

# ISO 13912:2017-11 (E)

## Structural timber - Machine strength grading - Basic principles

---

<b>Contents</b>		<b>Page</b>
Foreword .....		iv
Introduction .....		v
1	Scope .....	1
2	Normative references .....	1
3	Terms and definitions .....	1
4	Symbols and abbreviated terms .....	1
5	General .....	1
5.1	Machine strength-graded timber .....	1
5.2	Machine strength-grading operations .....	1
5.3	Machine strength-grading quality procedures .....	2
5.3.1	Machine-controlled system .....	2
5.3.2	Output-controlled system .....	2
6	Resource and sawn timber input requirements .....	3
6.1	General .....	3
6.2	Input requirements .....	4
6.2.1	Resource .....	4
6.2.2	Sawn timber .....	4
6.3	Control of inputs .....	4
6.4	Reprocessing of previously graded material .....	4
7	Machine strength-grading requirements .....	4
7.1	Machine checking requirements .....	4
7.2	Machine acceptance criteria .....	4
7.3	Machine strength-grading requirements .....	5
7.4	Visual grading requirements .....	5
7.4.1	General .....	5
7.4.2	Automated visual grading .....	5
8	Machine strength-graded timber structural properties .....	5
8.1	General .....	5
8.2	Initial evaluation .....	5
8.3	Daily evaluation .....	6
9	Product identification .....	6
10	Documentation .....	6
Annex A (informative) Example of a machine strength-grading timber standard .....		7
Annex B (informative) Use of the CUSUM procedure for daily evaluation .....		20
Annex C (informative) Strength-grading machine acceptance considerations .....		24
Annex D (informative) Training, supervision and oversight of grading .....		26