

# SHORTHAND GRADING GUIDE



## SHORTHAND GUIDELINES

WANE Max for  $\frac{1}{4}$  the Length\*

#1 -  $\frac{1}{2}$  the Edge\*,  $\frac{1}{3}$  the Face

#2 -  $\frac{1}{2}$ " Nailing Edge\*,  $\frac{1}{2}$  the Face

#3 -  $\frac{3}{16}$ " Nailing Edge\*,  $\frac{3}{4}$  the Face

SKIP

#1 - Hit & Miss,  $\frac{1}{16}$ "\*\* on 1 of 10 Pieces

#2 - Hit & Miss,  $\frac{1}{16}$ "\*\* on Every Piece,

$\frac{1}{8}$ " for 2 Feet\*\* on 1 of 20 Pieces

#3 - Hit or Miss,  $\frac{1}{16}$ " on Every Piece,

$\frac{1}{8}$  for Full Length\*\* on 1 of 10 Pieces

SPLITS

#1 - Equal to the Width

#2 - Equal to the Width +  $\frac{1}{2}$  the Width

#3 -  $\frac{1}{6}$  the Length (2 Times the Length in Inches)

SHAKES on Ends (Same as Splits)

#1 - 2 Feet\*\* on Surface, None Through\*\*

#2 - 2 Feet Through\*, 3 Feet Surface or  $\frac{1}{4}$  the Length in 14 foot or Longer Pieces

#3 -  $\frac{1}{3}$ \*\* the Length Through-Full Length Surface  $\frac{1}{6}$ \*\* the Length on Edge or End

\*Most Often Applied on the Chain

## SHORTHAND GUIDELINES

### SLOPE OF GRAIN

#1 - One Inch in 10

#2 - One Inch in 8

#3 - One Inch in 4

### DECAY

#1 - None\*\*, Hollow Pith is OK

#2 - 1/2”\*\* Deep for 1/3 the Width

#3 1/3 the Cross Section

### CHECKS

#1, #2, #3 - Surface Checks Not Limited,  
Through Checks on Ends Same as SPLITS.

WARP Rules for Warp Vary Based on the Width and Length of a Piece. Allowable CROOK\* Increases with Length and Decreases as Width Increases.  
Allowable BOW Increases with Length.  
Allowable TWIST Increases as Both Length and Width Increase.  
Allowable CUP Increases as Width Increases.

\*\*Most Important Limitation

## TOTAL MEASUREMENT RULES

	<u>Any Edge Knot</u>		
	No. 1	No. 2	No. 3
2X4	About 1/2 The Face	About 2/3 The Face	About Full Face
2X6			
2X8			
2X10			
2X12			

	<u>Any Combination Knot</u>		
	No. 1	No. 2	No. 3
2X4	1/2" Wood	1/2" Over	1 1/2" Over
2X6	1" Wood	1/4" Over	2" Over
2X8	1 3/4" Wood	1/4" Wood	1 3/4" Over
2X10	2 3/4" Wood	3/4" Wood	1 3/4" Over
2X12	3 3/4" Wood	1 3/4" Wood	1 3/4" Over

## **ABOUT THE TOTAL MEASUREMENT RULES**

Total Measurement (TM) is a practical method of quickly and accurately judging the grade of any knot on the production line. TM is the SUM of all of the parts of the knot which must be measured eliminating the need to determine the average knot size. Applying TM to grade any shape knot: Compare the observed Total Measurement (TM) of the knot to the twice the knot size allowed in the rules while using the width of the piece as a guide when estimating the knots total (TM).

**NEED MORE INFO?**

**CONTACT US**