

accoya®

COLOR

# Grading guide

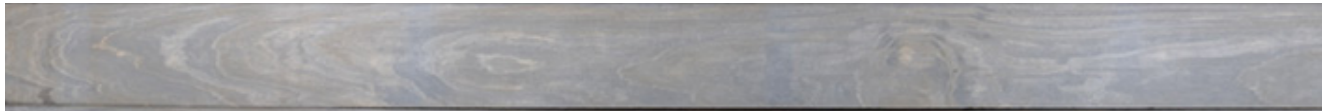
Grading rules for Accoya® Color  
English | Version 1



# 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.



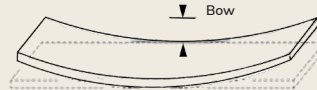
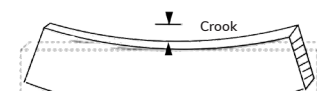

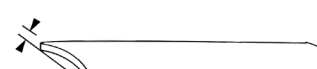
# GRADING

## 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><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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125mm	2mm																
150mm	2mm																
Tolerances		Thickness - 25mm section min 23mm & 32mm section min 30mm															

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



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### 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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