

LUMBER GRADING SPECIFICATIONS



Grade Names &
Definitions for Accoya
Radiata Pine Version 10.0

ROUGH SAWN ACCOYA WOOD



A1 MINIMUM GRADE DEFINITION

4 sides primarily clear with total allowance (combination of all sides) of the following:

BOARDS UP TO 6/4 THICKNESS:

Up to 3 of the following defects or equivalent:

- Knot (pin): 1/4" or less
- Bark or resin pocket: 1/2" x 2"

8/4 THICKNESS AND GREATER:

Up to 6 of the following defects or equivalent:

- Knot (intergrown, partially intergrown and tight encased): 1/2"
- Bark or resin pocket: 1/2" wide, 4" long or equivalent.

RESIN STREAKS

3 up to 1/2" wide, 4" long or equivalent, slightly more for a short distance.

SURFACE CHECKS

- 3 up to 1/16" wide, 10" long or equivalent, slightly more for a short distance.
- For boards 8" to 12" wide the following additional allowance applies: Up to 1 surface check per 2" width, no wider than 1/16", 10" long or equivalent, slightly more for a short distance.

SPLITS

Short split, up to width of board and not to exceed 8".

NEEDLE FLECK / BIRDS EYE

Medium birds eye or fleck.

WARP

As given in tables 1,2,3,4.

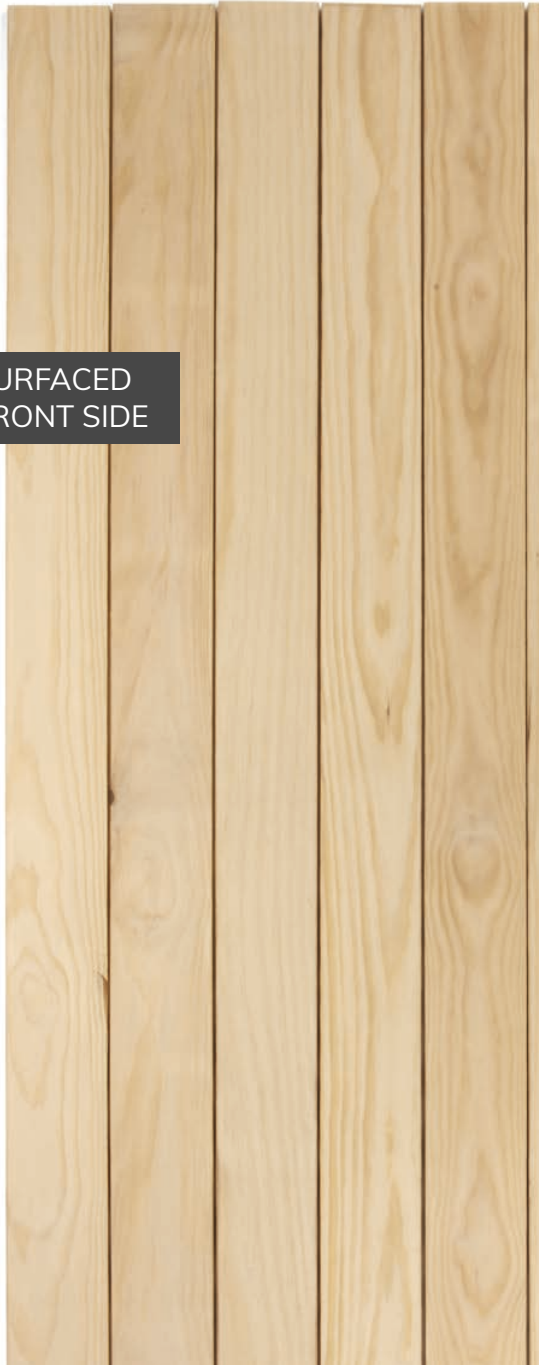
WANE

Up to 1/2" in depth, 1/4 length of board or equivalent, slightly more for short distance. Transport damage is permitted within the same wane limits.

SURFACE FINISH

A1 supplied rough sawn
A1p supplied surfaced one side, hit/miss on the other side.

A1

A vertical stack of light-colored wood planks with a visible grain pattern. The planks are arranged in a slightly offset manner, showing the front side of the wood.

SURFACED
FRONT SIDE

A vertical stack of light-colored wood planks with a visible grain pattern. The planks are arranged in a slightly offset manner, showing the backside of the wood.

SURFACED
BACKSIDE

Refer to Accoya Wood
Information Guide for
guidance on milling.

GENERAL SPECIFICATIONS

PROPERTY	SPECIFICATION
Thickness	No more than 1/16" less than the specified size.
Width	No more than 1/16" less than the specified size.
Length	No more than 1" shorter than nominal length.
Moisture Content	Less than 10%.

SURFACE FINISH AND DIMENSION

Accoya boards can be rough sawn or dressed to a smaller dimension. The dressed dimensions have been selected with the intent of enabling production of the same final products. Boards are sold and classified according to their original sawn (nominal) dimension.

A1p boards are surfaced from 4/4 to 7/8".

ADDITIONAL GRADE SPECIFICATIONS

Internal defects not visually present on surface: Accoya wood is produced from a natural resource. All wood has natural variation from tree to tree and board to board. This natural variation results in a product that can have defects naturally present within the wood. Furthermore, cutting trees into lumber and drying of the lumber can induce defects such as shakes, cracks and checks. Accoya wood is produced from lumber visually inspected on the surface to meet the grade specifications. Accoya is sold on the basis of this surface grade. Defects within the wood cannot be seen and grading and are not part of the grade specification.

MANUFACTURING IMPERFECTIONS

Lumber may have slight manufacturing related imperfections.

OVERALL DEVIATION FROM SPECIFICATIONS

Up to 5% of boards off grade shall be deemed acceptable.

SURFACING CONSIDERATIONS

DISCOLORATION

The acetylation process can result in discoloration and sticker marks up to 1/4" in depth, and slightly deeper on occasion due to wood's natural variation. This is typically over come in a one-sided application such as decking by milling 1/16" off the intended back side and a higher proportion from the appearance side. Removing the discoloration is typically unnecessary when opaque coatings are used.

Refer to Accoya Wood Information Guide for guidance on milling.

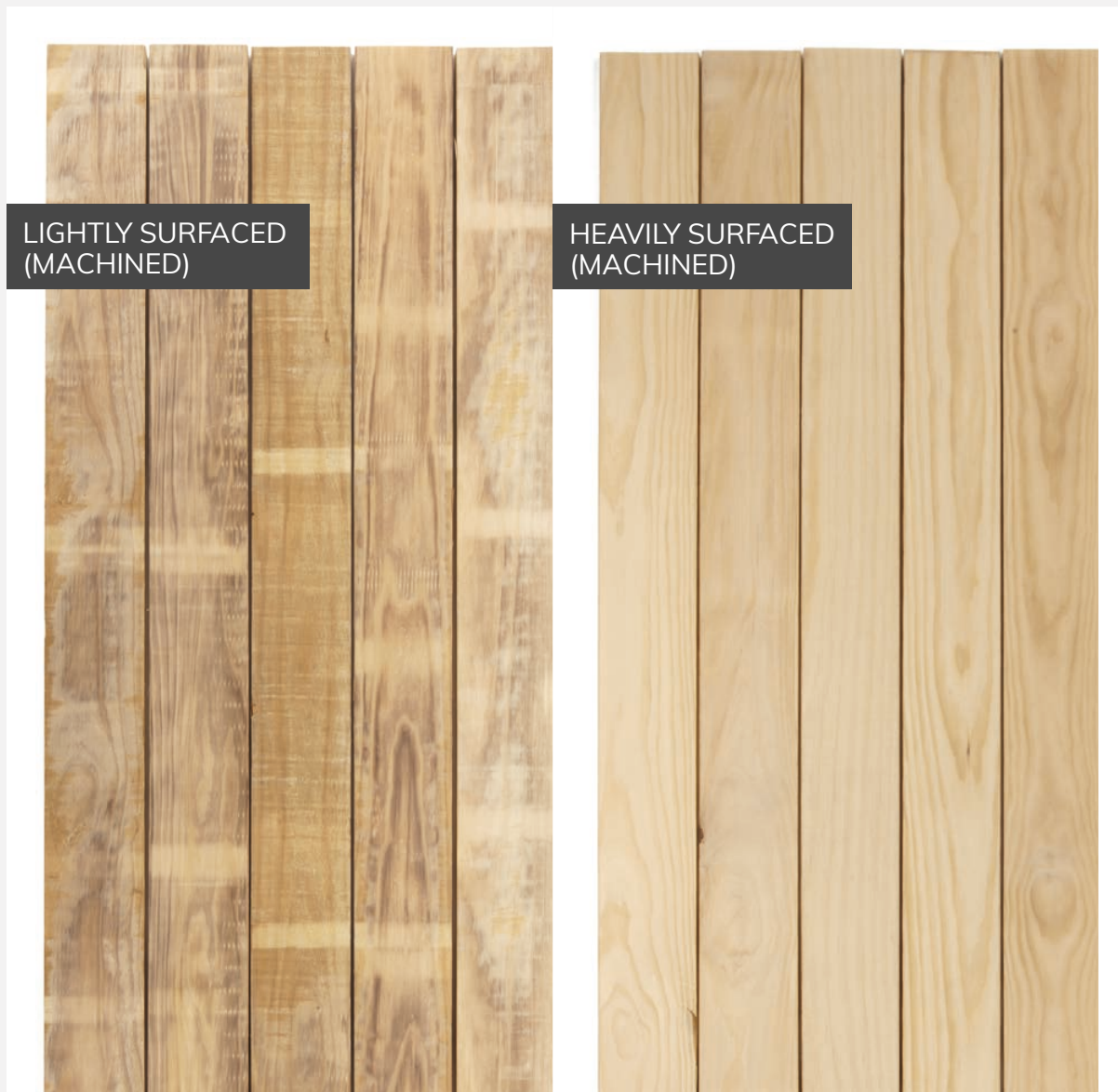


TABLE 1: ALLOWED BOW

LENGTH [ft]	THICKNESS [in]					
	4/4	5/4	6/4	8/4	10/4	12/4
6'	3/4"	3/4"	1/2"	1/2"	1/2"	1/4"
7'	1"	7/8"	3/4"	1/2"	1/2"	1/2"
8'	1 1/4"	1"	7/8"	3/4"	3/4"	1/2"
9'	1 1/2"	1 1/4"	1"	3/4"	3/4"	3/4"
10'	2"	1 1/2"	1 1/4"	1"	1"	3/4"
11'	2 1/4"	2"	1 1/2"	1 1/4"	1 1/4"	1"
12'	2 1/2"	2 1/4"	1 1/2"	1 1/2"	1 1/2"	1"
13'	3 1/4"	2 1/2"	2"	1 1/2"	1 1/2"	1"
14'	3 1/2"	3"	2 1/4"	2"	2"	1 1/4"
15'	4"	3 1/2"	2 1/2"	2 1/4"	2 1/4"	1 1/2"
16'	5"	4"	3"	2 1/2"	2 1/2"	1 1/2"

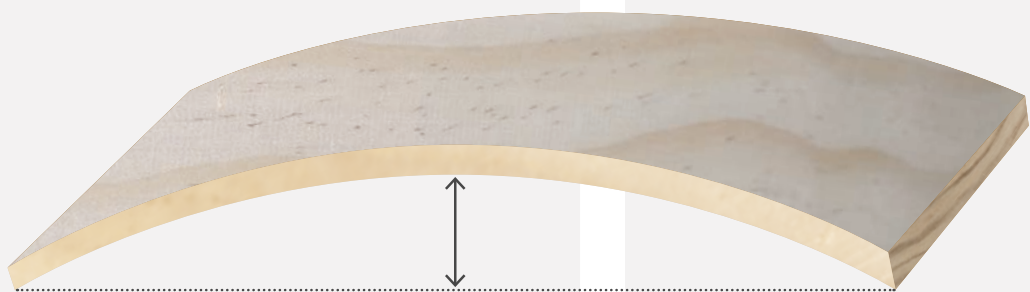


TABLE 2: ALLOWED CROOK

LENGTH [ft]	WIDTH [in]					
	3"	4"	5"	6"	8"	>8"
6'	1/4"	1/4"	1/8"	1/8"	1/8"	1/8"
7'	1/2"	1/4"	1/4"	1/4"	1/8"	1/8"
8'	1/2"	1/2"	1/4"	1/4"	1/4"	1/8"
9'	3/4"	1/2"	1/2"	1/4"	1/4"	1/4"
10'	3/4"	1/2"	1/2"	1/2"	1/4"	1/4"
11'	3/4"	3/4"	1/2"	1/2"	1/4"	1/4"
12'	1"	3/4"	3/4"	1/2"	1/2"	1/4"
13'	1"	3/4"	3/4"	3/4"	1/2"	1/2"
14'	1-1/4"	1"	3/4"	3/4"	1/2"	1/2"
15'	1-1/2"	1"	3/4"	3/4"	3/4"	1/2"
16'	1-1/2"	1-1/4"	1"	3/4"	3/4"	1/2"



TABLE 3: ALLOWED TWIST PER 4" WIDTH

LENGTH [ft]	THICKNESS [in]					
	7/8 & 4/4	5/4	6/4	8/4	10/4	12/4
6'	1/2"	1/2"	1/4"	1/4"	1/4"	1/8"
8'	1/2"	1/2"	1/2"	1/4"	1/4"	1/4"
12'	3/4"	3/4"	1/2"	1/2"	1/2"	1/4"
14'	3/4"	3/4"	3/4"	1/2"	1/2"	1/4"
16'	1"	3/4"	3/4"	1/2"	1/2"	1/2"

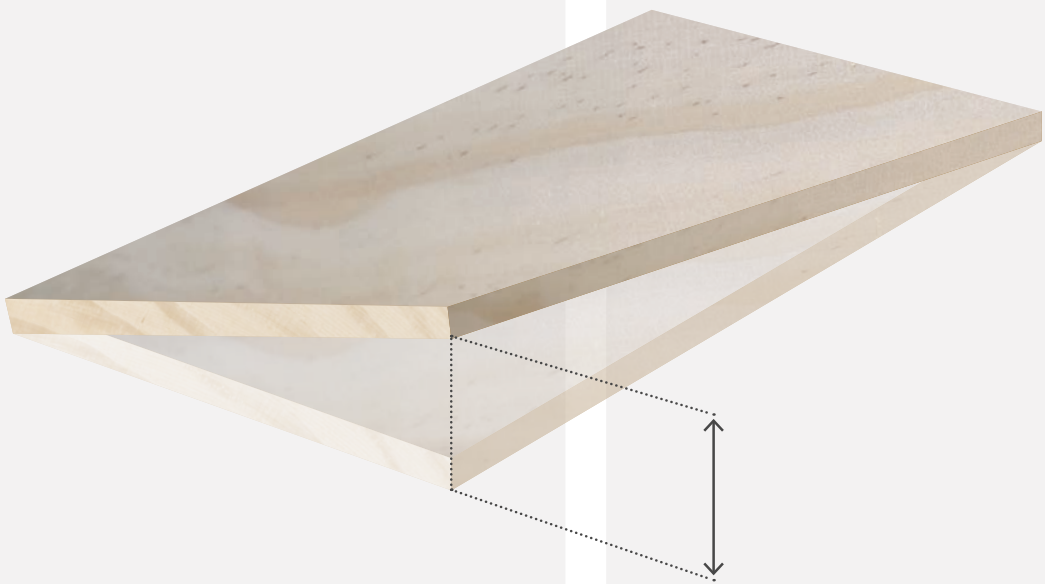
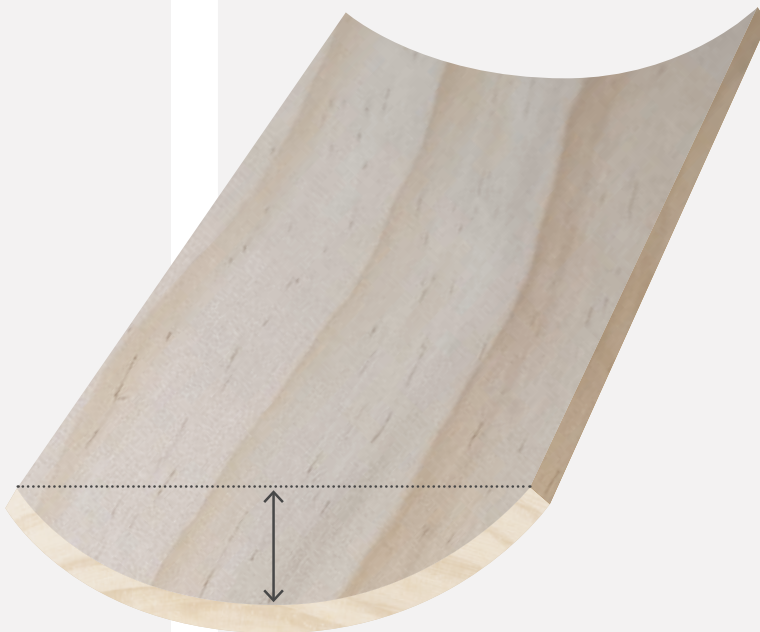


TABLE 4: ALLOWED CUPPING

WIDTH [in]	ALLOWED CUPPING [in]
3"	1/16"
4"	1/16"
5"	1/8"
6"	1/8"
8"	3/16"
9"	1/4"
10"	5/16"
12"	3/8"



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Declare.