

	Visual inspection requirements for machine strength graded material (C24M)
Knots	No limitation.
End splits <sup>2</sup>	End splits smaller than half of thickness are not accounted. End splits must not be longer than ¼ of material length.
Traversing fissures	Only end splits, that are not longer than width of the material.
Maximum curvature for 2 meters	Bow: 10 mm. Spring: 8 mm. Twist: 2 mm / 25 mm in width. Cup: No limitation.
Wane and mechanical damage	Wane must not be longer than 1/3 of material length, mechanical damage is considered as wane.
Resin pockets	No limitation.
Bark pockets	No limitation.
Discolouration	Blue stain and rot are not allowed.
Insect damage	Not allowed.
Moisture content	18 ± 2 %
Surface quality	<p><b>Unplaned surface:</b> according to tolerances described in standard            Thickness ± 1 mm            Width ± 1 mm            Length -0/+1 mm</p> <p><b>Hit and miss</b> is allowed, if measurements remain within the limits permitted by the standard.</p>
	<p><b>5% deviation from given requirements is allowed.</b></p> <p><sup>2</sup> <b>Length of fissures is related to moisture content, therefore set rules only apply at the time when material is being graded.</b></p>