

AMENDMENT NO. 1 MARCH 2025
TO
IS 303 : 2024 PLYWOOD FOR GENERAL PURPOSES — SPECIFICATION
(Fourth Revision)

(Page 1, clause 4.3) — Substitute the following for the existing:

4.3 In terms of bending class, each grade of plywood shall be further classified in bending classes as follows:

- a) Bending Class F10;
- b) Bending Class F20;
- c) Bending Class F30;
- d) Bending Class F40; and
- e) Bending Class F50.

4.4 These shall be manufactured in accordance with **7.1** and **7.2**. The grades and classes shall conform to the general and workmanship requirements given in **8** and **9** respectively, and the test requirements laid down in **11**.’

(Page 1, clause 5.1) — Substitute the following for the existing:

5.1 Surfaces of plywood for general purposes shall be classified into different types namely A, B and C based on their quality. The type of plywood shall, therefore, be designated by the kind of surfaces (top and bottom) of the panels. The better quality surface shall be called ‘face (top)’, and the opposite side shall be called ‘back (bottom)’. The type of plywood shall denote first the quality of top followed by the quality of bottom. For example, Type AA shall have both surfaces of quality A, Type AB shall have top of quality A and the bottom of quality B and Type CC shall have both the surfaces of quality C. Plywood of both C type surfaces shall be used only in applications where the plywood used to get covered by other materials like foam/upholstery. The manufacturer shall declare the type of plywood as above mentioned in the example.’

(Page 1, clause 5.2) — Insert the following at the end:

5.3 The surface quality requirements (*see 5.1 and 5.2*) shall not apply to the plywood used as base material for any type of decorative plywood or any other further overlays.’

(Page 2, Table 1) — Substitute the following for the existing:

‘Table 1 Quality Requirements of Surfaces of Plywood for General Purposes

(Clause 5.2)

Sl No.	Defect Categories	Type of Surfaces		
		A Type	B Type	C Type
(1)	(2)	(3)	(4)	(5)
i)	Blister	Nil	Nil	Nil

Price Group 2

Table 1 (Concluded)

Sl No.	Defect Categories	Type of Surfaces		
		A Type	B Type	C Type
(1)	(2)	(3)	(4)	(5)
ii)	Checks	Individual check not more than 50 mm in length and the total length not more 300 mm per m ² area	Individual check not more than 100 mm in length and the total length not more 1 000 mm per m ² area	Individual check not more than 125 mm in length and the total length not more 1 200 mm per m ² area
iii)	Discolouration	Nil	5 percent	75 percent
iv)	Dote	5 cm per m ²	15 cm per m ²	25 cm per m ²
v)	Insect hole	Scattered up to 12 holes per m ²	Scattered up to 24 holes per m ²	Scattered up to 50 holes per m ²
vi)	Joints	One joint for every multiple of 200 mm, provided no individual piece is less than 100 mm in width	No restriction	No restriction
vii)	Knots (dead)	2 up to 12 mm diameter per m ²	4 up to 20 mm diameter per m ²	8 up to 20 mm diameter per m ² including drop out knot holes may be permitted
viii)	Pin knots (dead)	2 per m ²	6 per m ²	No restriction
xi)	Pin knots (live)	No restriction	No restriction	No restriction
x)	Knots (tight)	6 up to 25 mm diameter per m ²	No restriction	No restriction
xi)	Patches	4 patches per m ² , provided they are all tight patches and do not mar the appearance	Any number, provided they are all tight patches and do not mar the appearance	Any number, provided they are all tight patches and do not mar the appearance
xii)	Splits	2 splits, each not more than 1 mm wide and length not more 100 mm, provided they are filled with suitable filler	3 splits, each not more than 4 mm wide and length not more 150 mm, provided they are filled with suitable veneer inserts. Splits up to 25 mm long and 0.8 mm wide may be ignored, provided they are suitably filled with a filler	6 splits, not more than 25 mm wide and length not more 400 mm.
xiii)	Swirl	Unlimited, provided they do not mar the appearance	No restriction	No restriction

(Page 2, Table 2) — Substitute the following for the existing:

‘Table 2 Permissible Categories of Defects

(Clause 5.2)

Sl No.	Type of Surface	Maximum Number of Categories of Permissible Defects, per m ²
(1)	(2)	(3)
i)	Type A	3
ii)	Type B	5
iii)	Type C	As agreed between the manufacturer and the purchaser (see Note)

NOTE — In case of Type C surface, the maximum number of categories of permissible defects, per m² shall be declared by the manufacturer in marking information on the plywood.

(Page 3, clause 7.2.2, line 5) — Delete the word ‘metal’.

(Page 4, clause 8.2) — Insert the following at the end:

‘The plywood of up to and including 4 mm thickness used solely as the base for veneered decorative plywood are not covered in this standard. However, the requirements of such plywood shall be as given in IS 1328 for the raw material (plywood).’

(Page 4, clause 9.1, line 2) — Substitute ‘8.4’ for ‘8.3’.

(Page 5, clause 11.5) — Substitute the following for the existing:

‘11.5 Three test specimens taken in each direction from the sample of plywood, when tested in accordance with IS 1734 (Part 11) shall have an average modulus of elasticity and modulus of rupture not less than the values specified in Table 4. Also, no individual value shall be less than 10 percent of the specified value of the respective bending class. This test is applicable only for plywood of thickness 6 mm and above.’

(Page 5, Table 4) — Substitute the following for the existing:

‘Table 4 Average Values of Modulus of Elasticity (MoE) and Modulus of Rupture (MoR)

(Clause 11.5)

Sl No.	Properties	Bending Class (F)	Requirements
(1)	(2)	(3)	(4)
i)	Modulus of elasticity (MoE), N/mm ² , average, <i>Min</i>	Bending Class 10	1 000
ii)		Bending Class 20	2 000
iii)	Along (direction parallel to the grain direction of the top veneer) and across (direction perpendicular to the grain direction of the top veneer)	Bending Class 30	3 000
iv)		Bending Class 40	4 000
v)		Bending Class 50	5 000
vi)	Modulus of rupture (MoR), N/mm ² , average, <i>Min</i>	Bending Class 10	10
vii)		Bending Class 20	20
viii)	Along (direction parallel to the grain direction of the top veneer) and across (direction perpendicular to the grain direction of the top veneer)	Bending Class 30	30
ix)		Bending Class 40	40
x)		Bending Class 50	50

Amendment No. 1 to IS 303 : 2024

(Page 6, clause 13.1) — Substitute the following for the existing:

‘13.1 Each plywood shall be legibly and indelibly marked or stamped with the following:

- a) Manufacturer’s name and his initials or his recognized trade-mark, if any;
- b) In words ‘PLYWOOD FOR GENERAL PURPOSE;
- c) The grade and type. For example, for BWP grade with Type AA - BWP/AA;
- d) Bending class (*see 4.3*);
- e) Formaldehyde class (*see 4.2*);
- f) Nominal length, width and thickness of plywood;
- g) Month and year of manufacture;
- h) Batch No.; and
- j) Criteria for which the plywood has been labelled as ECO-Mark (if applicable).’

(CED 20)