



## USA - Grading rules for dimension lumber

Widths		Centreline knots (on wide face)				Combination knots (two or more knots in cross section)				Edge knots (at edge of wide face)				Knot area (narrow face knots / spikeknots)				Holes (also decay, loose knots for Sel Str & No.1)			
mm	inches	mm				displacement %				mm				displacement %				mm			
		Sel Str	No. 1	No. 2	No.3 Stud	Sel Str	No. 1	No. 2	No.3 Stud	Sel Str	No. 1	No. 2	No.3 Stud	Sel Str	No. 1	No. 2	No.3 Stud	Sel Str	No. 1	No. 2	No.3 Stud
89	4"	22	38	<b>51</b>	64	25	43	<b>57</b>	71	19	25	<b>32</b>	44	21	29	<b>36</b>	50	19	25	<b>32</b>	44/38
140	6"	48	57	<b>73</b>	95	34	41	<b>52</b>	68	29	38	<b>48</b>	70	20	27	<b>34</b>	50	25	32	<b>38</b>	51
184	8"	57	70	<b>89</b>	114	31	38	<b>48</b>	62	38	51	<b>64</b>	89	21	28	<b>34</b>	48	32	38	<b>51</b>	64
235	10"	67	83	<b>108</b>	140	28	35	<b>46</b>	59	48	64	<b>83</b>	114	20	27	<b>35</b>	49	32	38	<b>64</b>	76
286	12"	76	95	<b>121</b>	165	25	31	<b>42</b>	56	57	76	<b>96</b>	140	20	27	<b>33</b>	49	32	38	<b>75</b>	89

Sizes		Lengths		Bow (mm)			Crook (mm)			Twist (mm)			Cup (mm)						
mm	inches	m	feet	Sel Str	No.1	No.2	No.3	Sel Str	No.1	No.2	No.3	Sel Str	No.1	No.2	No.3	Sel Str	No.1	No.2	No.3
		Const	Stud	Const	Stud	Stdnd	Util	Const	Stud	Stdnd	Util	Const	Stud	Stdnd	Util	Const	Stud	Stdnd	Util
38 x 89	2 x 4"	2,44	8'	13	<b>19</b>	25	6	<b>10</b>	13	10	<b>13</b>	19	1	<b>1</b>	2				
		3,05	10'	35	<b>38</b>	70	10	<b>13</b>	19	11	<b>16</b>	22	1	<b>1</b>	2				
		3,66	12'	38	<b>51</b>	76	13	<b>17</b>	25	14	<b>19</b>	29	1	<b>1</b>	2				
		4,27	14'	51	<b>64</b>	102	16	<b>22</b>	32	16	<b>22</b>	32	1	<b>1</b>	2				
		4,88	16'	64	<b>83</b>	127	19	<b>25</b>	38	19	<b>25</b>	38	1	<b>1</b>	2				
38 x 140	2 x 6"	2,44	8'	13	<b>19</b>	25	6	<b>8</b>	13	14	<b>19</b>	29	2	<b>2</b>	3				
		3,05	10'	35	<b>38</b>	70	8	<b>11</b>	16	17	<b>22</b>	35	2	<b>2</b>	3				
		3,66	12'	38	<b>51</b>	76	11	<b>16</b>	22	21	<b>29</b>	41	2	<b>2</b>	3				
		4,27	14'	51	<b>64</b>	102	14	<b>19</b>	29	24	<b>32</b>	48	2	<b>2</b>	3				
		4,88	16'	64	<b>83</b>	127	17	<b>22</b>	35	29	<b>38</b>	57	2	<b>2</b>	3				
38 x 184	2 x 8"	2,44	8'	13	<b>19</b>	25	5	<b>6</b>	10	19	<b>25</b>	38	2	<b>3</b>	5				
		3,05	10'	35	<b>38</b>	70	6	<b>10</b>	13	24	<b>32</b>	48	2	<b>3</b>	5				
		3,66	12'	38	<b>51</b>	76	10	<b>13</b>	21	29	<b>38</b>	57	2	<b>3</b>	5				
		4,27	14'	51	<b>64</b>	102	13	<b>16</b>	25	33	<b>44</b>	67	2	<b>3</b>	5				
		4,88	16'	64	<b>83</b>	127	14	<b>19</b>	29	38	<b>51</b>	76	2	<b>3</b>	5				
38 x 235	2 x 10"	2,44	8'	13	<b>19</b>	25	3	<b>5</b>	6	24	<b>32</b>	48	3	<b>5</b>	6				
		3,05	10'	35	<b>38</b>	70	6	<b>6</b>	11	30	<b>38</b>	60	3	<b>5</b>	6				
		3,66	12'	38	<b>51</b>	76	10	<b>11</b>	19	35	<b>48</b>	70	3	<b>5</b>	6				
		4,27	14'	51	<b>64</b>	102	11	<b>13</b>	22	41	<b>54</b>	83	3	<b>5</b>	6				
		4,88	16'	64	<b>83</b>	127	13	<b>16</b>	25	48	<b>64</b>	95	3	<b>5</b>	6				
38 x 286	2 x 12"	2,44	8'	13	<b>19</b>	25	2	<b>3</b>	5	28	<b>38</b>	57	3	<b>6</b>	9				
		3,05	10'	35	<b>38</b>	70	5	<b>5</b>	10	35	<b>48</b>	44	3	<b>6</b>	9				
		3,66	12'	38	<b>51</b>	76	7	<b>9</b>	14	43	<b>57</b>	86	3	<b>6</b>	9				
		4,27	14'	51	<b>64</b>	102	9	<b>9</b>	19	49	<b>67</b>	98	3	<b>6</b>	9				
		4,88	16'	64	<b>83</b>	127	11	<b>13</b>	22	57	<b>76</b>	114	3	<b>6</b>	9				

Please note that the above measurements are converted from US inches and are approximations. In case of disagreement, measurements according to NGR (National Grading Rule) in inches are valid. The above measurements have been converted into metric units according to the American Softwood Lumber Standard PS20-15 regulations.



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Wood properties	Select Structural	No. 1	No. 2	No. 3
Wane	1/4 thickness and 1/4 width full length or equivalent on each face. May not exceed 1/2 the thickness or 1/3 the width for 1/4 of the length.		1/3 thickness and 1/3 width full length or equivalent on each face. May not exceed 2/3 the thickness or 1/2 the width for 1/4 of the length.	1/2 thickness and 1/2 width full length or equivalent on each face. May not exceed 7/8 the thickness or 3/4 the width for 1/4 of the length.
Slope of grain	1:12	1:10	1:8	1:4
Splits Shakes Checks	Surface checks allowed, if through at ends, considered as splits. Splits can be as long as the nominal width of the piece. Measure both faces and average. Surface shakes up to 610 mm long. Through shake away from end is not allowed.		Surface checks allowed. Splits (& shakes at ends) may be 1,5 x the nominal width of piece. Shakes away from end may be through for 610 mm. Surface shakes may be 915 mm long or 1/4 the length.	Surface checks and shakes allowed. If through at ends or edges limit to 1/6 the length (incl. splits). All others 1/3 the length. Measure both faces and average.
Stain	Not limited.			
Sawcuts	Not allowed.		Limited to 1/2 the equivalent edge knot displacement if wide face to edge. Limited to 1/2 the allowable edge knot size on worst face if wide face to wide face.	
Unsound wood	Not allowed.		Limited to 1/12 the width and 51 mm in length, on any face or combination of faces.	Limited to spots or streaks 1/3 the cross section at any point along length. Must not destroy nailing edge.
Compression wood	Prohibited if in readily identifiable and damaging form. Damaging form = excessive warp, break, etc.			
Timber breaks	Not allowed.			Limited to the allowable knot hole size on the worst face.
Skips	"Hit and miss" allowed. Maximum depth 1,6mm in maximum 10% of pieces.		"Hit and miss" with max 1,6 mm depth. In addition 5% of pieces may be "Hit or miss", or heavy skip max depth 3,2 mm on max 610 mm length.	"Hit or miss" with max 1,6 mm depth. In addition 10% of pieces may have heavy skips max depth 3,2 mm.
Machine bite, offset	Maximum 1,6 mm.		Maximum 3,2 mm.	
Rounding of edge	Maximum 3,2 mm.			
Moisture content	Maximum 19 %. Any lumber found to have over 19% of moisture content will be rejected as non-conforming.			
DET allowance	DET (Double End Trim) lumber is allowed to be up to 76 mm longer than the specified length, but not shorter.			
PET allowance	PET (Precision End Trim) lumber is allowed to be 1,6 mm longer or shorter than the specified length on 20% of the pieces. The rest 80% have to be exact.			

Dimension lumber nominal sizes in inches	Dimension lumber nominal sizes metric	Dimension lumber actual sizes in inches	Dimension lumber actual sizes metric
2 x 4"	50,8 x 101,6 mm	1-1/2 x 3-1/2"	38,1 x 88,9 mm
2 x 6"	50,8 x 152,4 mm	1-1/2 x 5-1/2"	38,1 x 139,7 mm
2 x 8"	50,8 x 203,2 mm	1-1/2 x 7-1/4"	38,1 x 184,2 mm
2 x 10"	50,8 x 254,0 mm	1-1/2 x 9-1/4"	38,1 x 235,0 mm
2 x 12"	50,8 x 304,8 mm	1-1/2 x 11-1/4"	38,1 x 285,8 mm

- 1) During routine mill inspection, lumber found to have 7,5% or above of below grade, excess moisture content or incorrect species will be held for re-inspection. Illegible stamp allowance is 10%.
- 2) Non-conforming inspection results can trigger mandatory follow up inspections that may be considered non-routine.
- 3) All TP stamped lumber shall be reported as shipped volume. Also, any non-stamped lumber, regardless of size, which is shipped to the US or US territories shall be reported.
- 4) It is only allowed to use TP approved stamps on material shipped to the U.S.
- 5) All lumber should be manufactured to the correct dimensions in inches. The tolerance for under-size is -0.0 mm. Over-sized lumber may be manufactured up to the next size.

If you have any questions, please do not hesitate to contact your local TP representative.