



**THERMORY**  
Excellence in Wood

# THERMORY® CLEAR PINE










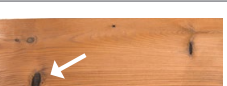




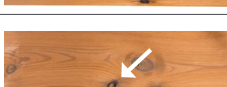


## GRADING RULES



*Photo: thermally modified clear pine for cladding*

All boards are graded by the better face.

The final grade of our Thermory® Clear Pine products (grade Clear) corresponds to following criteria:

GRADED BY THE BETTER FACE		BETTER FACE	BACK FACE *
HIT&MISS		<i>not allowed</i>	<i>max. 50% of the width of the board</i>
FEED-ROLLER MARKS		<i>not allowed</i>	<i>allowed</i>
WANE		<i>not allowed</i>	<i>max. 1/3 of the width and 20% of the thickness of the board</i>
MECHANICAL DEFECTS		<i>not allowed</i>	<i>allowed</i>
SURFACE CHECKS		<i>max. 100 mm long</i>	<i>allowed</i>
SHAKES		<i>not allowed</i>	<i>not allowed</i>
END SPLITS		<i>max. length = width of the board</i>	<i>allowed</i>
RING SHAKE		<i>not allowed</i>	<i>not allowed</i>
SOUND KNOTS		<i>not allowed</i>	<i>allowed</i>
KNOT HOLE		<i>not allowed</i>	<i>allowed</i>
BARK KNOTS		<i>not allowed</i>	<i>allowed</i>
DEAD KNOTS		<i>not allowed</i>	<i>allowed</i>
BLACK KNOTS		<i>not allowed</i>	<i>allowed</i>
UNSOUND KNOTS		<i>not allowed</i>	<i>allowed</i>
BROKEN KNOTS		<i>not allowed</i>	<i>allowed</i>
KNOT SHAKE		<i>not allowed</i>	<i>allowed</i>
PIN KNOTS		<i>not allowed</i>	<i>allowed</i>

GRADED BY THE BETTER FACE		BETTER FACE	BACK FACE *
SPIKE KNOTS		<i>not allowed</i>	<i>allowed</i>
EDGE & ARRIS KNOTS		<i>not allowed</i>	<i>allowed</i>
KNOT CLUSTER		<i>not allowed</i>	<i>allowed</i>
PARTIALLY INTER-GROWN KNOTS		<i>not allowed</i>	<i>allowed</i>
RESIN POCKET		<i>max. length 60 mm; max width 5 mm</i>	<i>allowed</i>
SCAR		<i>not allowed</i>	<i>allowed</i>
HEARTWOOD		<i>allowed</i>	<i>allowed</i>
PITH		<i>max. 20% of the length of the board</i>	<i>allowed</i>
SLOPE OF GRAIN		<i>allowed</i>	<i>allowed</i>
BARK		<i>not allowed</i>	<i>allowed</i>
ROT AND MOULD		<i>not allowed</i>	<i>not allowed</i>
BLUE STAIN		<i>not allowed</i>	<i>allowed</i>
INSECT HOLES		<i>not allowed</i>	<i>allowed</i>
BOW		<i>allowed up to 2 mm per linear meter</i>	
SPRING		<i>allowed up to 7.5 mm per linear meter</i>	
TWIST		<i>allowed up to 5% per linear meter, has to be reversible during installation</i>	
CUP		<i>allowed up to 1% of the width of the board</i>	
TOLERANCES:		<i>thickness +/- 0.5 mm width +0.5/- 1 mm</i>	

The pine photos used above are suitable to illustrate here also the radiata pine.

up to 5% of the volume can be of lower grade

\*Defects acceptable on the back face, but of undefined size must not exceed the size where they pose a threat to the consistency, usability or visual integrity of the product.

Last updated: May 2018.  
All previous versions are null and void.