

## GR04 Sawn timber for building and construction

**Prime** PRIM  
**Select** SEL  
**Sound** SUD  
**Merchantable** MERCH

### Purpose

For grading sawn hardwood timber for framing in building and construction. Both rough sawn and gauged (size matched) timber are included.

### Sawing tolerance

All timber shall be well and truly sawn to specified nominal dimensions and with square trimmed ends. Marking out of defects without trimming is not permitted.

The following tolerance to nominal sizes at time of sawing shall apply:

Thickness and width    up to 75 mm nominal, ± 5 mm  
    above 75 mm nominal, ± 10 mm

Where timber of close dimensional tolerance is produced by machine gauging (planing) after sawing a planing tolerance of ± 3 mm shall be allowed.

### Grade distinctions

There are four grades allocated for GR04.

Timber may be ordered as a particular species and grade e.g. "Mora Select Grade" or by type of forest product and grade e.g. "GR04 Prime Grade".

Sawn timber will normally be graded and supplied green; but it may be supplied in "shipping dry" condition by arrangement between the customer and supplier.

Sawn timber meeting this specification shall not contain defects beyond the limits given in the table below.

Grading factors	Prime	Select	Sound	Merchantable
Length	Greater than 2.4m with an interval of 0.1m		Greater than 0.5m with an interval of 0.1m	
Knots, loose, decayed or hollow	Not permitted	Not permitted	Not permitted	One quarter width of face to 75 mm diameter maximum
Knots, sound, tight and inter-grown	Not permitted	25 mm diameter maximum and scattered	50mm diameter or 1/3 width of the face whichever is less.	75 mm diameter or ½ width of face whichever is less.

Grading factors	Prime	Select	Sound	Merchantable
End Shakes	None	A quarter width of face in length and at one end only	Half width of face in length at one end only	Width of face in length at one end only
Face shakes	None	Showing on one face only and length not more than 1/3 of the width of that face	Showing on one face only and not more than 60 cm in total length.	Half the length of piece on one face and not more than ¼ maximum width. Must not penetrate through opposite or adjacent faces for more than 60 cm
Sapwood, sound not treated by preservative	Permitted only when the species is in durability Class 1A	Permitted only when the species is of durability Class 1 or 1A.	A perimeter measurement of 50 mm or 20% whichever is greater.	A perimeter measurement of 25%.
Sapwood, treated by an approved preservation process	No limit	No limit	No limit	No limit
Sloping grain	None, only local deviations	None, only local deviations	50 - 60 %	> 60 %
Bow	Not permitted	Not permitted	40 mm in 5 m length	60 mm in 5 m length
Spring	Not permitted	Not permitted	20 mm in 5 m length	30 mm in 5 m length
Twist	Not permitted	Not permitted	Slight	Up to 5 mm per 5 m length
Holes, bark and gum pockets	None	5 mm wide and 50 mm long in one face only	10 mm wide and 75 mm long one face only	25 mm wide and 150 mm long
Compression failure	Not permitted	Not permitted	Not permitted	Slight and Occasional
Brittle heart and unsound heart	Not permitted	Not permitted	Not permitted	Not permitted
Sound black heart and heart stain	Slight	No limit	No limit	No limit

<b>Grading factors</b>	<b>Prime</b>	<b>Select</b>	<b>Sound</b>	<b>Merchantable</b>
Insect and grub holes 3 mm diameter and above	None	Scattered and not more than equivalent of 1 per metre of length	Scattered and not more than equivalent of 2 per metre of length	Not clustered but up to 4 per metre of length
Pinhole (ambrosia) borer holes	None	None	Slight on one face only	Moderate but scattered
Seasoning checks	None	Slight	Moderate	Up to 30 mm per metre of length
Wane	None	20 mm perimeter per metre of length maximum	40 mm perimeter per metre of length maximum	60 mm perimeter per metre of length maximum
Want	Not permitted	Not permitted	Not permitted	Not permitted

## GR05 Sawn timber for dressing and furniture manufacture

**Prime** **PRIM**  
**Standard** **STD**  
**Factory-suited** **F.S.**  
**Mill-run** **MR**

### Purpose

For grading sawn timber up to 75 mm in thickness and not more than 250 cm<sup>2</sup> end cross-section, intended for dressing and furniture manufacturer.

### Unseasoned

Timber green off saw, partially seasoned or shipping dry will be regarded as unseasoned. Where a particular time in stack is specified by the customer this shall be verified as far as possible by the grader but no guarantee as to actual moisture content can be given.

### Seasoned

Seasoned timber in these rules means timber seasoned in air, kiln or a combination of methods to moisture content below 18%. This shall be verified as far as possible by the grader and on request a certificate covering sampling for moisture content of a shipment can be given.

### Dimensions and tolerances

All timber shall be well sawn to specified dimensions and with square-trimmed ends. The following allowances to the nominal sizes need to be ascertained, at the time of grading, unless specially agreed between the customer and supplier.

Thickness	up to 75 mm nominal thickness the allowance shall be $\pm 5$ mm for 75 mm nominal and thicker the allowance shall be $\pm 10$ mm
Width	up to 75 mm nominal the allowance shall be $\pm 10$ mm
Length	trimmed lengths shall measure 0 to 100 mm longer than nominal for Prime and Standard grades  there shall be additional 25 mm allowance to the length specified by the customer. The same allowance applies to Mill-Run grade.

Grading factors	Factory-suited	Prime	Standard	Mill-Run
Purpose	A quality equal or superior to prime but cut to size by arrangement with the customer. For use in furniture, parquet etc.	For the highest quality work	Very good quality for normal use in building, joinery and utility furniture construction	Moderate to low quality for normal use in building, joinery and utility furniture in local markets
Length	Customer specified	Minimum of 1.8 m	Minimum of 1.8 m	Length greater than 0.6 m
Knots, dead, loose or decayed	Not permitted	Not permitted	25 mm diameter maximum	Permitted
Knots, sound, tight inter-grown	25 mm diameter 1 per piece in 10% of the lot.	25 mm diameter 1 per 2 metres in 20% of lot	75 mm diameter maximum	Permitted
Edge Shakes	Not permitted	At one end only up to 75 mm in length	At one end only 75 mm or half width of face	Permitted at both ends only if the aggregate length does not exceed 1/5 of the length
Face Shakes	Not permitted	On worse face only 150 mm total length per piece in 10% of lot	On worse face only 900 mm long total length by 3 mm wide	On worse face only Up to 75 mm per metre of length of the piece in up to 25% of lot
Sapwood, sound, not <i>Lyctus</i> susceptible	No limit unless specified by customer. In many timbers sapwood is not strongly differentiated in colour from heartwood and is not <i>Lyctus</i> susceptible. However in some species the sapwood is of different colour and may or may not be desired depending on species. A customer may specify the timber free of sap in which case it will be limited as for sapwood, <i>Lyctus</i> susceptible. Sapwood may be preserved by an approved process, as defined in the Timber Marketing Act in which case it will be of natural colour and not <i>Lyctus</i> susceptible.			
Sapwood, sound <i>Lyctus</i> susceptible	18 mm, one corner only	25 mm perimeter	100 mm perimeter	150 mm perimeter
Sloping grain	Up to 15%	Up to 15%	Up to 15%	Up to 20%
Bow	Not permitted	10 mm per metre length	20 mm per metre length	Up to 40 mm per metre length
Spring	Not permitted	5 mm per metre of length evenly distributed	5 mm per metre of length evenly distributed	Up to 25 mm per metre of length evenly distributed
Twist	Not permitted	Slight in 10% of lot	Slight in 15% of lot	Slight in 20% of lot

<b>Grading factors</b>	<b>Factory-suited</b>	<b>Prime</b>	<b>Standard</b>	<b>Mill-Run</b>
Pin holes ( <i>Ambrosia</i> ) borer	Occasional on one face only in 10% of lot	3 mm diameter Maximum 3 in 5 metres length in 10% of lot	3 mm diameter 3 per metre of length	Up to 4 mm diameter Up to 5 per metre of length
Grubholes	Not permitted	1 per 2 m in 10% of lot	Average of 1 per 2 m length	Average of 1 per 1.5 m length
Check-seasoning	Slight on one face only	Slight on one face only	Slight on one face only	One face or one side edge only
Brittle heart	Not permitted	Not permitted	Not permitted	One face only where sound, up to 75 mm long
Log stain and incipient decay	Not permitted	Not permitted	Not permitted	Slight and occasional
Holes, bark pockets	Not permitted	To be classified as loose knots	To be classified as loose knots	To be classified as loose knots

## GR06 Dressed products from seasoned timber

Prime Standard PRIM STD

### Purpose

For grading dressed products from seasoned hardwoods.

The Prime grade is intended for finishing and construction work of the highest quality. Standard grade is intended for general construction and finishing purposes where sound lumber well milled but of lesser visual quality than grade A is adequate.

The following products are included under these rules.

- Tongue and groove siding
- Tongue and groove flooring
- Secret nail flooring
- Channel lining
- V-joint lining
- Spring and rebate siding
- Dressed boards, square edged.

Standard profiles are given for these products in figure 1.

### Moisture Content

All dressed products meeting these rules shall have a moisture content not less than 10% and not more than 15% at the time of dressing. The oven drying method shall be used to determine moisture content.

### Quality of Dressing

All products shall be of sound wood, well milled to a smooth surface and free from defects on the face other than those described for the particular product and grade.

### Tolerance

Tolerance in thickness and width at the time of milling shall be plus 1 mm minus 0 mm. Tongue and groove shall match as described and each product shall conform to the standard profiles.

### Branding

All dressed products shall be indelibly marked on the back by the grader to show.

- the grader's registered number.
- the grade of the dressed item PRIM or STD and the type reference number of this forest product.

In addition, the registered brand or name of the manufacturer shall be applied.

### End trimming

All dressed products shall be trimmed square at the ends. Marking out of defects without trimming is not allowed.

### Species

Dressed products of any hardwood species may be graded under these rules and may be supplied either as lots comprising a single nominated species or in lots comprising several species by arrangement between customer and supplier.

### Grade distinctions

The limits of defects affecting appearance and performance of the two grades are given below. Limits refer to defects appearing on the better face. Any imperfections may appear on the back of the piece providing they do not significantly affect the strength or fixing of the products. No defect is allowed at the edges where it would result in fitting problem.

Grading factors	Prime	Standard
Knots, sound, tight and inter-grown	¼ face width or 25 mm diameter maximum	½ face width or 50 mm diameter maximum
Knots, dead, decayed and knot holes	Not permitted	12 mm diameter 1 per 4 meters length
Pin holes ( <i>Ambrosia</i> borer)	4 per 5 metres of length	Occasional, well scattered
Unsound heart and pith	Not permitted	Not permitted
Gum and bark pockets	Not permitted	12 mm wide x 75 mm long and tight 1 in 4 meters of length
Wane	Not permitted	Not permitted
Bow	16 mm in a metre length	18 mm in a metre length
Spring	5 mm in a metre length and evenly distributed	8 mm in a metre length, evenly distributed
Shake	Not permitted	Occasional and less than 150 mm long
Compression failure	Slight	Slight
Sound sapwood not treated by an approved preservation process not immune to <i>Lyctus</i>	Not permitted (see note)	25 mm width on face
Sapwood – sound meaning treated by an approved preservation process or naturally immune to <i>Lyctus</i>	Not limited	Not limited

Grading factors	Prime	Standard
Seasoning checks	50 mm long not more than 1 in a metre	Slight well scattered
Mismatch	Not permitted	0.5 mm maximum in 10% of parcel
Skip (hit and miss)	Not permitted	Not greater than 80 mm long and 2 mm deep in 5 metre length
Broken, missing & short tongues	Not permitted	Maximum 110 mm long per metre in 10% of parcel
Broken & missing groove	Not permitted	Not permitted
Kick out	Not permitted	Not permitted

**Note:** In many Guyana hardwoods the sapwood is similar in colour and texture to heartwood and is not Lyctus borer susceptible. In these timbers sound sapwood would be admitted without limit under these rules. Where sapwood is distinctly different in colour it may be desired for its decorative effect e.g. Wamara, in other cases it may not be desired e.g. Purpleheart. In Prime grade a customer may specify by arrangement that the timber be sap free. Where sapwood has been treated by an approved preservation process as defined in the Timber Marketing Act then it will be of natural colour and perfectly sound.

### Standard profiles for GR06

Tongue and groove siding



Tongue and groove flooring



Secret nail flooring



Channel lining



V-joint lining



Spring and rebate siding

