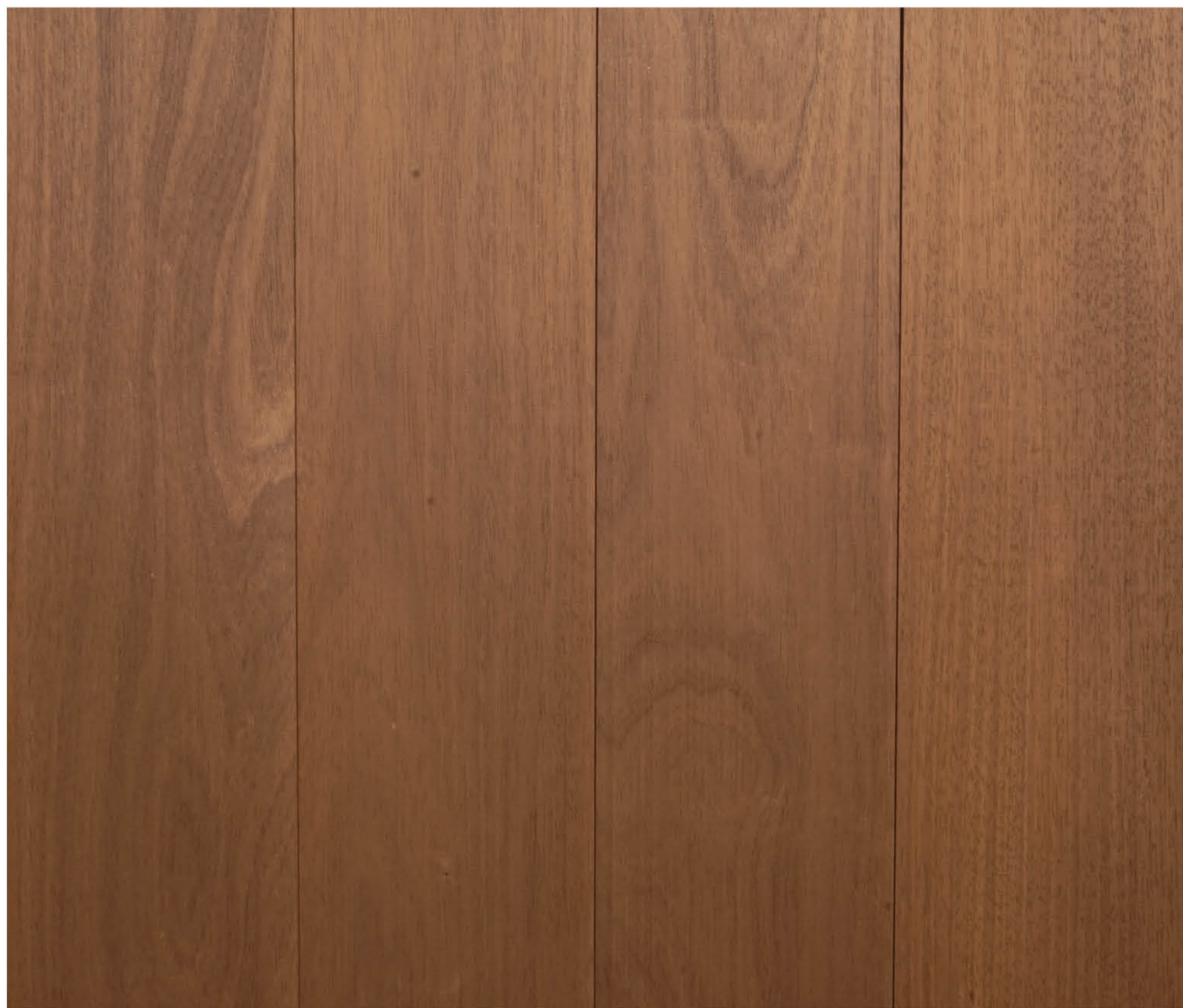


# Product Grading Rules **Excellence**



## Grade Selection

The purpose of this document is to provide a simplified but thorough explanation of the grading rules of TIMBRA Tech® hardwood thermally modified products.

TIMBRA Tech® benchmark products undergo intense thermal modification. It makes the EXCELLENCE selection exceptionally durable (Class 1) and stable while emphasizing its warm dark-brown colour.

Grade selection and specification will have a significant impact on both the appearance and performance of wood products in any given application. When thermally modified hardwoods are specified or purchased without clearly defining grade expectations, there is no assurance of the quality and consistency of the product delivered, and no accountability standard set for the supplier. And since grade affects price, what looks like a good deal on paper might not look nearly as good on your project. If the product is being used in structural applications like decking, grade has a direct impact on mechanical properties and load performance.

In the absence of industry established and defined quality control standards for thermally modified hardwood, cladding, decking and lumber TIMBRA Tech® has developed and published grading standards and product specification language which we apply to our production.

TIMBRA Tech® has created this guide to assist clients and end users in determining grade expectations and value requirements as well as to understand some of the common grades that might be encountered in the market. We strongly encourage clients and consumers to utilize these standards in their decision making process and to specifically reference these standards in their purchase orders.

## Grading Rule Definitions

As with most natural wood products, Thermally Modified hardwoods possess natural “Appearance Characteristics” that add to their unique beauty.

Those that are appreciated include colour variation and distinctive grain patterns. Other characteristics in all types of lumber that develop naturally or through manufacturing are known as “Physical Characteristics”, “Sound Defects”. Unsound Defects and “Milling Defects”.

The grading of Decking into categories as it is processed by **TIMBRA Tech**<sup>®</sup> to determine to a large extent the value and potential use possible for each board. The following is a summary of the typical characteristics one might find in a wood grade specification.

**It is important to note that industry standard allows for 5% sub grade in all production to allow for human error in the grading process.**

## Characteristics

### ■ Appearance

1. Color Variation
2. Mixed Grain
3. Drying Checks
4. Reverse Grain
5. Birdseye
6. Pin Knots
7. Water Stain

8. Discoloration
9. Sticker Marks
10. Molder Knife Marks

### ■ Physical

1. Bow
2. Crook
3. Cup
4. Twist

## Defects

### ■ Milling

1. Hit or Miss/Skip
2. Torn grain
3. Non-compliant profiling

### ■ Sound

1. Pin holes
2. Sound knots











### ■ Unsound

1. Large borer holes
2. Splits
3. Unsound knots
4. Shake
5. Sapwood

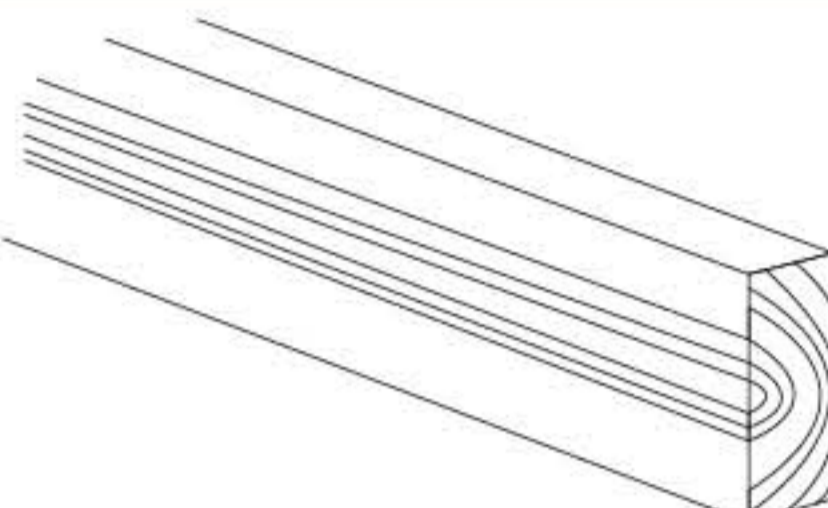







**GRADED BY**

		BETTER FACE	BACK FACE
HIT & MISS		Not allowed	≤20% area
FEED-ROLLER MARKS		Not allowed	≤30% area
WANE		Not allowed	Max 1/5 of width and 1/3 of the thickness of the board
MECHANICAL DEFECTS		Not allowed	Not allowed
SURFACE CHECKS		Up to 1 mm wide and 20 mm long	Up to 1 mm wide and 50 mm long
SHAKES		Not allowed	
RING SHAKES		Not allowed	
END SPLITS		Up to 30 mm	Up to 60 mm
KNOT HOLE		Not allowed	
BARK KNOTS		Not allowed	Unlimited

**GRADED BY**

		BETTER FACE	BACK FACE
DEAD KNOTS/ BLACK KNOTS		Not allowed	Unlimited
UN SOUND/ BROKEN KNOTS		Not allowed	Unlimited
KNOT SHAKE		Not allowed	Unlimited
PIN KNOTS		Up to Ø 10 mm	Unlimited
ARRIS KNOTS		Not allowed	Unlimited
EDGE KNOTS		Allowed up to 1/2 of the thickness of the board	Unlimited
KNOT CLUSTER		Not allowed	Unlimited
PARTIALLY INTERGROWN KNOTS		Not allowed	Unlimited
SCAR		Up to 100 mm <sup>2</sup>	Unlimited
PITCH POCKET		≤30% area	Unlimited

**GRADED BY**

		BETTER FACE	BACK FACE
BARK/ROT/ MOULD		Not allowed	
INSECT HOLES		Not allowed	Unlimited
GLASS WORN MARKS		Not allowed	Unlimited
STICK MARKS		Not allowed	≤20% area
CUP		Allowed up to 1% of the width of the board	
TWIST		Allowed up to 5% of board width per linear meter, has to be reversible during installation	
BOW		Allowed up to 2 mm per meter in length	
SPRING CROOK		Allowed up to 7,5 mm per meter in length	
TOLERANCES		Thickness: +/- 0,5 mm Width: +/- 1 mm Length: +/- 1 mm per meter in length	

All defects that are allowed on the back face and not limited by size, are tolerated to the extent that they will not jeopardize the integrity, usability, and visual wholeness of the installed product.

Innovating  
**Nature**  
Building  
**Futures**



**Together**  
**we change wood.**  
to change the world



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