



THERMO PINE

Grading rules

Pine wood is highly valued due to its good mechanical features - pine is light, soft and easy to process. During thermal modification, pine wood achieves other valuable properties for outdoor use, such as weather and rot resistance, better moisture and dimensional stability. It also removes resin from wood, gives the material a beautiful brown tone and emphasizes the wood texture.

2024 //

The material is sorted into quality classes based on the conditions below.

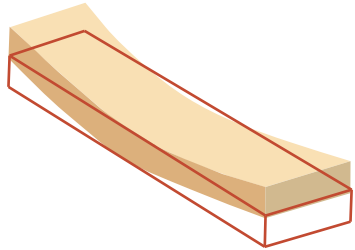
Up to 5% of the volume can be of lower grade.

Grading will be carried out **by the visible face** (if it's definated) or by the better face.

Defect	Grade AB		Grade BC	
	Visible face	Back face	Visible face	Back face
SOUND KNOTS	visual grading, not measured, has to maintain the integrity of the board	allowed	allowed	allowed
DEAD KNOTS	up to \emptyset 15 mm	allowed	allowed	allowed
BROKEN KNOTS	if not disturbing visually, evaluated form a distance min 1,5 m, up to 1/10 of the width of the board	allowed	allowed up to 1/5 of the board width	allowed
KNOT HOLE	not allowed	limited if not through the	up to \emptyset 20 mm allowed in whole length	allowed
BARK KNOTS	sound, \emptyset up to 1/3 of the width of the board, bark not over half of the diameter	allowed	if not disturbing visually	allowed
BLACK KNOTS	\emptyset up to 1/5 of the width of the board	allowed	allowed	allowed
UNSOUND KNOTS	not allowed	allowed	if not disturbing visually	allowed
KNOT SHAKE	decking: up to 3 mm wide and 50 mm long/ cladding: up to 5 mm wide and 50 mm long	allowed	allowed	allowed
SPIKE KNOTS	\emptyset up to 1/2 of the width of the board	allowed	allowed	allowed
PIN KNOTS	allowed	allowed	allowed	allowed
PARTIALLY INTERGROWN KNOTS	bark up to 1/2 of the diameter	allowed	allowed	allowed
EDGE & ARRIS KNOTS	allowed	allowed	allowed	allowed
BROKEN EDGE KNOT	limited to 1/10 of the width	allowed	allowed	allowed

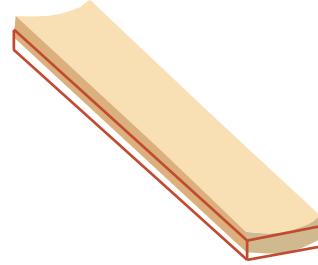
Defect	Grade AB		Grade BC	
	Visible face	Back face	Visible face	Back face
KNOT CLUSTER	visual grading, not measured, has to maintain the integrity of the board	allowed	allowed	allowed
END SPLITS	max length = width of the board	allowed	allowed up to 300 mm from both ends	allowed
SHAKES	not allowed	not allowed	allowed up to 300 mm from both ends	allowed
SURFACE SHAKES	max 100 mm long	allowed	allowed	allowed
RING SHAKE	not allowed	not allowed	allowed up to 300 mm from both ends	allowed
WANE	not allowed	max 1/3 of the width and 1/5 of the thickness of the board	allowed up to 300 mm from both ends	allowed
MECHANICAL DEFECTS	not allowed	allowed	allowed up to 300 mm from both ends	allowed
HIT&MISS	not allowed	max 1/2 of the width of the board	allowed up to 300 mm from both ends	allowed
FEED-ROLLER MARKS	not allowed	allowed	allowed up to 300 mm from both ends	allowed
ROT/BLUE STAIN/BARK	not allowed	not allowed	not allowed	not allowed
SCAR	allowed up to 300 mm ²	allowed	allowed	allowed
RESIN POCKET	allowed up to 300 mm ³	allowed	allowed	allowed
PITH	allowed	allowed	allowed	allowed
SLOPE OF GRAIN	allowed	allowed	allowed	allowed
INSECT HOLES	not allowed	allowed	not allowed	allowed

BOW



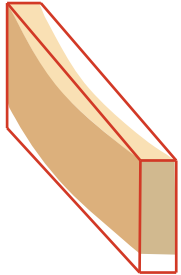
allowed up to 2 mm
per linear meter

CUP



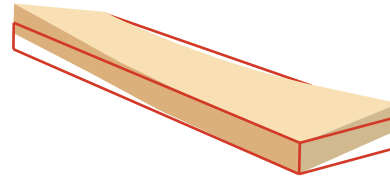
allowed up to 1% of
the width of the
board

SPRING, CROOK



allowed up to 7,5 mm
per linear meter

TWIST



allowed up to 5% of
board width per
linear meter, has to
be reversible during
installation

TOLERANCES: thickness: $\pm 0,5$ mm; width: $+ 0,5/-1,0$ mm;
length: ± 2 mm per linear meter.

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