

GUIDELINES FOR VISUAL ASSESSMENT OF PRODUCT QUALITY

The surface quality of visually painted wooden windows, wooden exterior doors, wooden facades, wooden window sills and wooden posts is assessed according to this guide. The surfaces can be covered with covering (opaque) paint or transparent glaze (lasur).

Definitions

Window – an opening in the wall of a building, fitted with glass in a frame to admit light or air and allow people to see out.

Exterior door – an openable barrier at the entrance to a building that separates exterior and interior climate.

A window and an external door are constructional products that have been manufactured in accordance with the requirements of national product standards, national technical approvals and other national technical specifications and norms for construction products. The European standard EVS-EN 14351-1 applies to windows and exterior doors.

Windows, exterior doors and facades are made of laminated glulam (finger-jointed or non-finger-jointed, also known as solid).

Laminated glulam - an element of timber compiled from two or more layers, which may contain one or more adjacent lamellas.

The thickness of the dry coating layer – according to the finishing coating manufacturers, the specified dry film thickness finishing agent shall be 100 (+/- 20) µm. The measurement results of the dry film thickness are affected by the natural structure of the surface to be measured. The thickness of the dry layer of meranti and oak products cannot be achieved due to the natural structure of the wood. When measuring the thickness of the dry layer, the weighted average of the measurements of the different regions is calculated.

Crack - (narrow) gap, slit, rift.

Surface quality is observed from a distance of approx. 2 m in diffuse daylight in accordance with the usual use of space.

1. REQUIREMENTS AND TOLERANCES

ID	Requirements	
1.1	Planing trace, kinetic wave	≤ 2,0 mm allowed.
1.2	Wood fibers	The coating must completely cover the wood fibers.
1.3	Adhesive residues	Adhesive residues with a maximum width of 3 mm may be present at the joints, there must be no adhesive residues on the surface.

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1.4	Fasteners	Fasteners must not be rusty. Separation of recessed mounting points is permitted. In the case of technically prescribed screw fastening or nail fastening, it is permissible for the screws and nails to remain visible. When using double-sided tape, air bubbles under the tape are allowed.
1.5	Joints	The joint between the glazing bead and the sash, and the joints between components, may be ≤ 2.0 mm. The variation in the joint of the tongue-and-rebate connection of windows and doors may be 1.2 mm per 1 m.
1.6	End surface	End surfaces do not need to be sanded. Rounded edges on end surfaces and repair of torn areas are allowed.
1.7	Crushing	Crushing areas with an area ≤ 5.0 mm ² or a depth ≤ 2 mm are permitted in areas which, after installation, are no longer visible when a window is closed.
1.8	Wood pores	The pores must be painted, the pores may differ depending on the type of wood.
1.9	Year-rounds	Trees behave differently and embossed year-rounds are allowed.
1.10	Glue and finger joints, spots, knots	Visible surface relief at glue joints, finger joints, repairs and knots is permitted. The appearance of outlines of glue joints, repair plugs, finger-joint glue lines, knots, wood grain and similar features through the paint layer due to changes in humidity and/or temperature is not considered a finish defect as long as the finish remains intact (without cracking, peeling, etc.). See clause 1.2. In windows and doors made of non-finger-jointed pine, profiles measuring 2 m or longer may contain one finger joint per metre.
1.11	Resin release	Irrespective of the surface paint, resin release cannot be prevented when using resin-rich wood (eg pine). The release of the resin is allowed, it is not considered a defect and it does not affect the declared performance of the products.
1.12	Differences in color	The colour may vary slightly depending on the natural properties of the wood and may change differently over time. In products finished with transparent stains, colour and shade variations caused by the natural colour and structure of the wood are permitted. Yellowing of the finish caused by the migration of extractives from the wood is permitted. Minor paint runs are permitted. Paint touch-ups (repainting) carried out with a brush or roller on products installed on site, and the resulting difference in the surface texture compared with the factory-applied finish, are permitted. Such touch-ups and repainting do not affect the declared performance of the products.
1.13	Silicone	The silicone connection must completely seal the joint between the wood and the glass package. Line thickness fluctuations are allowed ± 2 mm. Unevenness in the corners is allowed. Air bubbles (≤ 2.0 mm ²) and streaks ($\leq 1 * 5.0$ mm) inside the silicone are permitted and do not impair the tightness of the joint. Some silicone residues on the glass and wood are allowed. Silicone can be easily removed from surfaces after drying.
1.14	Glass packages (glazing unit)	The visual quality of insulating glass units is assessed in accordance with standards EVS-EN 1279-1:2018 and EVS-EN 12150-1:2015+A1:2019.

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1.15	Aluminum coatings	A gap of ≤ 1.5 mm is permitted at the corner joints of aluminium profiles. Slight surface waviness is permitted on aluminium surfaces larger than 0.1 m^2. Hairline scratches are permitted on aluminium surfaces. A flatness deviation of ± 3 mm is permitted for aluminium cladding. Due to thermal expansion of aluminium, changes in temperature may affect the dimensions, flatness and joint gaps of profiles. The linear thermal expansion coefficient of aluminium is approximately 0.023 mm per metre of profile length per 1°C temperature change. For example, a temperature change of 40°C causes a length change of approximately 1.84 mm in a 2 m profile. Product quality control and assessment of dimensional conformity are carried out at the factory under the indoor climate conditions specified for the production environment. Subsequent changes in the dimensions, flatness and joint gaps of aluminium profiles caused by temperature fluctuations are a natural physical property of the material and are not considered product defects.
1.16	Maintenance and repair	Products must be inspected and maintained at least once a year: https://www.lasita.ee/wp-content/uploads/2026/04/WARRANTY-TERMS-AND-CONDITIONS-MAINTENANCE-AND-INSTALLATION-INSTRUCTIONS_14.10.26.pdf Products may be repaired on site (replacement of insulating glass units and glazing beads, repainting, replacement of hardware and seals, etc.). Repairs do not affect the declared performance of the products.

The development of this manual is based on the following documents and the technical possibilities of Lasita Aken AS.

1. Requirements for construction materials and products and procedures for attesting their conformity
<https://www.riigiteataja.ee/akt/130072013002?leiaKehtiv>
2. Estonian Building Materials Manufacturers Association
<http://www.eetl.ee/et/avataited>
3. EVS-EN 14351-1:2006+A2:2016 Windows and doors. Product standard, product characteristics. Part 1: Windows and exterior doors
4. EVS-EN 14080:2013 Timber structures. Lamellar glulam and plank glulam. Requirements
5. EVS-EN 15497:2014 Finger-jointed solid construction timber. Performance requirements and minimum production requirements
6. REGULATION (EU) No 305/2011 OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL
<https://eur-lex.europa.eu/LexUriServ/LexUriServ.do?uri=OJ:L:2011:088:0005:0043:ET:PDF>