

DIN EN 14081-3:2018-12 (E)

Timber structures - Strength graded structural timber with rectangular cross section
- Part 3: Machine grading; additional requirements for factory production control
(includes Amendment A1:2018)

Contents		Page
European foreword		3
Introduction		4
1	Scope	5
2	Normative references	5
3	Terms and definitions	5
4	Requirements for the operation, calibration and maintenance of a grading machine	5
5	Additional requirements for factory production control for machine controlled systems	6
5.1	General	6
5.2	Requirements for bending strength classes with a characteristic bending strength level above 30 N/mm ² and for tension strength classes with a characteristic tension strength level above 21 N/mm ²	6
6	Additional factory production control requirements for output controlled systems	6
6.1	General	6
6.2	Grading	6
6.3	Sampling	7
6.4	Destructive testing and calculation of characteristic values	7
6.5	Batch verification	7
6.6	Recording	7
Annex A (normative) Requirements for using control planks		9
A.1	General	9
A.2	Requirements for selecting the control planks	9
A.3	Requirements for the use of control planks for internal factory production control	9
A.4	Requirements for the use of control planks for third party factory production control	11
Bibliography		14