

accoya®



COLOR

Rough Sawn & Deckboard Grading Specifications

Grade & Definitions for Accoya® Color
North America | Version 1

GRADING

Accoya Color Rough Sawn

Grading takes place across 3 zones



Layer of Typical Rough Sawn Boards



GRADING

Accoya Color Deckboards

Grading takes place across 3 zones



Layers of Typical Color Deckboards



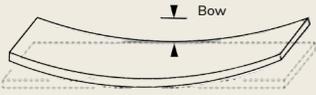
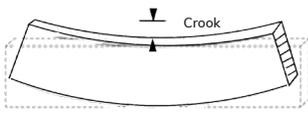
GRADING

Accoya Color Grading Rules

Accoya Color Rough Sawn - these boards are skimmed, generally on sapwood face for Color quality check. This is defined as the top face. These grading rules apply to the boards as delivered and visible defects in that delivered form. The grading rules do not apply to boards which have been further processed by the manufacturer or any further step.

Accoya Color Deckboards - the grading rules apply to boards supplied as profiled to the finished deck board by manufacturers, Accsys, and of those boards in the delivered state. As with all wood products, supplemental defects might develop in service and are outside the scope of this Grading specification.

Accoya Color Grading Table

	Graded by the better face	Better Face	Back Face														
Color Defects	At the end of the board	Maximum 24 inches patch total length	Unlimited														
	In the middle of the board	Up to 3 patches allowed Maximum 24 inches total length	Unlimited														
	Along the edge of the board	Maximum 1 inches wide	Unlimited														
	Between boards	Variable shades of grey permitted	Unlimited														
	Total surface area	Maximum no color uptake on 15% of surface area. Brown staining (will machine out)	Unlimited														
Wood Defects	Up to 3 of the following defects or equivalent	Knot (pin)	1/2 inches diameter or less	Unlimited													
		Bark or resin pocket	5/16 inches wide, 2 inches long or equivalent	Unlimited													
		Resin streaks	A set of three up to 5/16 inches wide, 4 inches long or equivalent, E.g. equivalent could be 6 qty 5/16 inches wide and 2 inches long	Unlimited													
	Surface checks	Three up to 1/16" wide, 10" long or equivalent	Unlimited														
	Splits and end splits	Short split, up to width of board and not to exceed 8"	n/a														
	Wane	Not allowed	Unlimited														
	Bow	<table border="1"> <thead> <tr> <th colspan="2">Allowable Limit</th> </tr> </thead> <tbody> <tr> <td>8 ft</td> <td>1.18 in</td> </tr> <tr> <td>12ft</td> <td>2.56 in</td> </tr> <tr> <td>14ft</td> <td>3.54 in</td> </tr> <tr> <td>16ft</td> <td>4.72 in</td> </tr> </tbody> </table>	Allowable Limit		8 ft	1.18 in	12ft	2.56 in	14ft	3.54 in	16ft	4.72 in					
	Allowable Limit																
	8 ft	1.18 in															
	12ft	2.56 in															
	14ft	3.54 in															
	16ft	4.72 in															
	Crook	<table border="1"> <thead> <tr> <th colspan="2">6 in</th> </tr> </thead> <tbody> <tr> <td>8 ft</td> <td>0.2 in</td> </tr> <tr> <td>12ft</td> <td>0.39 in</td> </tr> <tr> <td>14ft</td> <td>0.59 in</td> </tr> <tr> <td>16ft</td> <td>0.79 in</td> </tr> </tbody> </table>	6 in		8 ft	0.2 in	12ft	0.39 in	14ft	0.59 in	16ft	0.79 in					
6 in																	
8 ft	0.2 in																
12ft	0.39 in																
14ft	0.59 in																
16ft	0.79 in																
Allowed twist per 3.93 in width	<table border="1"> <thead> <tr> <th></th> <th>4/4 in</th> <th>5/4 in</th> </tr> </thead> <tbody> <tr> <td>8 ft</td> <td>0.39 in</td> <td>0.39 in</td> </tr> <tr> <td>12ft</td> <td>0.79 in</td> <td>0.79 in</td> </tr> <tr> <td>14ft</td> <td>0.79 in</td> <td>0.79 in</td> </tr> <tr> <td>16ft</td> <td>0.79 in</td> <td>0.79 in</td> </tr> </tbody> </table>		4/4 in	5/4 in	8 ft	0.39 in	0.39 in	12ft	0.79 in	0.79 in	14ft	0.79 in	0.79 in	16ft	0.79 in	0.79 in	
	4/4 in	5/4 in															
8 ft	0.39 in	0.39 in															
12ft	0.79 in	0.79 in															
14ft	0.79 in	0.79 in															
16ft	0.79 in	0.79 in															
Allowed cupping	<table border="1"> <thead> <tr> <th>Width (in)</th> <th>Allowed cupping (in)</th> </tr> </thead> <tbody> <tr> <td>5 in</td> <td>0.08 in</td> </tr> <tr> <td>6 in</td> <td>0.08 in</td> </tr> </tbody> </table>	Width (in)	Allowed cupping (in)	5 in	0.08 in	6 in	0.08 in										
Width (in)	Allowed cupping (in)																
5 in	0.08 in																
6 in	0.08 in																
Tolerances	Thickness - 0.08 in	Width - 0.04 in															

Up to 5% of boards off grade shall be deemed acceptable.



Get in touch

Please email us with enquiries and the responsible sales manager will follow up promptly:

sales@accsysplc.com

North America

Accsys Sales Office
Accoya USA
Building 470
200 S Wilcox Dr
Kingsport, TN 37660-5174

© Accsys Technologies, the trading name of Titan Wood Limited, 2023. Accoya® and the Trimarque Device are registered trademarks owned by Titan Wood Limited, a wholly owned subsidiary of Accsys Technologies PLC, and may not be used or reproduced without written permission.

Accoya® Color should always be installed and used in accordance with the written instructions and guidelines of Accsys Technologies and/or its agents (available upon request). Accsys Technologies accepts no liability for any defect, damage or loss that may occur where such written instructions and guidelines are not adhered to.

The information contained within this document has not been independently verified, and no warranty (express or implied) or representation is given in respect of the same, including without limitation as to its accuracy, completeness or fitness for any purpose. Accsys Technologies and its affiliates, officers, employees or advisers expressly disclaim any liability to the fullest extent permitted by law for any loss or damage whatsoever arising in respect of



www.accoya.com

Retain this grading specification guide for future use.
Visit accoya.com for the most up-to-date requirements.