

# GLUED LAMINATED TIMBER

## QUALITY DESCRIPTION



Glued laminated timber manufacturing accordance to LVS EN 14080:2013, additionally Easywood, SIA distinguishes the following visual criteria for the glued laminated beams:

	CRITERIA	INDUSTRIAL QUALITY	STANDART VISUAL QUALITY	SELECT (HIGH) QUALITY
1.	Firmly grown knots	Permitted		
2.	Fallen and loose knots with bark remains	Up to $\varnothing \leq 30$ mm permitted; from $> 30$ mm to be replaced with knot hole plugs	Up to $\varnothing \leq 20$ mm permitted; from $> 20$ mm to be replaced with knot hole plugs	Up to $\varnothing \leq 5$ mm permitted
3.	Resin pockets	Permitted	Up to 5 mm in width are permitted	Up to 3 mm in width are permitted
4.	Defects patched with minispot patches, long patches and knot hole plugs	Not necessary	Permitted	
5.	Knots and cracks filled patched with wood filler compound Number of patches not limited	Not necessary	Permitted By agreement between customer and manufacturer	
6.	Insect holes, damage	Permitted up to 2mm in width	Permitted up to 2mm in width	Not permitted
7.	Pith	Permitted		
8.	Craks caused by shrinking (Delivery condition)	Not limited	Up to 3mm wide	Up to 2 mm wide
9.	Discoloration that does not affect mechanical strength: blue, brown and red staining	Not limited	Up to 10% of the visible surface area	Not permitted
10.	Glued laminated beam surface roughness (smoothness)	Unplanned area permitted up to 5% of the total surface area, if not deeper than 3mm	Planed surfaces, edges are chamfered. Planning chatter permitted up to depth 1mm.	Planed surfaces, edges are chamfered. Planning chatter permitted up to depth 0,5mm.

13.	Grown in bark	Permitted	Permitted, width up to 10 mm, length up to 60mm	Not permitted
14.	Planing rip-outs	Permitted	Permitted up to 3mm in depth.	Not permitted

Notes:

1. Glued laminated beams are mainly a crack-resistant composite wooden material. Season cracks on the material surface are caused by changes in the climate or environment that is inevitable. These cracks are not considered as a defect and are permitted, they have no impact on the strength characteristics of the structure component.
2. If the customer does not request specific visual criteria for the desired glued laminated beams, the producer manufactures glued laminated beams with **Standard visual quality by default**.