

INTERNATIONAL
STANDARD

ISO
13912

Second edition
2017-11

Structural timber — Machine strength grading — Basic principles

*Bois de structure — Classement par machine selon la résistance —
Principes de base*



Reference number
ISO 13912:2017(E)

© ISO 2017



COPYRIGHT PROTECTED DOCUMENT

© ISO 2017, Published in Switzerland

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Ch. de Blandonnet 8 • CP 401
CH-1214 Vernier, Geneva, Switzerland
Tel. +41 22 749 01 11
Fax +41 22 749 09 47
copyright@iso.org
www.iso.org

Contents

Page

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