

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.



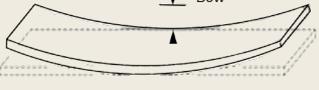
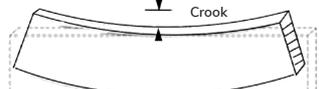
# GRADING

## 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					
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150mm	2mm																
Tolerances	Thickness - 25mm section min 23mm & 32mm section min 30mm																

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](mailto:sales@accsysplc.com)



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