

# Product specification for export markets

## Flooring specifications – all products

These specifications meet the international standards for solid or engineered flooring products.

General	European market	Australian market
Density (air dry):	700 kg/m <sup>3</sup> or greater	700 kg/m <sup>3</sup> or greater
Discolouration: stain or spots	None	
Distortion: bow, twist, cup	As for EN 13226:2009 Wood Flooring - Solid Parquet Elements with Grooves and/or Tongues.  as for EN 13696:2009 Wood Flooring - Test Methods to Determine Elasticity and Resistance to Wear and Impact Resistance	As for AS 2796.1—1999. Australian Standard. Timber—Hardwood—Sawn and milled products. Part 1: Product specification
Moisture content:	All solid wood flooring, 9% (+/- 2%) Parquetry: 9% (+/- 2%) Tongue and groove: 9–12%	Engineered overlay: 9–14% (target 9%) Parquetry: 8–13% (target 9%) Tongue and groove: 9–14% (target 9%)
Colour	High density only: mix lighter and darker shades through the pack	

Product dimensions	European market	Australian market
Engineered overlay flooring	Manufacture a 15 mm overlay board from a laminated beam constructed from 8, 20 mm thick boards that are glued to 12 mm plywood.	Manufacture a 15 mm overlay board from a laminated beam constructed from 8, 20 mm thick boards that are glued to 12 mm plywood.
Tongue and groove	As for EN 13226:2009 Wood Flooring - Solid Parquet Elements with Grooves and/or Tongues: common dimensions - 15 x 90 x 450/990 mm 15 x 100 x 500/800/1000/12000/ 1500/2000 mm	As for AS 2796.1—1999. Australian Standard. Timber—Hardwood—Sawn and milled products. Part 1: Product specification
Parquetry	As for EN 13226:2009 Wood Flooring - Solid Parquet Elements with Grooves and/or Tongues: common dimensions - Piece: 16 x 22 x 160 mm, surfaced 2 sides Bundle: 2x (16 pieces),	As for AS 2796.1—1999. Australian Standard. Timber—Hardwood—Sawn and milled products. Part 1: Product specification

## Australian market

### 1. Engineered overlay flooring

**Density.** All export grade flooring products are made from cocowood boards with an air dry density of 700 kg/m<sup>3</sup> or greater.

**Moisture content.** The moisture content range is 9–14%; target 9%

**Colour.** If the density requirements are met, boards should be randomised to mix lighter and darker shades throughout the pack.

#### Recommended manufacture of a 15 mm overlay flooring product

The trend in timber flooring products is for wide boards, especially 133 mm or 5¼ inch but wide cocowood cover widths are difficult to produce because:

- wide boards are liable to shrink and expand in service in response to changing environmental conditions
- high variability in density and grain alignment over a small cross-section can worsen distortion

**The engineered overlay** is a wide board surface layer is produced by re-sawing a laminated beam constructed from 20 mm thick boards.

**Construct the beam** from 8 dressed boards of high density cocowood, which are bonded and clamped using the adhesive manufacturers' recommendation. This is shown in the diagram.

**Cure** the beam.

**Saw the cured beam** with a multi-rip sawmill or re-saw bandsaw to produce the surface lamellae.

**Bond the lamellae** to a 12 mm panel substrate, such as plywood.

**Re-saw** to the desired width and

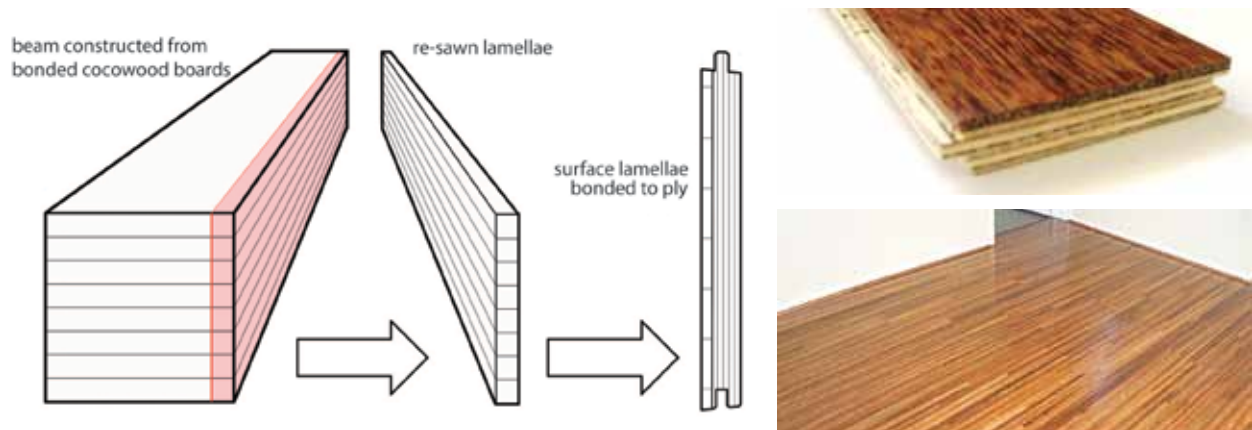
**Run through a moulder** to produce the tongue and groove profile with bevelled edges on the bottom.

**Sand** the top surface.

**Coat** with the required finish.

#### All other specifications

Follow the specifications for overlay flooring set by AS 2796.1–1999. Australian Standard. Timber—Hardwood—Sawn and milled products. Part 1: Product specification.



Constructing the wide boards from bonded lamellae.

Engineered overlay board (above) and in service.

## 2. Tongue and groove (T&G)

**Density.** All export grade flooring products are made from cocowood boards with an air dry density of 700 kg/m<sup>3</sup> or greater.

**Moisture content.** Required moisture content: 9–14%.

**Colour.** If the density requirements are met, boards should be randomised to mix lighter and darker shades throughout the pack.

### All other specifications.

Follow specifications set by AS 2796.1–1999. Australian Standard. Timber—Hardwood—Sawn and milled products. Part 1: Product specification.

## 3. Parquetry

**Density** All export grade flooring products are made from cocowood boards with an air dry density of 700 kg/m<sup>3</sup> or greater.

**Moisture content.** Required moisture content: 8–13% (target 9%)

**Colour.** If the density requirements are met, boards should be randomised to mix lighter and darker shades throughout the pack.

### All other specifications

Follow specifications set by AS 2796.1–1999. Australian Standard. Timber—Hardwood—Sawn and milled products. Part 1: Product specification.

## European market

### 1. Tongue and groove (T&G) (some common characteristics)

Always check specifications with the buyer.

**Density.** All export grade flooring products are made from cocowood boards with an air dry density of 700 kg/m<sup>3</sup> or greater.

**Moisture content.** Required moisture content: 9–12%.

**Colour.** If the density requirements are met, boards should be randomised to mix lighter and darker shades throughout the pack.

### Cutting profile:

Thickness - total: 15 mm

Width: 90 mm, or 100 mm

Lengths for 90 mm width flooring: 450 / 990 mm

Lengths for 100 mm width flooring: 500 / 800 / 1000 / 1200 / 2000 mm

### Cover surface

- thickness of **upper** surface: 6 mm
- thickness of **lower** surface: 4 mm, with four bevelled edges all round approximately 2 mm
- total finished width of 90 mm **lower** surface = 89 mm
- total finished width of 100 mm **lower** surface = 99 mm.

### Tongue

- thickness: 5 mm, with micro-bevelled edges at 4, 5 mm
- width: 6 mm.

### Groove

- thickness: 5 mm
- width / depth : 7 mm
- 1 mm remaining when tongue is inserted into the groove.

### Lower surface:

- 3 small grooves to facilitate gluing.



Tongue and groove construction, 90 mm cocowood boards. Images courtesy of *PlanetCoconut*

### All other specifications

Follow the relevant European standards e.g. EN 13226:2009 Wood Flooring - Solid Parquet Elements with Grooves and/or Tongues.

## **2. Parquetry**

Always check specifications with the buyer.

Cut parquetry dimensions per piece: 16 x 22 160 mm, surfaced two sides (S2S)



Parquetry pack (left) and in-service. Images courtesy of PlanetCoconut

Follow the relevant European standards, e.g. EN 13226:2009 Wood Flooring - Solid Parquet Elements with Grooves and/or Tongues.

## **3. Engineered overlay flooring**

See specifications for the Australian market.