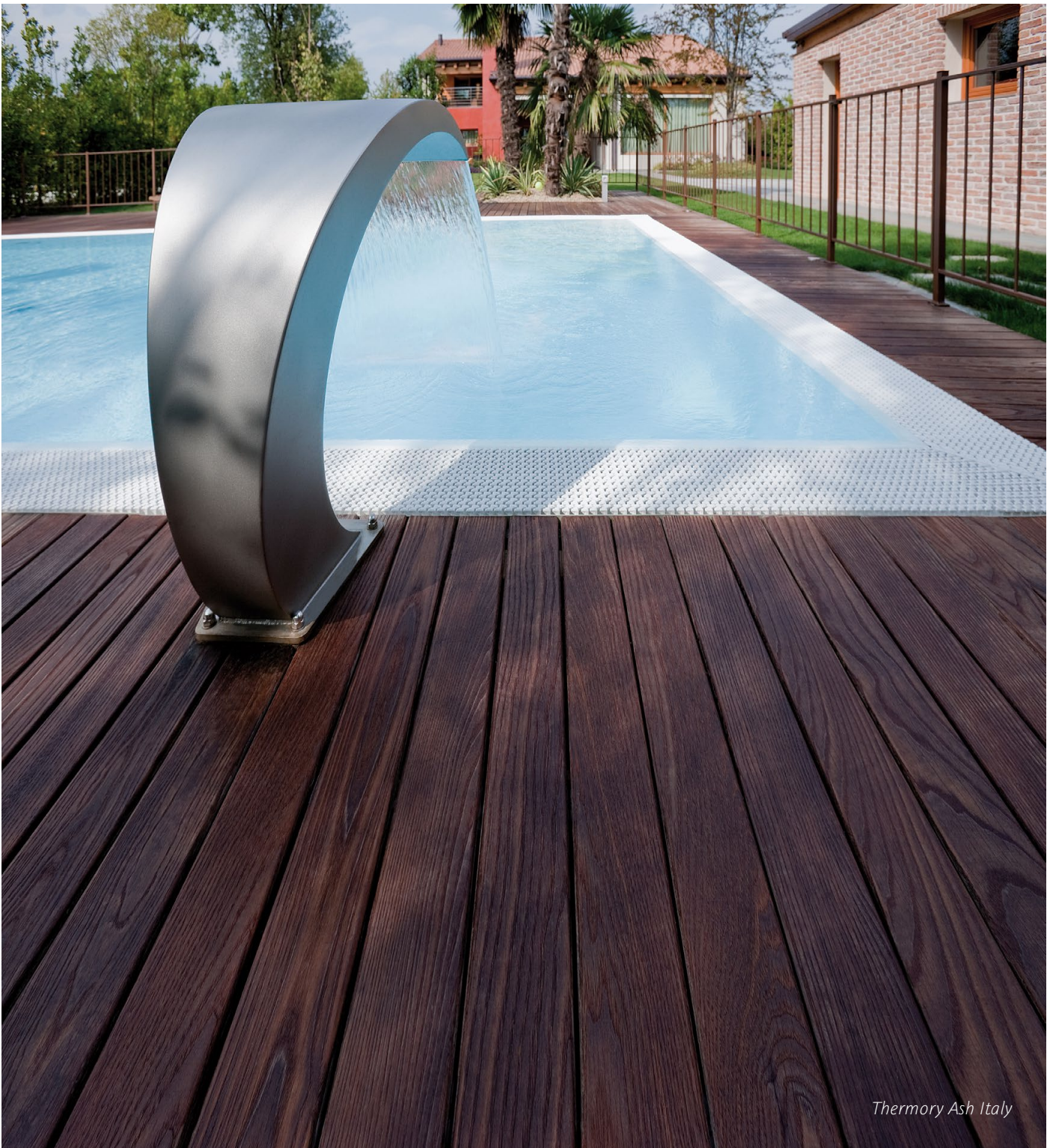




THERMORY
Excellence in Wood

THERMORY® ASH GRADING RULES



Thermory Ash Italy

All boards are graded by the better face.

The final* grade of our Thermory Ash products (grade Select) corresponds to following criteria:

GRADED BY THE BETTER FACE		BETTER FACE	BACK FACE
HIT&MISS		<i>not allowed</i>	<i>unlimited</i>
FEED-ROLLER MARKS		<i>not allowed</i>	<i>unlimited</i>
WANE		<i>not allowed</i>	<i>max 1/3 of width and 20% of the thickness of the board</i>
MECHANICAL DEFECTS		<i>not allowed</i>	<i>unlimited</i>
SURFACE CHECKS		<i>up to 1 mm wide and 50 mm long</i>	<i>unlimited</i>
SHAKES		<i>not allowed</i>	<i>not allowed</i>
RING SHAKE		<i>not allowed</i>	<i>not allowed</i>
END SPLITS		<i>up to 30 mm</i>	<i>unlimited</i>
KNOT HOLE & BLACK KNOTS		<i>up to 5 mm</i>	<i>unlimited</i>
DEAD KNOTS		<i>not allowed</i>	<i>unlimited</i>
BROKEN KNOTS		<i>not allowed</i>	<i>unlimited</i>
KNOT SHAKE		<i>not allowed</i>	<i>unlimited</i>
PIN KNOTS		<i>up to Ø 15 mm</i>	<i>unlimited</i>
ARRIS KNOTS		<i>not allowed</i>	<i>unlimited</i>
EDGE KNOTS		<i>up to 1/2 of the thickness of the board</i>	<i>unlimited</i>
KNOT CLUSTER		<i>not allowed</i>	<i>unlimited</i>
PARTIALLY INTER-GROWN KNOTS		<i>not allowed</i>	<i>unlimited</i>

GRADED BY THE BETTER FACE	BETTER FACE	BACK FACE
SCAR 	<i>up to 200 mm²</i>	<i>unlimited</i>
HEARTWOOD	<i>unlimited</i>	<i>unlimited</i>
PITH 	<i>not allowed</i>	<i>unlimited</i>
BARK	<i>not allowed</i>	<i>not allowed</i>
ROT & MOLD	<i>not allowed</i>	<i>not allowed</i>
INSECT HOLES 	<i>not allowed</i>	<i>unlimited</i>
GLASS WORM MARKS 	<i>unlimited</i>	<i>unlimited</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>up to 1% of the width of the board</i>	
TOLERANCES:	<i>thickness +/- 0.5 mm width +/- 0.7 mm</i>	

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

All defects of the reverse side are allowed as long as they do not affect the structural integrity of the board and are not visible on the face.