

accoya 

COLOR

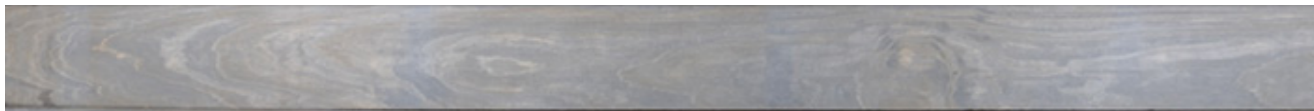
Grading guide

Grading rules for Accoya® Color
English | Version 1

GRADING

Accoya Color - Rough sawn

Grading takes place across 3 zones on one face.
The reverse side of the boards may show less well coloured areas.



Example of one face of the boards.



GRADING

Accoya Color - Machined

Layers of typical colour when machined.




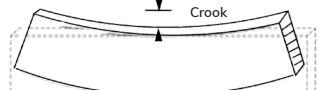
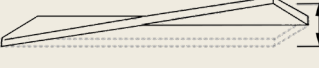
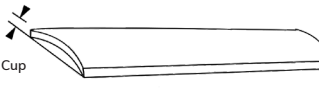
GRADING

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 manufactured by 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														
Colour Defects	At the end of the board	Maximum 600mm patch total length	Unlimited														
	In the middle of the board	Up to 3 patches allowed	Unlimited														
	Along the edge of the board	Maximum 25mm wide	Unlimited														
	Between boards	Variable shades of grey permitted	Unlimited														
	Total surface area	Maximum no colour 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)	12mm diameter or less	Unlimited													
		Bark or resin pocket	8mm wide, 50mm long or equivalent	Unlimited													
		Resin streaks	A set of three up to 8mm wide, 100mm long or equivalent, E.g. equivalent could be 6 qty 8 mm wide and 100mm long	Unlimited													
	Surface checks	Three up to 1.6mm wide, 250mm long or equivalent	Unlimited														
	Splits and end splits	Short split, up to width of board and not to exceed 200mm	n/a														
	Wane	Not allowed	Unlimited														
	Bow	<table border="1"> <thead> <tr> <th colspan="2">Allowable Limit</th> </tr> </thead> <tbody> <tr> <td>2.40m</td> <td>30mm</td> </tr> <tr> <td>3.60m</td> <td>65mm</td> </tr> <tr> <td>4.20m</td> <td>90mm</td> </tr> <tr> <td>4.80m</td> <td>120mm</td> </tr> </tbody> </table>	Allowable Limit		2.40m	30mm	3.60m	65mm	4.20m	90mm	4.80m	120mm					
	Allowable Limit																
	2.40m	30mm															
	3.60m	65mm															
	4.20m	90mm															
4.80m	120mm																
Crook	<table border="1"> <thead> <tr> <th colspan="2">Allowable Limit</th> </tr> </thead> <tbody> <tr> <td>2.40m</td> <td>5mm</td> </tr> <tr> <td>3.60m</td> <td>10mm</td> </tr> <tr> <td>4.20m</td> <td>15mm</td> </tr> <tr> <td>4.80m</td> <td>20mm</td> </tr> </tbody> </table>	Allowable Limit		2.40m	5mm	3.60m	10mm	4.20m	15mm	4.80m	20mm						
Allowable Limit																	
2.40m	5mm																
3.60m	10mm																
4.20m	15mm																
4.80m	20mm																
Allowed twist per 100mm width	<table border="1"> <thead> <tr> <th></th> <th>25mm</th> <th>32mm</th> </tr> </thead> <tbody> <tr> <td>2.40m</td> <td>10mm</td> <td>10mm</td> </tr> <tr> <td>3.60m</td> <td>20mm</td> <td>20mm</td> </tr> <tr> <td>4.20m</td> <td>20mm</td> <td>20mm</td> </tr> <tr> <td>4.80m</td> <td>20mm</td> <td>20mm</td> </tr> </tbody> </table>		25mm	32mm	2.40m	10mm	10mm	3.60m	20mm	20mm	4.20m	20mm	20mm	4.80m	20mm	20mm	
	25mm	32mm															
2.40m	10mm	10mm															
3.60m	20mm	20mm															
4.20m	20mm	20mm															
4.80m	20mm	20mm															
Allowed cupping	<table border="1"> <thead> <tr> <th>Width</th> <th>cupping</th> </tr> </thead> <tbody> <tr> <td>125mm</td> <td>2mm</td> </tr> <tr> <td>150mm</td> <td>2mm</td> </tr> </tbody> </table>	Width	cupping	125mm	2mm	150mm	2mm										
Width	cupping																
125mm	2mm																
150mm	2mm																
Tolerances	Thickness - 0.5mm																

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

accoya 

COLOR



Get in touch

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

sales@accsysplc.com

Brettenham House
19 Lancaster Place
London
WC2E 7EN
+44 20 7421 4312



© Accsys Technologies, the trading name of Titan Wood Limited 2022. 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® wood 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 such information or the result of having acted upon it.