

SPECIES

SEASONED SPOTTED GUM AND IRONBARK

F27 IN ALL LENGTHS

NATURAL CHARACTERISTICS	GRADE LIMITATIONS
Fractures, Splits and Shakes. Low density, Termite Galleries	NOT ALLOWED
Knots, Branch Stubs, Knot Holes and other Holes (not insect holes)	$\leq 1/4$ W or T (25% W or T)
Borer Holes (no decay) - up to 3 mm dia. - over 3 mm dia. and separated by $< 2x$ dia.	≤ 20 holes per 100 x 100 mm as for knots
Termite Galleries - not enclosed	As for Want & Wane
Slope of Grain	30 in 300 (1 : 10)
Heart - not effecting utilisation	$< 20\%$ CAR (cross section)
Heart Shakes - Wavy grain if with sloping grain	not permitted
Tight Gum Veins	unlimited
Loose Gum Veins, Ring Shakes, Included Bark; - aggregate length - intersecting an end surface to surface	≤ 3 mm wide, not surface to surface $\leq 1/6$ L not permitted
Gum Pockets, Latex Pockets, Resin Pockets, Overgrowth of Injury - individual length Individual width, measure radially - one surface only (lesser of) - one surface to another (lesser of) - one surface to another & intersecting an end	≤ 300 mm ≤ 20 mm ≤ 12 mm as for end splits
End Splits, Aggregate length	$\leq W$ or 100
Checks, other than internal, ≤ 3 mm wide	$\leq 1/3$ L
Internal Checks, Loss of Cross section	$\leq 1/10$
Primary Rot (decay)	≤ 3 mm deep, $\leq 150 \times 100$ mm in any 2 m
Want and Wane - Lyctid Susceptible Sapwood - individual or aggregate	$\leq 1/5$ (20%) cross section $\leq 1/2$ (50%) W or $1/3$ (33%) T
Hit and Miss, if more than Want and Wane	≤ 3 mm deep, ind. ≤ 600 mm
Bow, Spring and Twist	See Bow, Spring and Twist Tables;
Cupping	Cupping: 1 mm per 50 mm W

TOLERANCES

Sizes	2 & + 1 mm
Squareness	± 20
Square Docked	both ends

BOW, SPRING AND TWIST - ALL GRADES

Length in metres	BOW		SPRING				Length in metres	Twist in mm	TWIST		
	THICKNESS		WIDTH						WIDTH		
	35 mm	45 mm	90 mm	120 mm	140 mm	190mm			90 mm	120/140 mm	190mm
2.4	20	15	9	7	6	4	2.4	35 45	5 4	7 6	10 8
3.0	35	25	14	11	9	7	3.0	35 45	7 5	10 8	14 11
3.6	50	35	20	16	13	10	3.6	35 45	8 6	13 9	18 13
4.8	70	50	30	29	24	18	4.8	35 45	10 7	16 12	23 17
6.0	80	60	45	45	37	28	6.0	35 45	12 9	20 15	28 21

GRADING DECKING

PERMISSIBLE FEATURES - ALL GRADES

SLOPING GRAIN	40 in 300
CUPPING	≤ 1 mm per 100 mm W
BURLS, BIRDSEYE	No Limitation
HOB NAILS, BORER MARKS	No Limitation
BLACK SPECK	No Limitation
SAPWOOD	Unlimited if non-susceptible or treated
STAINS, SAPWOOD natural colour variation	No Limitation

MACHINING IMPERFECTIONS and SURFACE FINISH - ALL GRADES

Skip, hit and miss	Once/board, ≤ 0.5 mm deep
Cutter marks	$>10/30$ mm
Raised grain, ridges, torn grain	≤ 0.5 mm
Chip marks or roller marks	Continuous 1/3 of L unaffected
Pause marks or glazed surfaces	Once per board
Knot chipping	≤ 3 mm wide
Torn corners and edges, gouge, kick out	Permitted within the last 100mm each end

TOLERANCES - ALL GRADES

All Dimensions	± 0.5 mm in W and T
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PERMISSIBLE FEATURES

PERMISSIBLE FEATURES	SELECT GRADE	STANDARD GRADE	HIGH FEATURE
TIGHT KNOTS and associated voids	≤ 15 mm, ≤ 1 / any 1M	≤ 40 mm, ≤ 1 / any 1M	≤ 50 mm, ≤ 1 / any 1M
HOLES including unstained insect holes measure diameter	≤ 2 mm dia, < 2x15 mm, 6 per 80 x 120mm or ≤ 12 / any 1M	≤ 3 mm dia, <3x40 mm, 20 per 80 x 120mm or ≤ 20 / any 1M	≤ 3 mm dia, No limitation
INSECT HOLES stained (Ambrosia) measure diameter	≤ 1 mm dia, < 1x15 mm, 4 per 80 x 120mm or ≤ 10 / any 1M	≤ 2 mm dia, < 2x40 mm, 12 per 80 x 120mm or ≤ 20 / any 1M	3 to ≤ 10 mm; ≤ 3 per any 1 M
TIGHT GUM VEINS	≤ 2 mm wide, ≤ 250 mm	≤ 5 mm wide	No Limitation
BACKSAWN GUM VEINS	Not Permitted	≤ 60 mm wide, ≤ 2 mm deep, ≤ 1/any 1 M	No Limitation
LOOSE GUM VEINS	Not Permitted	≤ 3 mm wide, no end, aggr. ≤ L/6 length	≤ 3 mm wide, no end, aggr. ≤ L/4 length
GUM POCKETS, OVERGROWTH of INJURY, OTHER POCKETS	Not Permitted	≤ 500 mm ² , (20 x 25mm) ≤ 3 mm deep	≤ 1200 mm ² , (15 x 75mm) ≤ 3 mm deep
KNOT CHECKS	≤ 1 mm wide	≤ 2 mm wide	≤ 3 mm wide
CHECKS	≤ 1 mm wide, ind. ≤ 250 mm	≤ 2 mm wide, ind. ≤ 250 mm	≤ 3 mm wide
STICKER MARKS	Not Permitted	Not Permitted	Not Permitted

BOW, SPRING and TWIST - ALL GRADES

Length in Metres	BOW	SPRING		TWIST		Length in Metres
		WIDTH		WIDTH		
	19 mm	64 mm	86 mm	64 mm	86 mm	
1.5	8	8	6	3	4	1.5
1.8	11	11	8	4	5	1.8
2.4	19	19	15	5	6	2.4
3.0	30	30	23	6	8	3.0
3.6	45	45	35	7	10	3.6
4.2	60	60	47	8	11	4.2
4.8	75	75	58	10	13	4.8
5.4	95	95	75	11	14	5.4
6.0	110	115	95	12	16	6.0

PERMISSABLE FEATURE IN FLOORING

PERMISSIBLE FEATURES IN ALL GRADES

BOW, SPRING and TWIST

See Tables

CUPPING

≤ 1 mm per 100mm Width

BURLS, BORER MARKS

No Limitation

HOB NAILS, BIRDSEYE

No Limitation

NOT PERMITTED in ANY GRADE on SURFACE

- Enclosed termite galleries;
- Heart and Heart shakes
- Shakes; Cross-fractures and cross-shakes
- Splits and End splits
- Decay and primary rot
- Lyctid-susceptible sapwood
- Loose Gum Veins
- Gum Pockets
- Overgrowth of Injury
- Other pockets from surface to surface or intersecting an end
- Holes and knot holes > 10 mm.

NOT PERMITTED in ANY GRADE on ANY EXPOSED SURFACE

- Want and Wane; Mechanical damage
- Stain other than natural discolouration
- Sticker marks.

PERMISSIBLE FEATURES

PERMISSIBLE FEATURES	SELECT GRADE	STANDARD GRADE	FEATURE GRADE
SAPWOOD	No limitation if Non-susceptible or treated	No limitation if Non-susceptible or treated	No limitation if Non-susceptible or treated
TIGHT KNOTS and associated voids	≤15 mm or 1/4W, ≤1 / any 1M	≤40 mm or 1/3W, ≤2 / any 1M	≤50 mm or 3/8W, ≤4 / any 1M
HOLES < 1 mm in DIAMETER	Concentration < 20 in any 100 cm ² Spread < Average of 15 per 100 cm ² over the length of the board	Concentration < 40 in any 100 cm ² Spread < Average of 30 per 100 cm ² over the length of the board	No limitation
HOLES > 1 mm in DIAMETER	< 2 mm in diameter Concentration < 6 in any 100 cm ² Spread < Average of 4 per 100 cm ² over the length of the board	< 3 mm in diameter Concentration < 20 in any 100 cm ² Spread < Average of 4 per 100 cm ² over the length of the board	< 3 mm in diameter – no limitation >3 mm in diameter and < 10 mm in diameter no more than 3 in any 1m length
TIGHT GUM VEINS (Quartersawn, straight line))	≤2 mm wide, individual length. ≤250 mm, Aggr. ≤1/2L	≤5 mm wide Aggr. ≤1/2L	Unlimited
TIGHT GUM VEINS (Backsawn, blotch)	≤2 mm wide, individual length. ≤250 mm, Aggr. ≤1/2L	2 mm deep < 1000mm long Aggregate < 2/3 of length < ¾ of face width	Unlimited
LOOSE GUM VEINS	Not Permitted	≤3 mm wide, Aggregate. ≤1/6 L	≤3 mm wide, Aggregate. ≤1/4 L
GUM POCKETS, OVERGROWTH of INJURY, OTHER POCKETS	Not Permitted	≤500 mm ² ≤3 mm deep	≤1200 mm ² ≤3 mm deep
KNOT CHECKS	Not Permitted	≤2 mm wide	Unlimited but structurally sound
CHECKS	≤0.5 mm wide, Aggr. ≤1/2 of length	≤2 mm wide, ind. ≤250 mm	< 3 mm wide Unlimited length
STAINS, natural discolouration	Slight up to 10% of board surface area	No Limitation	No Limitation
BLACK SPECK	Slight up to 10% of board surface area	No Limitation	No Limitation
STICKER MARKS	Not Permitted	Not Permitted	No Limitation

TOLERANCES - ALL GRADES

Overall thickness	+ or - 0.5 mm
Other dimensions in thickness	+ or - 0.3 mm
Mismatch	<=0.5 mm
Clearance tongue and groove	<=0.6 mm and >= 0.3 mm
Dimensions in width, including cover width	+ or - 0.3 mm

MACHINING IMPERFECTIONS and SURFACE FINISH

Skip, hit and miss	Once per board, <=0.5 mm deep
Cutter marks	>10/30mm
Raised grain, ridges, torn grain	<=0.5 mm
Chip marks or roller marks	Continuous 1/3 of L unaffected, (<=0.5 mm deep)
Pause marks or glazed surfaces	Once per board and unlimited in feature
Knot chipping	<=3 mm wide
Torn corners and edges, gouge, kick out	Not permitted

TONGUE and GROOVE IMPERFECTIONS

Short Tongue, Broken Tongue, Broken Under-Groove All Grades

< 50% of tongue or under-groove missing	Individual <= 250 mm Aggregate <= 500 mm or ¼ of L (lesser of)
> 50% of tongue or under-groove missing	Individual <= 200 mm Aggregate <= 250 mm or ¼ of L (lesser of)

ON CONCEALED SURFACES - ALL GRADES

Natural features	As for Natural Grade (High Feature Grade)
Want and Wane, Mechanical damage	1/3 of W or T; aggregate. <=300 mm
Stains and Stickermarks	Unlimited
Heart Checks	Feature Grade only unlimited

BOW, SPRING and TWIST - ALL GRADES

Length in Metres	BOW		SPRING			TWIST			Length in Metres
	THICKNESS		WIDTH			WIDTH			
	15 mm	19 mm	60 mm	80 mm	130 mm	60 mm	80 mm	130 mm	
1.2	6	5	6	5	4	2	3	5	1.2
1.8	13	11	14	12	8	4	5	8	1.8
2.4	22	19	25	21	15	5	6	10	2.4
3.0	35	30	40	33	23	6	8	13	3.0
3.6	50	45	60	50	33	7	10	16	3.6
4.2	70	60	80	67	48	8	11	18	4.2
4.8	90	75	100	83	58	10	13	21	4.8
5.4	110	95	130	106	73	11	14	23	5.4
6.0	130	110	150	130	90	12	16	26	6.0