



THERMORY® PINE GRADING RULES








To suit every taste and style, Thermory has three grades available: Natur, Rustic and Country.
All boards are graded by the better face.

The final grades of our Thermory® Pine products correspond to the following criteria:

GRADED BY THE BETTER FACE	GRADE: NATUR		GRADE: RUSTIC	GRADE: COUNTRY	
	BETTER FACE	BACK FACE *		BETTER FACE	BACK FACE *
HIT&MISS		not allowed	85% NATUR AND 15% COUNTRY	allowed up to 300 mm from both ends	unlimited
FEED-ROLLER MARKS		not allowed		allowed up to 300 mm from both ends	unlimited
WANE		not allowed		allowed up to 300 mm from both ends	unlimited
MECHANICAL DEFECTS		not allowed		allowed up to 300 mm from both ends	unlimited
SURFACE CHECKS		max 100 mm long		allowed up to 2 mm wide and 1 m long	unlimited
SHAKES		not allowed		allowed up to 300 mm from both ends	unlimited
END SPLITS		max length = width of the board		allowed up to 300 mm from both ends	unlimited
RING SHAKE		not allowed		allowed up to 300 mm from both ends	unlimited
SOUND KNOTS		visual grading, not measured, has to maintain integrity of the board		allowed	unlimited
KNOT HOLE		not allowed		allowed up to Ø 20 mm in whole length*	unlimited
BARK KNOTS		sound, up to Ø 30 mm, bark not over half of the diameter		allowed if not disturbing visually	unlimited
DEAD KNOTS		up to Ø 15 mm		allowed	unlimited

*Knots passing through the board are not allowed in defect-free areas.

GRADED BY THE BETTER FACE		GRADE: NATUR		GRADE: RUSTIC	GRADE: COUNTRY	
		BETTER FACE	BACK FACE *		BETTER FACE	BACK FACE *
BLACK KNOTS		Ø up to 20% of the width of the board	unlimited	85% NATUR AND 15% COUNTRY	allowed	unlimited
UN SOUND KNOTS		not allowed	unlimited		allowed if not disturbing visually	unlimited
BROKEN KNOTS		allowed if not disturbing visually, evaluated from a distance min 1,5 m	unlimited		allowed if not disturbing visually, evaluated from a distance min 1,5 m	unlimited
KNOT SHAKE		up to 1 mm wide and 50 mm long	unlimited		allowed	unlimited
PIN KNOTS		allowed	unlimited		allowed	unlimited
SPIKE KNOTS		Ø up to 1/2 of the width of the board	unlimited		allowed	unlimited
EDGE & ARRIS KNOTS		allowed	unlimited		allowed	unlimited
KNOT CLUSTER		visual grading, not measured, has to maintain integrity	unlimited		allowed	unlimited
PARTIALLY INTER-GROWN KNOTS		bark up to 1/2 of the diameter	unlimited		allowed if not disturbing visually	unlimited
RESIN POCKET		allowed up to 300 mm²	unlimited		allowed	unlimited
SCAR		allowed up to 300 mm²	unlimited		allowed in reasonable amount	unlimited
HEARTWOOD		allowed	unlimited		allowed	unlimited
DISCOLORATION		light changes in color are allowed	unlimited		allowed	unlimited

GRADED BY THE BETTER FACE	GRADE: NATUR		GRADE: RUSTIC	GRADE: COUNTRY	
	BETTER FACE	BACK FACE *		BETTER FACE	BACK FACE *
PITH 	<i>max 20% of the length of the board</i>	<i>unlimited</i>	85% NATUR AND 15% COUNTRY	<i>allowed</i>	<i>unlimited</i>
SLOPE OF GRAIN	<i>allowed</i>	<i>unlimited</i>		<i>allowed</i>	<i>unlimited</i>
BARK	<i>not allowed</i>			<i>allowed</i>	<i>unlimited</i>
ROT	<i>not allowed</i>			<i>not allowed</i>	
MOULD	<i>not allowed</i>			<i>not allowed</i>	
BLUE STAIN	<i>not allowed</i>			<i>not allowed</i>	
INSECT HOLES	<i>not allowed</i>	<i>unlimited</i>		<i>not allowed</i>	<i>unlimited</i>
BOW 	<i>allowed up to 2 mm per linear meter</i>			<i>allowed up to 2 mm per linear meter</i>	
SPRING 	<i>allowed up to 75 mm per linear meter</i>			<i>allowed up to 75 mm per linear meter</i>	
TWIST 	<i>allowed up to 5% per linear meter, has to be reversible during installation</i>			<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>			<i>up to 1% of the width of the board</i>	
TOLERANCES:	<i>thickness: +/-0.5 mm; width: +/-0.5/-1.0 mm</i>		<i>thickness: +/-0.5 mm; width: +/-0.5/-1.0 mm</i>		

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.