



Vulcan Thermally Modified Timber Grade Rules

Sawn Timber



Carefully Crafted Timber

Clear One Grade (C1)

Highest Grade Available

Specifications

Includes clear four sides (2 face and 2 edge).

- Permitted defects: birds eye fleck, kiln check (1mm wide by 250mm long, one per board), sap stain (insufficient to obscure grain), and bow, crook, cup, and twist as given in tables 1, 2, 3, 4 of appendix.
- Wane up to 8mm in depth, ¼ length of board of equivalent, slightly more for short distance. Transport damage is permitted within the same wane limits.
- Allowed on **back face only** – Bark or resin pocket: 8mm wide, 50mm long or equivalent.

Note: Clear One and Clear Two grades can be mixed into a composite grade of Clear Two or Better – which contains a mix of the two grades.



Best Face



Back Face

Clear Two Grade (C2) High Appearance Grade

Specifications

Front face and edges primarily clear with some small defects allowed.

Permitted best face defects:

- Birds eye fleck, kiln check (1mm wide by 250mm long, three per board), sap stain (insufficient to obscure grain), and bow, crook, cup, and twist as given in tables 1, 2, 3, 4 of appendix.
- Tight knot (intergrown, partially intergrown and tight encased): 15mm or equivalent smaller.
- Short split, up to the width of board and no more than 200mm.
- Wane up to 8mm in depth, ¼ length of board of equivalent, slightly more for short distance. Transport damage is permitted within the same wane limits.

Permitted reverse/back face defect may contain knots and defects as described below:

- Sound knots and pruned scars singly and in combination up to one third of the board width only.
- Resin pockets 10mm wide x 100mm long, three per board. Max depth on RS board 10mm.
- Machine Damage 50mm wide x 150mm long, two per board. Max depth on RS board 5mm.
- Surface checks less than 1mm wide x 250mm long.
- Short end split, up to the 50% width of board and no more than 200mm.
- Edge defects in bottom two thirds of edge only.
- Spike knots inter grown up to 20mm wide.
- Product may be up to 3% undersize from nominal size.
- Tight encased knots maximum 10mm wide, three per board.
- Wane up to 8mm in depth, ¼ length of board of equivalent, slightly more for short distance. Transport damage is permitted within the same wane limits.



Best Face

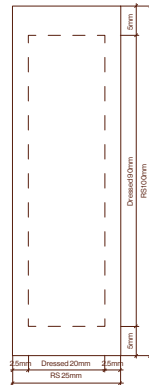


Back Face

Acceptable Defects

Rough sawn size vs Finished dressed size

RS: Rough sawn	Dressed size
25x100mm	20x90mm
25x125mm	20x115mm
25x150mm	20x140mm
25x200mm	20x190mm
32x100mm	27x90mm
32x125mm	27x115mm
32x150mm	27x140mm
32x200mm	27x190mm



RS product size once dressed

All faces are reduced in size. Therefore, defects can be dressed out.

Resin pocket – Clear Two grade



Acceptable on the back face of C2.

Max 3 resin pockets.

- Max width 10mm
- Max length 100mm
- Max Depth 10mm

Unacceptable on front (best) face.

Excessive wane



Unacceptable, pencil wane allowed.

Wane up to 8mm in depth, ¼ length of board of equivalent, slightly more for short distance. Transport damage is permitted within the same wane limits.

Machine damage



Acceptable on back face

Max 2 per board.

- 50mm wide
- 150mm long
- Max depth on RS board 5mm

Resin pocket – Clear One grade



Acceptable on the back face of C1.

Max 1 resin pockets.

- Max width 8mm
- Max length 50mm
- Max Depth 10mm

Unacceptable on front (best) face.

Surface checking
(aka kiln check).



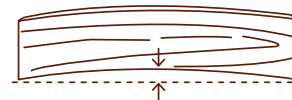
Acceptable on either face under 1mm wide by 250mm long.

Short end split
(end crack).

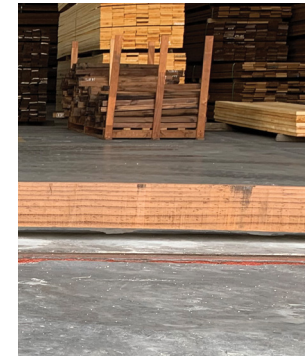


Acceptable up to 50% of the width of board and no more than 200mm.

Crook



A longitudinal curvature of the edge of a piece of timber. Crook is measured at the maximum deviation of the edge of a piece from a straight line joining the ends. Also referred to as Spring.



Refer Table 2 for acceptable crook.

Fillet marks



Acceptable, will dress off.

Twist



A spiral distortion along the length of a piece of timber. Twist is measured by the height of the remaining corner, when the other three corners are held on a flat surface.



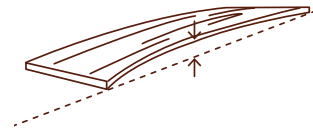
Some twist can be expected, and larger sections are prone to move. Refer Table 4 for allowable twist.

Undersize

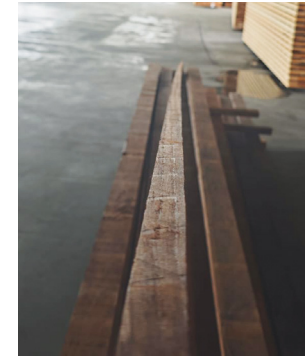


Typically, TM shrinkage can be up to 3% from the invoiced size. Anything more than 3% would be deemed **Unacceptable**.

Bow



A longitudinal curvature of the face of a piece of timber. Bow is measured at the maximum deviation from one end to the other.



Refer Table 1 for allowable bow.

General rules

Max 5% out of grade is deemed acceptable to allow for human error.
Bundle number required for any claim.

NOTE: Clear One and Clear Two grades can be mixed into a composite grade of Clear Two or Better – which contains a mix of the two grades.

Appendix

Table 1
Permitted Bow (mm)

Length (m)	Thickness (mm)					
	25	32	38	50	63	75
3.6	65	55	55	55	55	55
4.8	120	100	100	100	100	100
6.0	185	155	155	155	155	155

Table 2
Permitted Crook (mm)

Length (m)	Width (mm)				
	100	125	150	200	> 200
3.6	30	30	30	30	30
4.8	35	35	35	35	35
6.0	45	45	45	45	45

Table 3
Permitted Cup (mm)

Width (mm)	Permitted Cup (mm)
100	1
125	2
150	2
200	2
225	4
250	5
300	6

Table 4
Permitted Twist per 100mm of Width (mm)

Length (m)	Thickness (mm)					
	25	32	38	50	63	75
3.6	20	20	20	20	20	20
4.8	25	25	25	25	25	25
6.0	30	30	30	30	30	30



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