

GRADING RULES FOR UNEDGED LUMBER

EOS-STANDARD

The rules for visual quality grading of unedged lumber have been standardized under the direction of the European Organization for the Sawmill Industry (EOS). Today this is the standard in grading of European unedged lumber.

Quality	A - Quality	B – Quality	C - Quality
Length	≥ 2,10 m	≥ 2,10 m	90 % ≥ 2,10 m 10 % ≥ 1,80 m
Minimum cover width (measured half-wane)	≤ 32 mm ≥ 100 mm > 32 mm ≥ 120 mm	≤ 32 mm ≥ 100 mm > 32 mm ≥ 120 mm	≤ 32 mm ≥ 100 mm > 32 mm ≥ 120 mm
Sound knots	80 % of the pieces free on both sides. 20 % of the pieces a small knot (max. 10 % of the width) allowed per piece of 2,10 m.	Isolated small knots (max. 15 % of width) allowed on both sides and 1 big knot (>70mm) per running meter when compensated for in size.	allowed
Dead knots, unsound knots	not allowed	1 knot up to 70 mm allowed per running meter, when compensated for in size.	allowed
Slope of grain	fairly straight slope of grain	light slope of grain allowed	allowed
Curly grain	not allowed	allowed	allowed
Inbark	90 % of the pieces free on both sides, 10 % of the pieces allowed, when compensated in size.	allowed, when compensated for in size	allowed, when compensated for in size
Rot	not allowed	allowed if isolated and when compensated for in size	allowed, when compensated for in size
Discolourations	not allowed	allowed if isolated and when compensated for in size	allowed, when compensated for in size
Red heart	80 % of the pieces free on both sides. Allowed at 20 % of the pieces on the back up to 10 % of the width.	allowed up to 10 % on the upper face	allowed on both sides if white on at least 12 cm next to the heart
Curvature	up to 2 cm per running meter	up to 5 cm per running meter	allowed
Cracks, fissures	straight cracks up to 20 % of the length permitted	Straight cracks up to 30 % of the length permitted. Unstraight cracks permitted if compensated for in size.	Straight and unstraight cracks up to 40 % of the length permitted.

source: EOS – (European Organization for the Sawmill Industry)

Unedged Beech Lumber

A - Quality

F = Face
R = Reverse side



SI units

Length	≥ 2,10 m
Width	≤ 32 mm thick ≥ 100 mm
	> 32 mm thick ≥ 120 mm

US/UK units

Length	≥ 7'
Width	≤ 5/4" thick ≥ 4"
	> 5/4" thick ≥ 5"

Grading in accordance with E.O.S

Unedged Beech Lumber

B - Quality



SI units

Length $\geq 2,10$ m

Width ≤ 32 mm thick ≥ 100 mm
 > 32 mm thick ≥ 120 mm

US/UK units

Length $\geq 7'$

Width $\leq 5/4"$ thick $\geq 4"$
 $> 5/4"$ thick $\geq 5"$

Grading in accordance with E.O.S



Unedged Beech Lumber

C - Quality

F = Face
R = Reverse side



SI units

Length	90 % $\geq 2,10$ m
	10 % $\geq 1,80$ m
Width	≤ 32 mm thick ≥ 100 mm
	> 32 mm thick ≥ 120 mm

US/UK units

Length	90 % $\geq 7'$
	10 % $\geq 6'$
Width	$\leq 5/4''$ thick $\geq 4''$
	$> 5/4''$ thick $\geq 5''$
Grading	in accordance with E.O.S

Unedged Beech Lumber

Red Heart



Quality grades similar to C, however, allow red heart

