

accoya®



COLOR

Rough Sawn & Deckboard Grading Specifications

Grade & Definitions for Accoya® Color
North America | Version 1

GRADING

Accoya Color Rough Sawn

Grading takes place across 3 zones



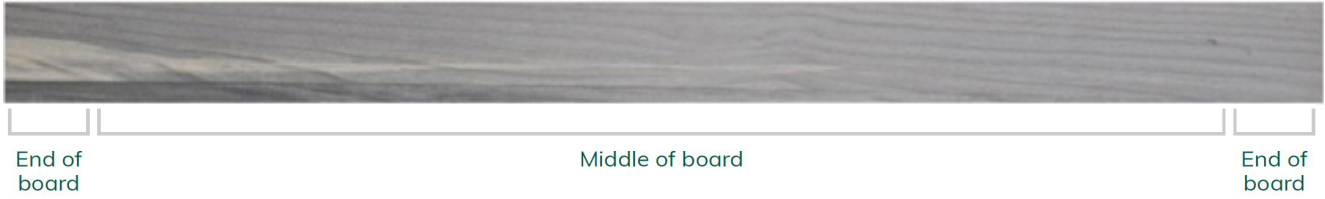
Layer of Typical Rough Sawn Boards



GRADING

Accoya Color Deckboards

Grading takes place across 3 zones



Layers of Typical Color Deckboards



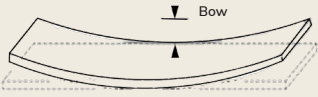
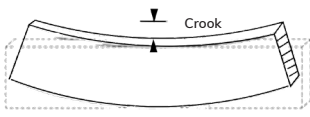
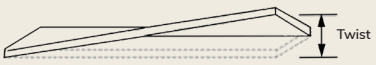
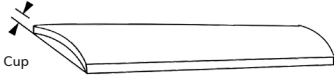
GRADING

Accoya Color Grading Rules

Accoya Color Rough Sawn - these boards are skimmed, generally on sapwood face for Color quality check. This is defined as the top face. These grading rules apply to the boards as delivered and visible defects in that delivered form. The grading rules do not apply to boards which have been further processed by the manufacturer or any further step.

Accoya Color Deckboards - the grading rules apply to boards supplied as profiled to the finished deck board by manufacturers, Accsys, and of those boards in the delivered state. As with all wood products, supplemental defects might develop in service and are outside the scope of this Grading specification.

Accoya Color Grading Table

		Graded by the better face	Better Face	Back Face														
Color Defects	At the end of the board		Maximum 24 inches patch total length	Unlimited														
	In the middle of the board		Up to 3 patches allowed Maximum 24 inches total length	Unlimited														
	Along the edge of the board		Maximum 1 inches wide	Unlimited														
	Between boards		Variable shades of grey permitted	Unlimited														
	Total surface area		Maximum no color uptake on 15% of surface area. Brown staining (will machine out)	Unlimited														
Wood Defects	Up to 3 of the following defects or equivalent	Knot (pin)	1/2 inches diameter or less	Unlimited														
		Bark or resin pocket	5/16 inches wide, 2 inches long or equivalent	Unlimited														
		Resin streaks	A set of three up to 5/16 inches wide, 4 inches long or equivalent, E.g. equivalent could be 6 qty 5/16 inches wide and 2 inches long	Unlimited														
	Surface checks		Three up to 1/16" wide, 10" long or equivalent	Unlimited														
	Splits and end splits		Short split, up to width of board and not to exceed 8"	n/a														
	Wane		Not allowed	Unlimited														
	Bow		<table border="1"> <thead> <tr> <th colspan="2">Allowable Limit</th> </tr> </thead> <tbody> <tr> <td>8 ft</td> <td>1.18 in</td> </tr> <tr> <td>12ft</td> <td>2.56 in</td> </tr> <tr> <td>14ft</td> <td>3.54 in</td> </tr> <tr> <td>16ft</td> <td>4.72 in</td> </tr> </tbody> </table> 	Allowable Limit		8 ft	1.18 in	12ft	2.56 in	14ft	3.54 in	16ft	4.72 in					
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Tolerances		Thickness - 0.02 in Width - 0.04 in																

Up to 5% of boards off grade shall be deemed acceptable.



Get in touch

Please email us with enquiries and the responsible sales manager will follow up promptly:

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North America

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972-233-6565

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