



IS 1659:2004 “Block Boards- Specification”

Blockboard is a type of **plywood** that is engineered in a special way. They have a core made up of **strips of wood**, which may or may not be glued together and the core is glued to two or more veneers, on either side with grain direction of **core and veneers** running at right angles to one another. They **do not crack easily** and are not likely to **bend easily** when heavy objects are placed on them. They are highly **durable** and suitable for applications where long pieces of wood have to be used.

Indian Standard, **IS 1659**, lays down the **method of manufacture, tests to be carried on** Blockboards. The standard recommends the **species of timber** and the **type of adhesives** to be used with a view to assuring the **optimum performance requirements** for different uses.

The standard specifies “**BWP Grade**” for **exterior uses** and “**MR Grade**” for **interior uses**. Each of the above grades are specified with two types “**Decorative type**” with decorative face veneers on one or both sides for use in **high class furniture, panelling, interior decoration, partitions, etc.** and “**Commercial type**” with veneers of commercial timber on both sides for use in **ordinary furniture, table tops, partitions and panelling** to be painted over flooring and seats of **bus bodies, railway carriages, etc.**

The standard mentions the manufacturing requirements of **Core, Cross bands and Faces** to be used including the required **preservative treatment** of timber. It specifies the **dimensions with tolerances** requirement of blockboards.

The standard outlines the **tests to be conducted** on the Block board alongwith the test methods to confirm its **compliance** with the various requirements laid out in it. Some of the main tests mentioned include **Dimensional changes caused by humidity, Resistance to water** for both BWP and MR grade block boards, **Adhesion of plies, Mycological tests, Modulus of Rupture & Modulus of Elasticity** and **Spot test**.

The block boards complying with the requirements laid down by IS 1659 and marked with **BIS Standard Mark** will ensure desired quality for the user.