

The Accoya logo features the brand name in a white sans-serif font on a green rectangular background, followed by a white stylized tree icon with a registered trademark symbol.

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



End of
board

Middle of board

End of
board

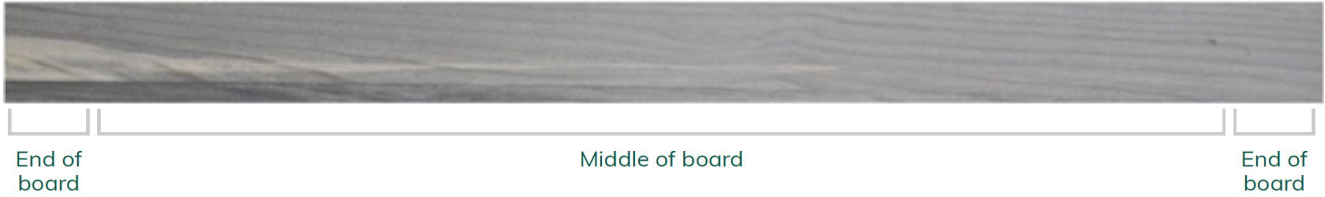
Layer of Typical Rough Sawn Boards



GRADING

Accoya Color Deckboards

Grading takes place across 3 zones



Layers of Typical Color Deckboards



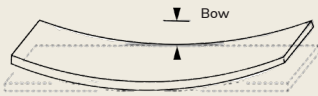
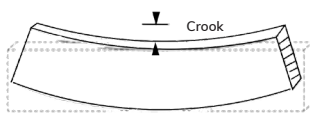
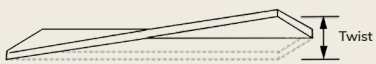
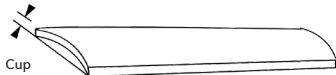
GRADING

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

Color Defects	Graded by the better face	Better Face	Back Face														
	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><tr><th colspan="2">Allowable Limit</th></tr><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></table> 	Allowable Limit		8 ft	1.18 in	12ft	2.56 in	14ft	3.54 in	16ft	4.72 in				
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	8 ft	1.18 in															
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Crook	<table><tr><th colspan="2">6 in</th></tr><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></table> 	6 in		8 ft	0.2 in	12ft	0.39 in	14ft	0.59 in	16ft	0.79 in						
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Allowed twist per 3.93 in width	<table><tr><th></th><th>4/4 in</th><th>5/4 in</th></tr><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></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	
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14ft	0.79 in	0.79 in															
16ft	0.79 in	0.79 in															
Allowed cupping	<table><tr><th>Width (in)</th><th>Allowed cupping (in)</th></tr><tr><td>5 in</td><td>0.08 in</td></tr><tr><td>6 in</td><td>0.08 in</td></tr></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:

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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.

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