

Visual over-rides for machine stress graded softwoods summarised from AS/NZS 1748.1:2011

Note: This is a brief summary only of the visual over-rides that apply to K/D P/G MSG softwoods under AS/NZS1748.1:2011. For a full description of all grade requirements, consult the Standard.

It has been developed for the BuildingLearning on-line training resource and is available for download from the webpage: *Visual over-rides for MSG softwoods* (in Section 5: Structural Timber Grading).

Characteristic	Limitation
Splits (not end splits)	Not permitted
End splits	Maximum individual length: ½ width of piece; Aggregate length at each end: lesser of 2 times width or 200 mm
Cupping	1 mm per 50 mm of width
Finished dressed size	+2 mm, -0 mm on specified width and thickness
Machine skip	Maximum -0.5 mm when extending for full length of the piece
Moisture Content	15% maximum average MC, with no individual piece exceeding 21% MC
Resin pockets and bark pockets	Depth: not extending from one surface to the opposite surface Individual length: not longer than the width of the piece
Squareness	±0.5 degree from a right angle (equivalent to less than 1 mm per 100 mm)
Want and wane	Maximum 1/2 face and 1/3 edge

Length (m)	Bow (mm)	Spring (nom. width mm)		Twist (nom. width mm)			
		Up to 125	150 & up	Up to 100	100-150	151-200	201-300
Up to 2.4	20	6	6	5	7	10	15
3.0	30	9	9	7	10	14	20
3.6	40	18	14	8	13	18	25
4.2	50	22	18	9	15	21	29
4.8	60	29	24	10	16	23	33
5.4	65	36	30	11	18	26	37
6.0 & over	70	44	36	12	20	28	40