

Grading rules

Grading rules for Profile boards and S4S

Characteristics	A/B (also valid for Qual. A)	B-SORT.
Knots	On the surface only tight and intergrown knots, up to 40 mm diameter are admissible, as well as minimal edge breakage if they are covered by tongue and groove. Tightly grown spike knots are also admissible, if they are not longer than the half width of the board.	Loose knots, slough knots, are up to 15 mm diameter admissible (by 10% of the whole quantity max. 2 knot hole / board admissible). Black and loose knots are admissible.
Resin pockets	Resin pocket up to a surface of 2 cm ² and 2 piece / board are admissible.	Resin pockets are admissible.
Shakes	Max. 2 shakes in a width of 1 mm and in a length of 10% of the board length as well as end shakes up to a max. length of the board width are admissible. Shakes in the knot caused by kiln drying up to 1 mm width are admissible.	Max. 2 shakes in a width of 2 mm and in a length of 20% of the board length as well as end shakes up to a max. length of 30 cm are admissible. Shakes in the knot are admissible.
Compression wood	Compression wood up to 20% of the board surface is admissible.	Compression wood is admissible.
Bark pockets	Bark pockets up to a surface of 2 cm ² and 2 pieces / board are admissible.	Bark pockets are admissible.
Heartwood	Heartwood is up to the half length of the board is admissible.	Heartwood is admissible.
Insect damage	Insect damage is inadmissible.	Holes caused by insects are up to 2 mm admissible (by 10% of the whole quantity max. 20 hole / board are admissible).
Discoloration	Discoloration up to 10 % of the surface is admissible, by 10% of the whole quantity.	Discoloration up to 50 % of the surface is admissible
Woodworking	The boards are on the surface well planed. Slight roughnesses (for example next to the knots) are up to 2 cm ² admissible. On the backface one rough edge is admissible.	Rough surfaces (for example next to the knots, notches or torn grain on the surface) are admissible. On the backface rough edges are admissible.

Note:

According to ÖNORM, inevitable grading errors caused by visual grading, are up to 5% of the whole quantity admissible!