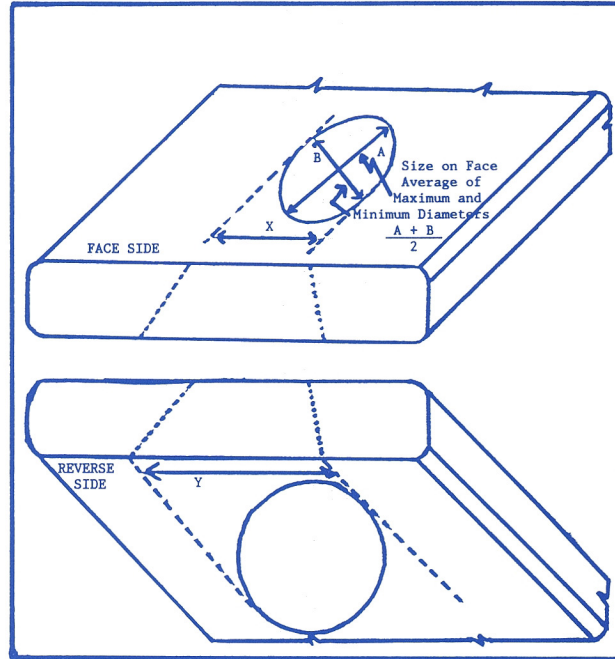




**GRADER'S
POCKET GUIDE
FOR
RADIUS EDGE DECKING**

Southern Pine Inspection Bureau
Pensacola, Florida

**How to Measure Knots
in
RADIUS EDGE DECKING**



SPIB GRADING RULES FOR RADIUS EDGE DECKING			
DEFECTS	PREMIUM	STANDARD	REVERSE SIDE STANDARD
Checks	1/32" wide x 10" long. If through – 1/32" wide by width of piece	Surface – not limited Through – 2 times width	No limit
Compression Wood	None if readily identifiable and damaging form		
Decay	None	None	1/3 width by 1/3 thickness
Firm Red Heart	25% of face	No limit	No limit
Holes	One 1/4" hole every 4'	Well scattered – 1/4"	No limit
Knots	Sound-Firm-Encased-Pith, if tight and well spaced: 4" width – 1" 6" width – 1-1/2" Decayed knots with serious pits and cavities – 1/2 the sound knot size. All knots in any 4' may not be over twice the maximum size knot	Sound-Firm-Encased-Pith, if tight and well spaced: 4" width – 1-1/2" 6" width – 2-1/2" Decayed knots with serious pits and cavities: 4" width – 1" 6" width – 1-1/2"	No limit except to 55% of the cross section as noted directly below
	Premium: Knot average on front and back cannot be larger than 45% of the cross section using the displacement method (between lines parallel to the edges).		
	Well-Spaced – The sum of all knots in any 6" of length may not be larger than twice the size of maximum size knot.		
Manufacture	Same as No. 2 Boards STD E	Same as No. 2 Boards STD E	No limit
Pitch	Medium	Medium	Heavy
Pitch Pockets	Medium	Medium	No limit
Pitch Streaks	1/6 width by 1/3 length	1/6 width by 1/3 length	No limit
Pith	No limit if sound	No limit if sound	No limit
Shakes	Surface – 1/32" wide Through at end – Width of piece	Surface – 1/8" wide Through at end – Two times width, but not over 1/6 length	No limit
Splits	Width of piece	Two times width	
Skips	1/64" for 6" or equivalent Same on edge	1/32" on 10% face 1/16" on edge (Hit or Miss)	1/32" full length
Slope of Grain	1" in 8"	1" in 8"	1" in 8"
Stain	Medium	Medium	Heavy
Wane	1/8" deep by 1/2" wide Reverse side – 1/2" deep by 1" wide	1/8" deep by 1/2" wide	1/2" deep by 1" wide
Crook For 6" Width	10/5/8 12/7/8 14 1-1/8 16 1-3/8 18 1-1/2	8/5/8 10 1 12 1-1/4	14 1-1/2 16 1-3/4 18 2
Loosened Grain	1/8" separation	1/8" separation	No limit
Offset	1/16" deep	1/16" deep	1/16" deep
Bites	1/16" deep	1/16" deep	1/16" deep