

# ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

## ISO RECOMMENDATION R 631

MOSAIC PARQUET PANELS

1st EDITION  
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## BRIEF HISTORY

The ISO Recommendation R 631, *Mosaic Parquet Panels*, was drawn up by Technical Committee ISO/TC 99, *Semi-manufactures of Timber*, the Secretariat of which is held by Oficiul de Stat Pentru Standarde (OSS).

Work on this question by the Technical Committee began in 1960 and led, in 1963, to the adoption of a Draft ISO Recommendation.

In November 1964, this Draft ISO Recommendation (No. 756) 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:

Australia	Hungary	Romania
Belgium	Iran	Switzerland
Czechoslovakia	Japan	Turkey
France	Netherlands	U.S.S.R.
Germany	New Zealand	Yugoslavia
Greece	Poland	

No Member Body opposed the approval of the Draft.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in November 1967, to accept it as an ISO RECOMMENDATION.

## MOSAIC PARQUET PANELS

### 1. SCOPE

The scope of this ISO Recommendation is

- to set down the manufacturing conditions for mosaic parquet panels made from any species of wood;
- to specify the characteristics of the panels and panel components of mosaic parquet panels and to classify them according to their quality and appearance;
- to specify the state upon delivery and the packaging and marking conditions of mosaic parquet panels.

This ISO Recommendation applies only to mosaic parquet panels made up from rectangular fingers, forming component squares laid in a chequered pattern and intended to be bonded (or fixed) to a supporting base, edge to edge, either directly or with an interlayer of adequate material.

### 2. TERMINOLOGY AND DESIGNATION

#### 2.1 Mosaic parquet panel

Aggregate made up from wooden components (fingers) laid on a single layer and preassembled by juxtaposition, either by means of a material temporarily fixed (paper glued on the face for example) or of a sufficiently flexible material, permanently fixed.

Generally the panel is square in shape, being made up from fingers assembled in component squares, laid in a chequered pattern (see Figure 1, below). Other patterns may also be formed.

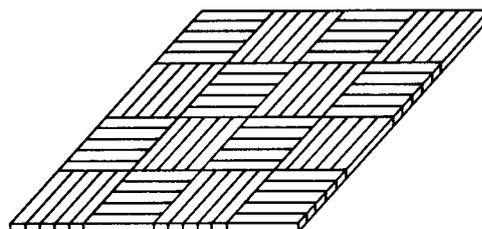


FIG. 1. — Mosaic parquet panel

## 2.2 Finger (of mosaic parquet)

Solid wood component of small dimensions, having regular form and planed edges (see Figure 2, below).

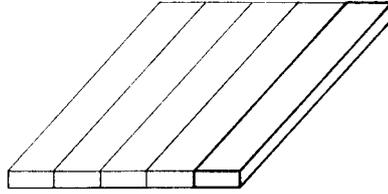


FIG. 2. — Finger

## 2.3 Component square

Assembly of fingers placed edge to edge making up a square, the side of which is equal to the length of the finger.

## 2.4 Designation

Mosaic parquet panels corresponding to this ISO Recommendation should be designated by specifying, in the order given below, the following

- the words “mosaic parquet”;
- thickness of the fingers, in millimetres;
- length and width of panel, in millimetres;
- number of fingers per component square;
- class (see clause 4.2), in Roman figures;
- species of wood.

Example: Mosaic parquet  $8 \times 400 \times 400 - 5-I$ , oak.

## 3. MANUFACTURE

### 3.1 The characteristics specified below refer to fingers with a reference moisture content of 11 % of dry weight.

NOTE. — This reference moisture content is not inconsistent with the moisture limits set down later on. It is intended to let the manufacturer provide for the increase or the reduction of finger dimensions, during machining operations and according to the moisture content of the wood at the time of manufacture, so that, for a moisture content of 11 %, the finger dimensions should be within the permitted tolerances.

**3.2** The fingers should have the following dimensions:

- thickness: 6, 8 and 10 mm;  
the 6 mm thickness is not suitable for softwood and for the softer grades of hardwood;
- width: 18 to 25 mm inclusive, preferred widths being 20, 24 and 25 mm;
- length: 100 to 165 mm inclusive, preferred lengths being 100, 120 and 125 mm.

**3.3** The maximum permitted deviations from the nominal dimensions indicated by the manufacturer should be as follows:

	Thickness mm	Width mm	Length mm	Diagonal * mm
On a single panel	—	± 0.5	± 0.5	± 0.8
On each component square of the panel	± 0.2	± 0.2	± 0.2	—
On any point of any finger making up the panel	± 0.2	+ 0.1 - 0.2	± 0.2	—

\* In relation to the nominal theoretical diagonal.

A panel, however, is considered to be acceptable if not more than 5% of the fingers have dimensions with deviations not exceeding twice the size of the deviations indicated above.

#### 4. REQUIRED CHARACTERISTICS

##### 4.1 General requirements

The wood used should be sound and free of any damage caused by insects or by fungus, which may affect the wear resistance properties of the wood.

Ring-shakes are not permitted.

Medullary rays are permitted.

For hardwood species having distinct coloured heartwood, the parts of the wood not converted into darker coloured heartwood (sapwood, included sapwood) are not permitted on the faces. The latter are permitted only on the backs, provided that they are sound and located at not less than 5 mm below the face.

The protection or non-protection of sapwood against damage by insects should be specially agreed upon by the parties.

Any treatment applied should not affect either the appearance or the fixing and bonding characteristics of the material.

## 4.2 Description of classes

The mosaic parquet panels are divided into two classes.

In both classes, sound knots with a diameter not exceeding 2 mm and black knots with a diameter not exceeding 1 mm are ignored.

The standard classes should comply with the respective conditions stated below:

### 4.2.1 Class I

*Processing.* The fingers may be quarter, half quarter or tangential sawn provided that the amount of tangential sawn fingers does not exceed 30% of each panel.

*Face.* The face should be free of knots other than those specified above, as well as decay and abnormal colorations.

#### NOTES

1. Any abnormality of the chemical composition of wood causing a change of the properties and affecting the usefulness of the material is considered to be "decay".
2. A colouration which is different from the normal average, colouration of the sound wood of a given species, is considered to be "abnormal colouration". However, colour variation which are specified to exotic hardwood species are not considered to be abnormal.

*Back.* Knots up to 5 mm in diameter and other slight defects are permitted.

### 4.2.2 Class II

No processing or colour restrictions are imposed on fingers belonging to this class.

*Face.* The following defects are permitted on the face, on not more than 25% of the fingers which make up a panel:

- sound knots, of a colour very nearly approaching that of the adjoining wood (sound knots);
- adherent knots, of a colour contrasting with that of the adjoining wood (black knots);
- cross grain;
- veined wood;
- seasoning checks;
- resin pockets;
- stains;