DIN EN 13647:2011-08 (E)

Wood flooring and wood panelling and cladding - Determination of geometrical characteristics

Contents

Page

Foreword 4

Introduction 4

1 Scope 5

2 Normative references 5

3 Terms and definitions 5

4 Principles 5
4.1 General 5
4.2 Dimensions 5
4.3 Angles 5
4.4 Warp 5
4.4.1 Cup 5
4.4.2 Bow 7
4.4.3 Spring 8
4.5 Lipping 9

5 Equipment 10
5.1 General 10
5.2 Equipment to measure the dimensions 10
5.2.1 Calliper 10
5.2.2 Micrometer 10
5.2.3 Graduated rule 10
5.3 Equipment to measure angle values 10
5.3.1 General 10
5.3.2 Equipment for square cut elements 11
5.3.3 Equipment for mitre-cut elements 11
5.4 Equipment to measure warp 11
5.4.1 Equipment to measure cup 11
5.4.2 Calibration plate 11
5.4.3 Equipment to measure bow and spring 11
5.4.4 Equipment to measure lipping 11
5.4.5 Conditioning equipment, if relevant 11

6 Procedure 12
6.1 Dimensions and shape 12
6.2 Conditioning 12
6.3 Measurement and recording 12
6.4 Dimensions 12
6.4.1 Length and width of the element 12
6.4.2 Thickness of the element 12
6.5 Additional dimensions, if relevant 13
6.5.1 Overall dimensions 13
6.5.2 Depth of the groove 13
6.5.3 Width of the tongue 13
6.5.4 Thickness of the tongue 14
6.5.5 Width of the groove 14
6.5.6 Undercut 14

6.5.7 Thickness of the upper lip 14
6.5.8 Thickness above the groove 14
6.6 Angles 15
6.6.1 Squareness 15
6.6.2 Mitre cuts 15
6.7 Warp 15
6.7.1 Cup 15
6.7.2 Bow 16
6.7.3 Spring 16
6.7.4 Lipping 16

7 Expression of results 16
7.1 Dimensions 16
7.1.1 Length and width of the element 16
7.1.2 Thickness of the element 16
7.2 Additional dimensions, if relevant 17
7.2.1 Overall dimensions 17
7.2.2 Depth of the groove 17
7.2.3 Width of the tongue 17
7.2.4 Undercut 17
7.2.5 Thickness of the tongue 17
7.2.6 Width of the tongue 17
7.2.7 Thickness of the upper lip 17
7.2.8 Thickness above the groove 17
7.3 Angle measurement 17
7.3.1 Squareness 17
7.3.2 Mitre cuts 18
7.4 Warp 18
7.4.1 Cup 18
7.4.2 Bow 18
7.4.3 Spring 18
7.4.4 Lipping 18

8 Test report 18

Annex A (informative) Apparatus for square cut elements 19

Annex B (normative) Test rig to measure cup 20