



**Appearance Grades  
Timber Grading Rules**

Finished Product



Carefully Crafted Timber

# Ethically Sourced Wood

Abodo is proudly a 100% New Zealand owned company headquartered in Auckland, New Zealand. Our plantation wood products are renewable, and more importantly, durable in almost any application imaginable.

By harnessing the latest wood preservation and modification technology, and combining this with high quality New Zealand Radiata Pine, Douglas Fir and Eucalyptus, Abodo is able to offer a range of long lasting appearance grade timbers.

Abodo's wood fibre is sourced from FSC certified forests in New Zealand's North Island.

Choosing high performance, plantation wood products is a step in the right direction for sustainable construction.

## Abodo Appearance Grades – Finished Product

Clears

Select

Premium

Feature

Standard and Better

Merchantable

Note – The timber is visually graded, therefore up to 5% of total volume may be supplied out of grade, allowing for human error.



The mark of responsible forestry

Radiata Pine products supplied by Abodo are available in FSC® certified form. Abodo is committed to supplying timber products sourced from responsibly managed forests.

# Clears Grade

## Graded to the Best Face and Two Edges

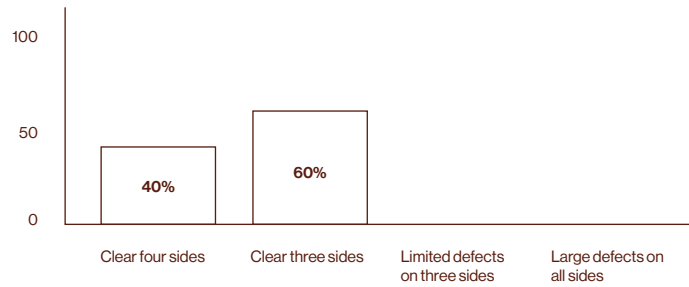
### Specifications

The highest grade available, with a mix of clear four sides (Number 1 Clears) and clear three sides (Number 2 Clears) product. The best face of the board and two edges allow the following permitted defects:

- Birds eye fleck.
- Kiln check 0.5mm wide by 50mm long, one per board.
- Sap stain insufficient to obscure the grain.
- Bow, crook, cup, twist as given in tables 1, 2, 3, 4 of appendix.

For Number 2 Clears product only, the reverse face may contain knots and defects as described in Premium grade.

### Indicative percentage of lengths per grade



Best Face



Reverse

# Select Grade

## Graded to the Best Face and Two Edges

### Specifications

A high appearance grade with front face and edges primarily clear but with some small defects allowed in some boards.

Front face and edges allow isolated defects as follows:

- Birds eye fleck – medium.
- Sap stain – insufficient to obscure grain.
- Edge defect – one tight knot, resin or bark pocket in bottom two thirds of edge only.
- Bow, crook, cup, twist as given in tables 1, 2, 3, 4 of appendix.

In **20% of boards** one defect is allowed on the best face as follows:

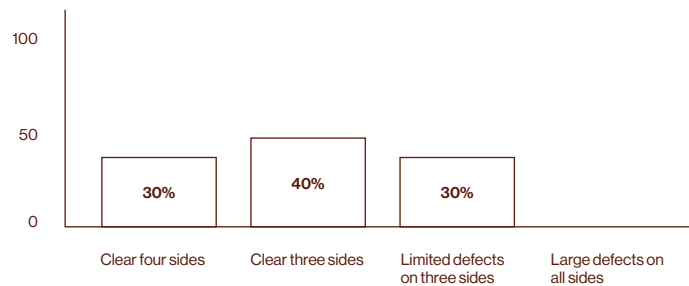
- Small tight knot (inter-grown or tight encased) <5mm diameter.
- Resin or bark pocket <30mm length x 3mm width.
- Kiln check less than 1mm wide x 50mm long.

The reverse face of the board may contain knots and defects as described in Premium Grade.

Cladding profiles may have skip dress present on the back face.

Laminated cladding boards may have one under thickness lamina up to 4mm depth on the back face, provided the function of the product is not compromised ie: boards fit together correctly and will sit flat on a wall.

### Indicative percentage of lengths per grade



Best Face



Reverse

# Premium

## Graded to the Best Face

### Specifications

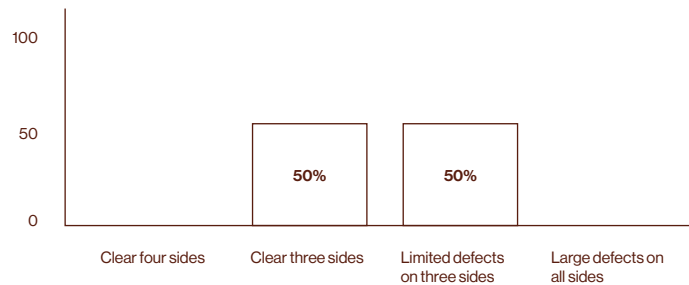
A good appearance grade that combines some clear three sides product, along with some product with small defects.

Front face and edges allow permitted defects as follows:

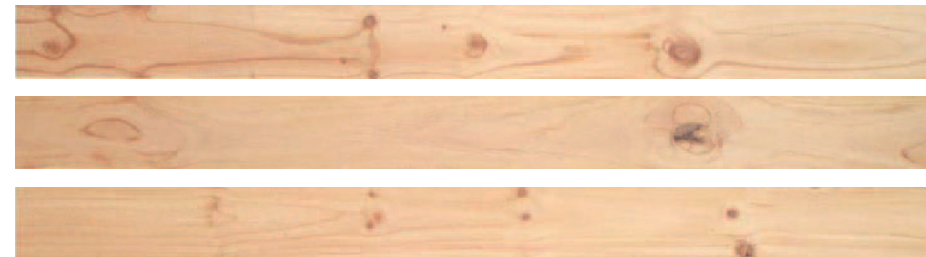
- Sound knots singly and in combination up to one third of the board width only.
- Resin pockets 6mm wide x 50mm long, three per board.
- Surface checks less than 1mm wide x 200mm long.
- Edge defects in bottom two thirds of edge only.
- Spike knots inter grown up to 20mm wide.
- Tight encased knots maximum 10mm wide, three per board.
- Sap stain insufficient to obscure the grain.
- Bow, crook, cup, twist as given in tables 1, 2, 3, 4 of appendix.

The reverse face may contain all permitted defects described in Standard and Better Grade except no pith, holes, wane or wane allowed.

### Indicative percentage of lengths per grade



Best Face



Reverse

# Standard and Better Grade

## Graded to the Best Face

### Specifications

A tight knot grade with some pith allowed.

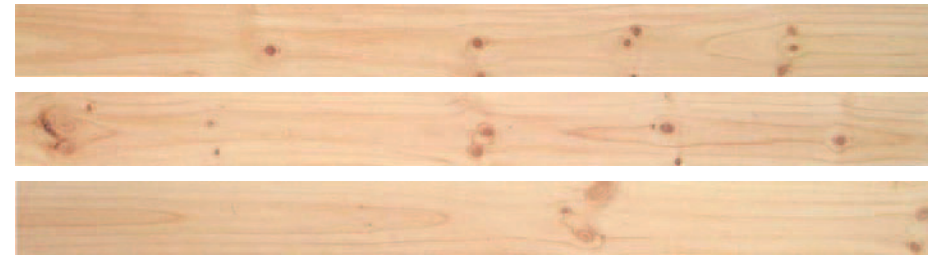
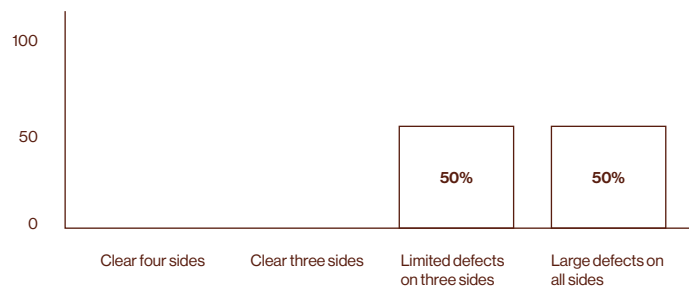
Permitted defects:

- Knots and resin pockets singly and in combination up to half the width of the board.
- Checks not exceeding 1mm in less than 5% of pieces.
- Tight encased knots up to 10mm wide and up to four per piece.
- Wandering pith, less than 100mm length individually.
- Spike knots less than 20mm wide.
- Edge defects.
- Sap stain insufficient to obscure the grain.
- Bow, crook, cup, twist as given in tables 1, 2, 3, 4 of appendix.

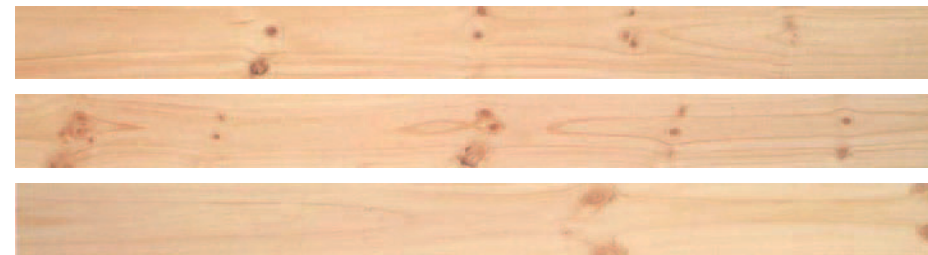
The reverse face may contain unlimited pith.

Cladding profiles may have skip dress present on the back face.

### Indicative percentage of lengths per grade



Best Face



Reverse

# Merchantable Grade

## Graded to the Best Face

### Specifications

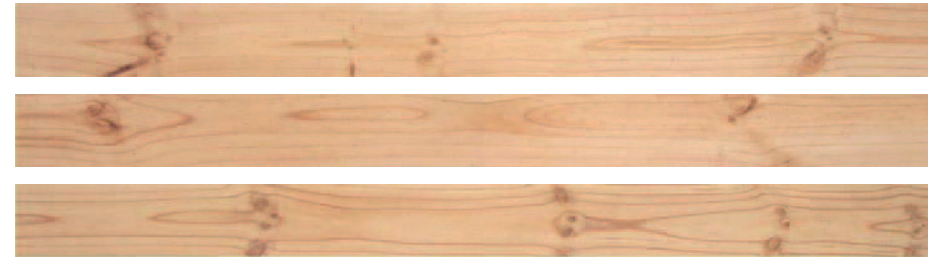
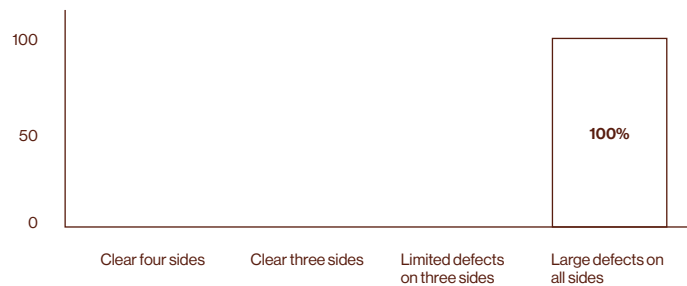
A knotty grade with large defects generally used for low appearance applications.

Permitted defects:

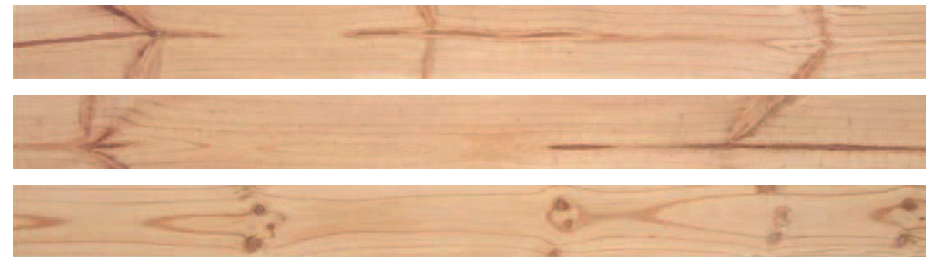
- Knots singly and in combination up to three quarters the width of the board.
- Tight encased knots less than 20mm.
- Spike knots up to 50mm on two thirds the width of the wood.
- Surface checks less than 100mm long.
- Bark or resin pockets 20mm wide x 50mm long.
- Holes up to 30mm and two per piece.
- Sap stain insufficient to obscure the grain.
- Pith 12mm wide and less than 10% of the board length.
- Bow, crook, cup, twist as given in tables 1, 2, 3, 4 of appendix.

Reverse face may contain – pith 12mm wide unlimited; wane and want 20mm wide on face and 10mm wide on edges.

### Indicative percentage of lengths per grade



Best Face



Reverse

# Appendix

**Table 1  
Permitted Bow (mm)**

Length (m)	Thickness (mm)					
	25	30	40	50	75	100
1.8	15	15	10	10	5	5
2.1	25	20	15	10	10	5
2.4	30	25	20	15	10	10
2.7	40	30	25	20	15	10
3.0	45	40	30	25	15	10
3.3	55	45	35	30	20	15
3.6	65	55	40	35	25	15
3.9	80	65	50	40	25	20
4.2	90	75	55	45	30	25
4.5	105	90	65	55	35	25
4.8	120	11	75	60	40	30
5.1	135	115	85	70	45	35
5.4	150	125	95	75	50	40
5.7	170	140	105	85	55	40
6.0	185	155	115	95	65	45
6.6	225	190	140	115	75	55
7.2	270	225	170	135	90	70

**Table 2  
Permitted Crook (mm)**

Length (m)	Thickness (mm)					
	75	100	125	150	200	Over 200
1.8	5	4	3	3	2	2
2.1	10	5	5	4	3	2
2.4	10	10	5	5	4	3
2.7	15	10	10	5	5	4
3.0	15	10	10	10	5	5
3.3	20	15	10	10	5	5
3.6	25	15	15	10	10	5
3.9	25	20	15	15	10	10
4.2	30	25	20	15	10	10
4.5	35	25	20	20	15	10
4.8	40	30	25	20	15	10
5.1	45	35	25	25	15	15
5.4	50	40	30	25	20	15
5.7	55	40	3	30	20	15
6.0	65	45	40	30	25	20
6.6	75	55	45	40	30	25
7.2	90	70	55	45	35	25

**Table 3  
Permitted Cup (mm)**

Face Width (mm)	Permitted Cup (mm)
75	1
100	1
125	2
150	2
200	2
225	4
250	5
300	6

**Table 4  
Permitted Twist per 100mm of Width (mm)**

Length (m)	Thickness (mm)					
	25	30	40	50	75	100
1.8	10	10	5	5	3	2
2.1	10	10	10	5	4	3
3.0	15	15	10	10	5	4
3.6	20	15	10	10	5	5
4.2	20	20	15	10	5	5
4.8	25	20	15	10	10	5
5.4	25	25	15	15	10	5
6.0	30	25	20	15	10	10
6.6	35	30	20	15	10	10
7.2	35	30	25	20	10	10





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