Faces Graded = All faces and both ends - WORST CHARACTERISTIC DETERMINES THE GRADE!

**Purpose Intended: Strength** 

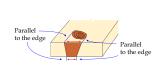
Grade Name	Construction - Para. 122b				Standard - Para. 122c				Utility - Para. 122d				Economy - Para. 122e
Shake/Checks	not through - up to 2' long through - not permitted				through - up to 2' long not through - 3' up to 1/4 length max 3/4 thickness if continuous through wide face				through - several 1/3 length not through - full length 3 face shake - max 1/6 length				no limit
Skips (S4S stock only)					Hit or Miss = 1/16" Deep more than 4' long or				Full Length skip				1/4" scant F.L.
Splits	Surfaced area = 1/2 Width x 2" Long or equiv Width of piece				One Heavy Skip - 1/8" Deep x 2' long 1 1/2 x width				1/8" Deep - on face or edge, not both 1/6 length				allowed on both W X T 1/3 length
•	1 in 6				1 1/2 X Widui				1 in 4				no limit
Slope of Grain (actual size)	, <del>-</del>				1								
Wane (based on actual size)	1/4 Thickness x 1/4 Width F.L. or equiv Max 1/2 Thickness x Max 1/3 Width				1/3T x 1/3W F.L. or equiv				1/2T x 1/2W F.L. or equiv Max 7/8 Thickness x Max 3/4 Width				3/4 across width full length.
don't forget to check width	1-1/2" Thick = min 3/4" good wood				Max 2/3T x Max 1/2W up to 1/4L 1-1/2" Thick = min 1/2" good wood				1-1/2" Thick = min 3/16" good wood				across face 1/4"scant for 1/2 width, 1/3 length
									_				, •
	<b>3-1/2" Width =</b> 2 5/16" good wood				<b>3-1/2" Width =</b> 1 3/4" good wood				<b>3-1/2" Width =</b> 7/8" good wood				If through equiv to holes
Pin Holes	See Knot Table (48 pin holes per inch of hole permitted) - WORST WIDE FACE ONLY (averaged over full length of the piece)												no limit
Grub/Teredo Holes	See Knot Table (12 holes per inch of hole permitted) - WORST WIDE FACE ONLY (averaged over the full length of the piece) no limit												
White Specks	Not Permitted				1/3 volume				no limit (100% permitted)				no limit
Honeycomb					1/6 actual width Full Length				no limit (100% permitted)				no limit
Peck (measured between lines parallel to actual width) Unsound Wood					1/6 actual width Full Length  Maximum area - 1/12 Width x 2" Long				max 1/3 cross section Full Length or 2/3 cross section on one face				3/4 cross section full length
must not destroy nailing edge					or equivalent smaller spots				through portion - maximum 1/6 length				
Waste					Not Per				mitted				25% if 9' or Longer minimum 2' from end
KNOT SIZES PERMITTED measured between lines	Firm &	UNS NFF	Pin Holes allowed	Grubs allowed	Any	KNOT	Pin Holes allowed	Grubs allowed	Any	KNOT	Pin Holes allowed	Grubs allowed	
parallel to the edges	Tight	HOLES	every 1'	every 1'	Quality	HOLES	every 1'	every 1'	Quality	HOLES	every 1'	every 1'	
2" NOMINAL WIDTHS	3/4"	5/8"	10	2.5	1"	3/4"	18	4.5	1 1/4"	1"	48	12	3/4 cross section
3" NOMINAL WIDTHS	1 1/4"	3/4"	12	3	1 1/2"	1"	24	6	2"	1 1/4"	60	15	
4" NOMINAL WIDTHS	1 1/2"	1"	16	4	2"	1 1/4"	30	7.5	2 1/2"	1 1/2"	72	18	
	1 Knot Hole per 3' or equivalent smaller 1 Knot Hole per 2' or equivalent smaller 1 Knot Hole per 1' or equivalent smaller												
Spike Knots	equ	ivalent size	to round k	nots	equivalent size to round knots				equivalent size to round knots				equivalent size to round knots
· · · · · · · · · · · · · · · · · · ·													· · · · · · · · · · · · · · · · · · ·

Round and Oval Knot Size

3-Face Knots

equivalent size to round knots **Knots in Squares** 

**Knot Holes** 



· Measure knots as the width between imaginary lines running parallel to the edges.

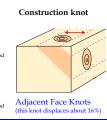
· Average the size on both faces.

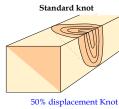
· Spike knot measurements must be converted to an equivalent round knot size.

Spike Knots

Fig. 2

Fig. 1 Fig. 2





and oval knots and each grade limits the size.

Each grade limits holes to the equivalent of one maximum sized hole for a given lineal measurement.

Knot holes may be concentrated.

Knot holes are measured the same as round

Fig. 1