.

4. CHARACTERISTICS

4.1 Geometrical characteristics

4.1.1 *Profile.* The solid wood parquet strips are manufactured in three different shapes described as types P_1, P_2 and P_3, having the dimensional characteristics given in Tables 1, 2 and 3, and shown in Figures 3, 4 and 5.

* At present under consideration.

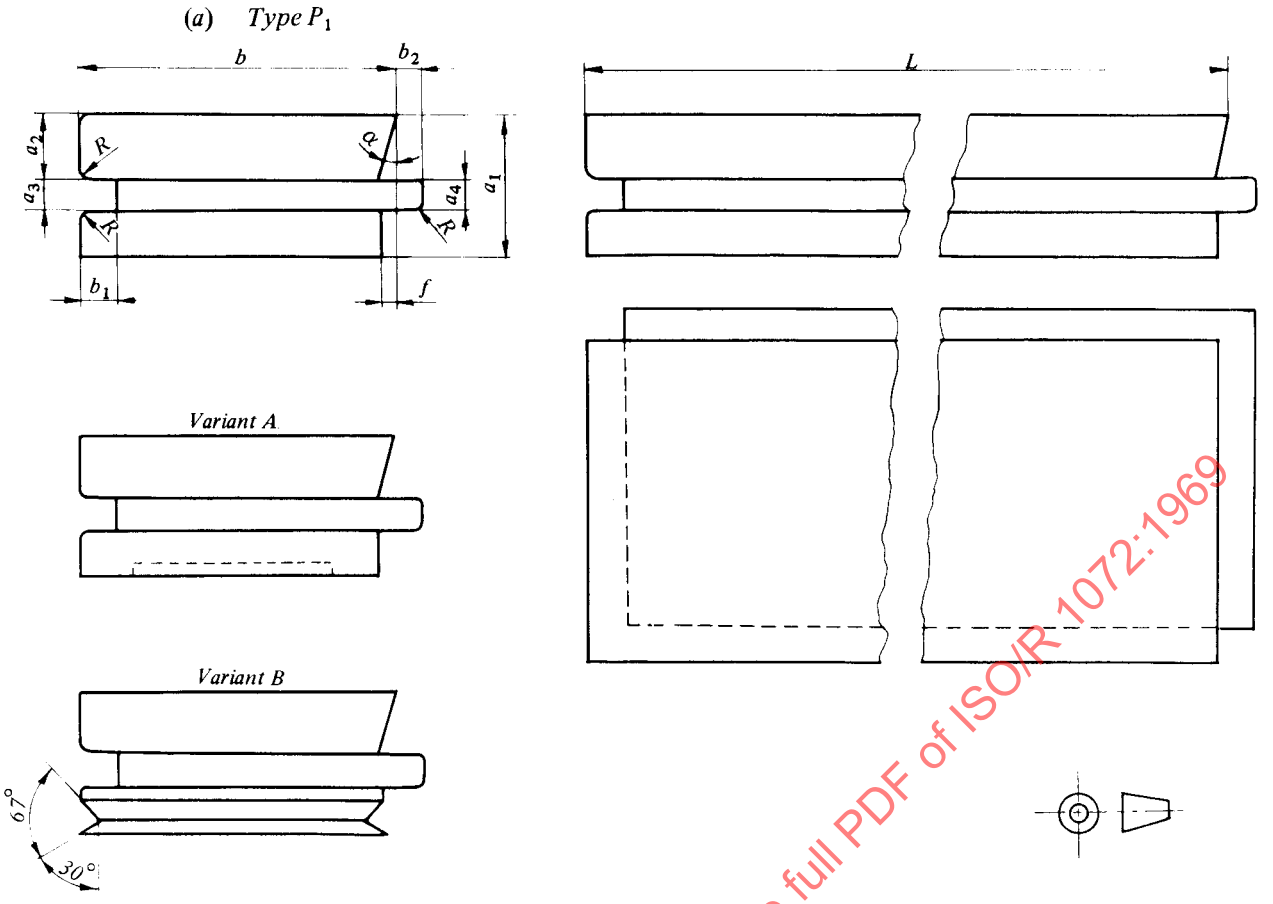

FIG. 3 – **Strip of type P_1**

The type P_1 may be ordered with a slotter (variant A) or a dovetail (variant B) in the floor-layer (see Fig. 3). On demand the strips can be delivered with grooves on both ends.

TABLE 1 – **Dimensional characteristics of type P_1**

	Symbols	Dimensions mm			Tolerances mm
Thickness of parquet strip	a_1	16	19	22	± 0.2
Thickness of wear-layer	a_2	7	8.5	10	± 0.1
Height of groove	a_3	5.2	5.2	5.2	± 0.1 *
Depth of groove	b_1	6	6	6	± 0.3
Thickness of tongue	a_4	4.9	4.9	4.9	± 0.1 *
Width of tongue	b_2	5	5	5	± 0.3
Rounding-off radius of groove, edge-tongue, and possibly end-tongue	R	0.5 to 1			
Recess of floor-layer (tongue side)	f	1	1	1	± 0.2
Bevel of wear-layer (tongue side)	α	5 %			

* In cases where the end-tongue and end-groove are not rounded off, the following tolerances should be applied :

tongue thickness $\begin{matrix}0\\-0.2\end{matrix}$ mm

height of groove $\begin{matrix}+0.2\\0\end{matrix}$ mm

(*b*) *Type* P_2

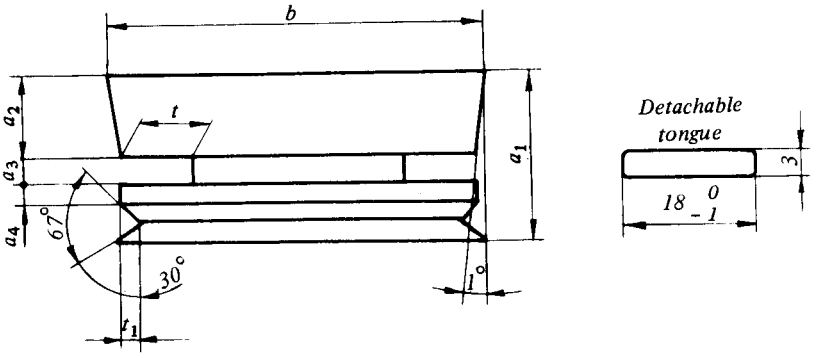

FIG. 4 – **Strip of type P_2**

TABLE 2 – **Dimensional characteristics of type P_2**

	Symbols	Dimensions mm		Tolerances mm
Thickness of parquet strip	a_1	19	22	± 0.2
Thickness of wear-layer	a_2	9	11	± 0.1
Height of groove	a_3	3	3	± 0.1
Thickness	a_4	3	3	± 0.2
Depth of groove	t	10	10	± 0.5
Depth of recess	t_1	4	4	± 0.2

(*c*) *Type* P_3

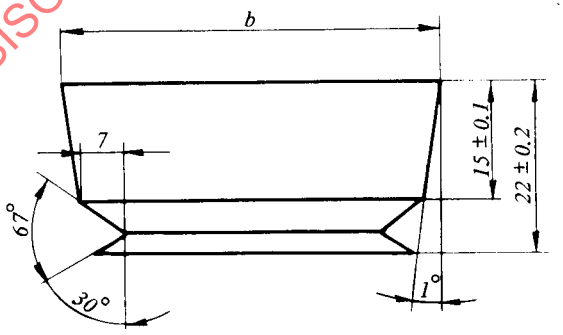

FIG. 5 – **Strip of type P_3**