



®

GRADER'S POCKET GUIDE FOR FINISH and BOARDS

SOUTHERN PINE INSPECTION BUREAU
PENSACOLA, FLORIDA

	C	D	No. 2	No. 3
Torn Grain	1/16" Deep	1/8" Deep	No Limit	No Limit
Raised Grain	1/32"	1/16"	No Limit	No Limit
Loosened Grain	1/32" Separation	Over 1/8" Separation	Over 1/8" Separation	No Limit
Machine Bite	1/64" Deep	1/32" Deep	1/16" Deep	1/8" Deep
Machine Gouge	1/64" Deep	1/32" Deep	No Limit	No Limit
Machine Offset	1/64" Offset	1/32" Offset	1/16" Offset	1/8" Offset
Chip Marks	1/32" Occ. Piece 1/16" deep	1/16" Deep	No Limit	No Limit
Knife Marks	Perfectly Smooth to Touch	Visible - No Unevenness - Touch	No Limit	No Limit
Mismatch	Trace	1/64"	1/32"	1/16"
Machine Burn	1-1/2" Wide x Width	3" Wide x Width	No Limit	No Limit
Wavy Dressing	None	None	1/32"	1/16"
Moisture Content	KD-12% (10% pes up to 15%) AD-15%	KD12% (10% pes up to 15%) AD-15%	KD-19% & 15% AD-19%	KD-19% & 15% AD-19%
Warp	Medium	Heavy	Heavy +25%	50% More than No. 2

9/97

SPIB GRADING RULES FOR FINISH AND BOARDS				
DEFECTS	C&BTR	D	NO. 2	NO. 3
Compression Wood	None	Not Limited	Not Limited	Not Limited
Firm Red Heart	25% Face Not Limited if Otherwise B&B	Not Limited	Not Limited	Not Limited
Decay	None	None	Heart Center Only 1/2" Wide by 1/4 Length	Allowed if Suitable for Nailing Throughout
Holes	1/16" Limited to 6 per/ft	1/16" Limited to 12 per/ft	1/4" Not Limited One 1" Per Piece	1-1/2" in 1x4 and 1x6 1/4 W in 1x8 1x10 1x12
Knots	<p>Sound or Firm and Tight 3/4"-All Widths 1 - 1-1/2" in 6" Width 2 - 1-1/2" in 8, 10 & 12"</p> <p>All Knots in Any 4 Ft Must Not Exceed Twice Diameter of Maximum Knot Allowed</p>	<p>Decayed 3/4"-All Widths if Smooth and Even with surface</p> <p>Sound, Firm, Encased & Pith 3/4" - 1x4 1-1/2" - 1x6 2" - 1x8, 1x10 & 1x12</p> <p>All Knots Must Be Tight-All Knots in Any 4 Ft Must Not Exceed Twice Diameter of Maximum Knot Allowed</p>	<p>No.1 Knot Size*</p> <p>1x4 - 2-1/2" 1x6 - 3" 1x8 - 3-1/2" 1x10 - 4" 1x12 - 4-1/2"</p> <p>Decayed and Hollow Knots Limited to No. 1 Sizes - Knot Holes & Loose Knots Same as Holes</p>	<p>Not Limited In-Size Except Must be Able to Handle Without Breaking</p> <p>Loose Knots and Through Openings in Hollow Knots Limited Same as Holes</p>
Pith	3/4 of Square Inch	1/6 Length	Not Limited	Not Limited
Stain	15% Face - Medium	25% Face - Medium	Not Limited if Medium	Not Limited if Medium
Pitch	Light - Medium if B&B	Medium, if C - Heavy (1/4W x 1/2L)	Not Limited	Not Limited
Pitch Streak	1/6 Width x 1/3 Length	1/6 Width x 1/3 Length If C-1/4 Width x 1/2 Length	Not Limited Worm-Eaten Area=Knot Size	Not Limited
Pitch Pocket	1/4" x 2" All Widths (Small) 1-3/8" x 4" in 1x6 (Medium) 2-3/8" x 4" in 1x8, 1x10 and 1x12	All Widths 3/8" x 4" (Med) 1x6 - 1 Large (4 sq") 1x8, 10, 12 - 2 Large (4 sq") If C: Through Pocket 3/8x4"	Not Limited	Not Limited
Shakes	1/32" Wide by Width of Piece - None Through	1/32" Wide - None Through	1/4 Length if Close Fitting	1/2 Length if Close Fitting
Skips	Face and Edge 1/64" for 6" or Equivalent	1/32" on 10% Face 1/16" on Edge (Full Length) If C - 1/32" Scant in Width for Each Inch of Width	1/32" on 25% Face 1/16" on Edge (Full Length) 10% of Pieces up to 1/8" Scant in Width	1/16" Full Length 1/8" on 10% of Pieces 1/4" in Width if Not Over 2 Ft Long
Split	Width of Piece	Twice Width But Cannot Exceed 1/6 Length	1/4 Length if Close Fitting	1/2 Length if Close Fitting
Checks	Surface - 1/32" x 10" Through - 1/32" x Width of Piece	Surface - 1/16" x 20" Through - 1/32" x 10" If C - Through 1/16" x 20"	Through - 1/4 Length if Close Fitting	If Through 1/2 Length
Wane	Face: 1/8" Deep x 1/2" Wide Reverse Side 1/4" Deep x 1/8 Width x 1/3 Length	Face: 1/4" Deep x 1/8 Width x 1/3 Length - Reverse: 1/2" Deep x 1/4 Width - Not Exceed 2" Wide	1/4 Width or 2" Wide - 1/8" of Wood on Edge - Sharp Edge for 8" on Occasional Piece	Face: 1/3 Width Reverse 3/4 Width Sharp Edge