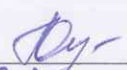


Joint Stock Company "Ust-Ilimsk Sawmill"

Approved:
Chief technologist of
JSC "Ust-Ilimsk Sawmill"


«31 07 2015 G. Okruzhnova

TECHNICAL SPECIFICATION

EDGED SOFTWOOD SAWN TIMBER

(ТУ ОП 13-0760708-96H)

Ust-Ilimsk
2015

1 General technical requirements

- 1.1 Edged sawn timber is produced from solid softwood by method of length- and cross-cutting and kiln-dried up to moisture content of 20±2%. Moisture content can be changed if agreed in the contract.
- 1.2 Sawn timber is sorted by:
- species
 - grades
 - dimensions
 - groups of lengths
- 1.3 Sawn timber under this Technical Specification is classified by width as follows:
- narrow 16-22 mm
 - medium 23-49 mm
 - thick 50 mm and more
- 1.4 Nominal dimensions are:
- 16-100 mm thickness
 - 60-250 mm width
 - 0.9-6.3 m length
- 1.5 Maximum dimension deviations from nominal ones can be:
- in thickness +7 mm, -7 mm
 - in width +15 mm, -15 mm
 - in length +50 mm, -50 mm
- 1.6 Thickness, width and length allowances shall be (+/-) 0.00 mm.
- 1.7 Sawn timber nominal lengths with 0.3 m scale (difference) shall be from 0.9 m to 6.3 m. Additionally 3.8 m and 4 m long sawn timber can be produced.
- 1.8 Nominal dimensions of sawn timber shall be applied to wood with moisture content of 20%. If wood moisture content is more or less than 20% actual sawn timber width and thickness should correspond to shrinkage size according to State Standard 6782.1-75.

2 Quality requirements

- 2.1 Allowances for biological and mechanical treatment defects of sawn timber shall be according to the table below

No.	Defect	Allowances
1	Knots – sound intergrown	Allowed without limits
2	Knots – partially intergrown and dead On face, edge, arris	Allowed without limits
3	Knots – decayed, unsound and tobacco-colored, knot holes On face, edge, arris	Allowed without limits
4	Nonthrough cracks on face and edge, including ring shakes, extended on the board end	Allowed without limits
5	Splits on face and edge, including coming out to the board end	Allowed if not longer 1/3 of a board length, and the board keeps its shape
6	End shakes including heart shakes, ring shakes, checks	Allowed without limits provided that the board is entire
7	Slope of grain, reaction wood, pockets, pith, double pith, bark pocket, gum mark, canker	Allowed without limits
8	Fungus heartwood spots and stripes	Allowed without limits

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No.	Defect	Allowances
9	Fungus sapwood coloured spots and mold	Allowed without limits
10	Hard sapwood rot	Allowed without limits
11	External moldering soft sapwood rot	Not allowed
12	Heartwood rot	Hard and soft rot is allowed on faces and edges in the shape of spots and stripes with total area not exceeding 60% of one face and two edges total area. Rot on a board end should not exceed 30% of the board end area.
13	Worm hole	Allowed without limits
14	Foreign deposits	Not allowed
15	Blunt wane	Allowed without limits
16	Acute wane	Allowed on both edges with inner face nominal size loss not more than 15 mm
17	Bark on wane	Allowed without limits
18	Slab	Allowed if not longer 1/3 of a board length
19	Tooth marks, tear-outs, shears, fringe, skewed saw cut, waviness	Allowed without limits
20	Bow, spring, cup, twist	Allowed without limits

3 Packaging and Marking

3.1 Transport bundles shall be formed with the use of strapping bands of tensile strength not less than 6000 H (steel and plastic).

3.2 Dimensions of a bundle:

- width 900-1200 mm
- height 250-1200 mm
- length 1.8-6.3 m

3.3 Markings shall be made in red paint on upper and side faces of each bundle.

3.4 Marking includes:

- species;
- bundle number;
- boards thickness and width;
- mark "KD" (notifying that sawn timber is kiln-dried);
- maximum board length in the bundle;
- total number of boards in the bundle /number of short boards in the bundle;
- volume;
- mark "TU" (meaning "Technical Specification")
- mark "TU" and abbreviation for species on the end face of a bundle.

3.5 No marking of boards is required.

3.6 Polyethylene film and polypropylene laminated cloth shall be used as wrapping material. Bundles can be 1-, 3- or 5-sided wrapped. In case of 1-side wrapping the film can be put on the upper face or under the upper layer of a bundle. Bundles shall be wrapped according to the requirements of sawmill regulations.

4 Storage and Shipment

4.1 Sawn timber bundles shall be stored in the sawmill warehouse, protected from atmospheric precipitations.

4.2 Sawn timber is stored and shipped according to the requirements of sawmill regulations.

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