

# **SPS 5**

## **Special Products Standard for Face-Glued Lumber "Vertical Use Only"**

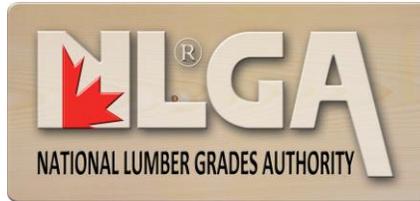


**Effective: November 2015**

**Approved by the Canadian Lumber Standards Accreditation Board**

**Supersedes All Previous Editions, Revisions and Supplements**





**SPS 5**

**SPECIAL PRODUCTS STANDARD**

**FOR**

**FACE-GLUED LUMBER**

**“VERTICAL USE ONLY”**

**EFFECTIVE: November 5, 2015**

**Supersedes all Previous Editions, Revisions and  
Supplements Previous to November 5, 2015**

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## PREFACE

- Below is a list of the Sections of SPS 5 that were revised since December 1, 2002.
  - a) **Revised Sections Effective December 1, 2003**
    - Section 7.1.3;
  - b) **Revised Sections Effective December 1, 2005**
    - Section 7.1.3;
  - c) **Revised Sections Effective December 1, 2006**
    - Section 1.5;
    - Section 3.1;
    - Section 6.2;
    - Section 8.3;
    - Section 9.2.4;
    - Section 11.2;
    - Section 13.3;
    - Section 15.2.1; and
    - Added a New Figure 2.
  - d) **New and Revised Sections Effective November 1, 2010**
    - Section 2.1 - added “HRA” and Spot-Check definitions and revised the “Interchangeable” definition;
    - Section 2.2 - updated the “Reference Publications”;
    - Section 10.2 - added “HRA”; and
    - Section 14.1 & 14.2 – Added “Spot-check” references.
  - e) **Revised Sections to Meet the ALSC Glued Lumber Policy Effective November 9, 2015**
    - Section 1.5.2
    - Section 2.2 – updated publication references
    - Section 3.3.1, Section 9.2.2, Section 10.2 and Appendix VIII

## 1.0 SCOPE

### 1.1 PART A AND PART B

This Standard consists of two parts:

#### PART A:

Product Specifications: specifies grade characteristics, standard sizes, visual grading and adhesive requirements, property requirements, property evaluation procedures, and grade stamping requirements for Face-Glued Lumber – Vertical Use Only

#### PART B:

Qualification and Quality Control Requirements: specifies minimum qualifications and quality control requirements for a facility producing face-glued lumber in accordance with the requirements of Part A of this Standard.

### 1.2 NLGA STANDARD GRADING RULES

This Standard shall be used in conjunction with and forms part of the NLGA Standard Grading Rules for Canadian Lumber.

### 1.3 IMPERIAL UNITS

In case of a dispute, the values stated in imperial units shall take precedence.

### 1.4 DESIGN VALUES

For use in Canada, design values are assigned to visually graded lumber of equivalent grade by the CSA Technical Committee on Engineering Design in Wood and are published in the current edition of CSA 086.

For use in the USA, design values are published in the NLGA Standard Grading Rules (Para 900).

### 1.5 FACE-GLUED LUMBER

#### 1.5.1 GENERAL

This Standard applies to **Stud grade** face-glued “Vertical Use Only” lumber. The quality of the components and the bonded face shall be verified by inspection and test procedures. The glue-line of each component shall run parallel to the edge and the bonded surface shall be flat with no profile included. The quality of the full-length piece of lumber containing the bonded face shall be verified by visual grading in accordance with Para 121a (STUD) of the NLGA Standard Grading Rules.

#### 1.5.2 PERMITTED PRODUCTS

The following are permitted under this Standard:

- i) Face-bonding of solid sawn lumber;
- ii) Face-bonding and ripping of solid sawn lumber;
- iii) Face-bonding of fingerjoined lumber meeting the requirements of NLGA SPS 1 or SPS 3;
- iv) Face-bonding of fingerjoined lumber meeting the requirements of NLGA SPS 1 or SPS 3 and ripping to 2” nominal thick lumber; or

- v) Fingerjoining in accordance with NLGA SPS 1 or SPS 3 of face-bonded segments meeting the requirements of this Standard.

(See Appendix VIII for products that fall within the scope of SPS 5)

#### 1.5.3 GRADE STAMP REQUIREMENTS FOR FACE-GLUED FINGERJOINED LUMBER

The grade stamp requirements of this Standard shall apply to face-glued lumber qualified to this Standard. The grade indicated shall not be greater than that for which the quality control test requirements of NLGA SPS 1 or SPS 3, whichever is applicable, can be satisfied.

Except for the grade stamp applied under this Standard, all other grade-marks shall be removed or obliterated.

#### 1.5.4 FACE-BONDING OF FINGERJOINED LUMBER

If fingerjoined lumber is used as candidate stock for face-bonding under this Standard, the following shall apply:

##### 1.5.4.1 REQUIREMENTS FOR THE CANDIDATE STOCK

The fingerjoined lumber shall have met the qualification and quality control requirements in accordance with NLGA SPS 1 or SPS 3 requirements for strength and delamination for Stud grade.

##### 1.5.4.2 FINGERJOINT QUALIFICATION & QUALITY CONTROL REQUIREMENT

The plant layout, production sequence and identification of the candidate stock shall be described in the Quality Control Manual. Steps shall be taken to ensure that all segments in the final product originate and can be verified to have originated from production that meets the NLGA SPS 1 or SPS 3 requirements for Stud grade.

#### 1.5.5 FINGERJOINING OF FACE-GLUED LUMBER

If face-glued lumber is used as candidate stock for fingerjoining under NLGA SPS 1 or SPS 3, the following shall apply:

##### 1.5.5.1 REQUIREMENTS FOR THE CANDIDATE STOCK

The finished face-glued lumber product including fingerjoints shall meet the requirements of this standard, except as permitted in Section 1.5.5.2.

##### 1.5.5.2 BONDED FACE EVALUATION

It is permissible to separately evaluate the bonded face prior to fingerjoining for shear parallel to grain and wood failure in accordance to this Standard.

##### 1.5.5.3 BONDED FACE QUALIFICATION & QUALITY CONTROL REQUIREMENT

The plant layout, production sequence and identification of the face-glued lumber to be fingerjoined shall be described in the Quality Control Manual. Steps shall be taken to ensure that all segments in the final product originate and can be verified to have originated from production that meets the bonded face requirements of this standard.

## 2.0 DEFINITIONS AND REFERENCED PUBLICATIONS

### 2.1 DEFINITIONS

The following definitions shall apply to this Standard.

**AGENCY:** an organization accredited by the Canadian Lumber Standards Accreditation Board (CLSAB) and/or the American Lumber Standard Committee Board of Review engaged in the grading, grade stamping and/or certification of lumber or who certifies facilities to grade and place a grade stamp upon lumber.

**AGENCY SUPERVISOR:** an employee of the Agency who is approved by the Agency to inspect facilities producing face-glued lumber.

**AGENCY VERIFICATION:** a specific set of procedures used by an Agency to verify that an item of post grade stamped face-glued lumber conforms to the requirements of this Standard and the NLGA Standard Grading Rules.

**BONDED FACE:** the location at which two components are held together with a layer of adhesive.

**CALIBRATION:** a procedure of comparing two instruments, measuring devices or standards, one of which is of known accuracy traceable to a nationally recognized standard.

**CHARACTERISTIC PROPERTY VALUE:** the value corresponding to a percentile in the assumed statistical distribution of a particular property of the material.

**CONFORMANCE:** a state in which the production process meets the requirements of this Standard.

**COMPONENTS:** lumber that is used for the lay-up of face-glued lumber. (Candidate stock)

**EVALUATION:** an assessment of the manufacturing process and its quality control programs to determine whether a facility is capable of producing an item that meets the requirements of this Standard.

**FACE-GLUED LUMBER:** a product made by bonding together two or more components of lumber so that the grain of all laminations is essentially parallel. For the purposes of this Standard, a product that meets the requirements of this Standard and has glue lines only visible on the wide face of the specimen and the bonded surface shall be flat with no profile included may be considered as “Face-glued – Vertical Use Only” lumber.

**FACILITY:** is a manufacturing plant that produces face-glued lumber and conducts visual grading and quality control sampling and testing.

**GLUE LINE:** the layer of adhesive that attaches two components.

**GRADE STAMP (MARK):** the grade identification applied on a specimen of face-glued lumber shall include the appropriate information under Section 10 of this Standard.

The grade stamp (mark) indicates that the face-glued lumber process meets the requirements of the Agency’s qualification and quality control procedures.

**HEAT RESISTANT ADHESIVE (HRA):** an adhesive that meets the elevated temperature performance requirements of ASTM D7374-13 or ASTM D7470.

**IN-CONTROL:** a state in which on-going quality control testing indicates that the production process meets the mechanical property and delamination requirements of this Standard.

**INSPECTION:** the examination, measurement and/or testing of the properties of an item to ensure they meet the quality control requirements of this Standard.

**INTERCHANGEABLE:** capable of being assigned the design values of another product under certain end-use conditions.

**Note 1:** *The specific end-use conditions are described in this Standard.*

**Note 2:** *Two products are deemed to be interchangeable only to the extent established by the minimum requirements specified in this Standard. Comparability of properties not explicitly covered by this Standard may require additional assessment.*

**ITEM:** lumber of a given grade, size (without reference to length), species or species group and moisture content.

**NON-CONFORMANCE:** a deficiency in a property, documentation or procedure that renders the quality of an item not to be in adherence to specified requirements of this standard and therefore unacceptable. Examples that may cause non-conformance: physical defects, test failures, incorrect or inadequate documentation, or deviations from prescribed processing, inspection or test procedures.

**OUT-OF-CONTROL:** a state in which on-going quality control testing indicates that the production process does not meet the mechanical property and delamination requirements of this Standard.

**PRESSURE-VACUUM-DRY TREATMENT:** a test procedure that provides an indication of the items ability to resist exposure conditions normally encountered during shipment, storage, or use.

**QUALITY CONTROL:** a set of procedures that provide a means of measuring and regulating the characteristics of an item to specified requirements.

**QUALITY CONTROL MANUAL (PLANT STANDARD):** a document which sets forth a specific set of instructions to describe the quality control functions and requirements to be carried out in the production of face-glued lumber.

**RANDOM SAMPLING:** a procedure by which a sample is generated from a population. The sample shall be representative of the population.

**RE-QUALIFICATION:** analysis of the test results from a random sample drawn from a process that has undergone corrective action in response to an “**OUT-OF-CONTROL**” condition or re-establishing conformance of non-production grades for a period exceeding one year of a particular face-glued lumber grade.

**SEPARATE-APPLICATION ADHESIVE:** a multi-component adhesive that has the following characteristics:

Each adhesive component is applied separately to one or both sides of the joint or glue-line.

All adhesive components are required for the bond strength to be fully developed.

Some separate-application adhesives require that the components be blended<sup>1</sup> in order for the adhesive to develop the required strength and durability. Other systems simply require the components to come into contact with each other.

<sup>1</sup> **Blended** is defined as thoroughly mixing the adhesive components together resulting in a homogeneous mixture.

**SHIPMENT:** one or more bundles, packages or units of lumber that comprise an order.

**SPECIMEN:** a piece of full size face-glued lumber randomly selected from production for purposes of quality control, quality verification testing and any subsequent analysis.

**SPOT CHECK:** the verification that the calibration / device / machine are still within calibration tolerances.

**SUBSEQUENT QUALIFICATION:** analysis of the test results from a random sample drawn from a process whose production is in-conformance with the requirements of this Standard, but has been modified for reasons other than to respond to a detection of non-conformance. Subsequent Qualification procedures apply only to the process changes specified in this Standard. Other process changes shall be evaluated using the Initial Qualification procedures.

**TEST BLOCK:** a piece of face-glued lumber cut out from a specimen selected for purposes of quality verification testing and any subsequent analysis.

**TEST EQUIPMENT:** equipment used by the facility to determine the shear strength of a bonded face for the purpose of determining conformance to the requirements of this Standard.

**TEST LOAD:** a load that will induce a stress that corresponds to the characteristic property value for the grade under consideration.

**WOOD FAILURE:** a type of failure induced on the glue bond in which the bonded face is failed by the tearing of wood fibre from one or the other of the two pieces that are face-glued.

## 2.2 REFERENCED PUBLICATIONS

### ANSI/AWC NDS<sup>®</sup>

National Design Specification for Wood Construction (2012)

### ALSC

**Glued Lumber Policy (GLP)** (Nov 2013)

## ASTM

**D905-08 (2013)** Standard Test Method for Strength Properties of Adhesive Bonds in Shear by Compression Loading

**D1101-97a (2013)** Standard Test Methods for Integrity of Glue Joints in Structural Laminated Wood Products for Exterior Use

**D2559-04** Standard Specification for Adhesives for Structural Laminated Wood Products for Use under Exterior (Wet Use) Exposure Conditions

**D4444-13** Standard Test Methods for Laboratory Standardization and Calibration of Hand-Held Moisture Meters

**D5266-13** Standard Practice for Estimating Percentage of Wood Failure in Adhesive Bonded Joints

**D7374-08 (2015)** Practice for Evaluating Elevated Temperature Performance of Adhesives Used in End-Jointed Lumber

**D7438-13** Standard Practice for Field Calibration and Application of Hand-Held Moisture Meters

**D7470-08 (2015)** Standard Practice for Evaluating Elevated Temperature Performance of End-Jointed Lumber Studs

**E4--13** Practices for Load Verification of Testing

## CLSAB

**REGULATIONS** (Oct 2013)

## CSA

**CAN/CSA-O86-14**

Engineering Design in Wood

**CAN/CSA-O141-05 (R2014)**

Softwood Lumber

**CSA-O112.7-M1977 (R-2001)**

Resorcinol and Phenol-Resorcinol Resin Adhesives for Wood

**CSA-O112.9-10 (R2014)**

Evaluation of Adhesives for Structural Wood Products (exterior exposure)

**CSA-O122-2006 (R-2011)**

Structural Glue-Laminated Timber

## NLGA

**Grade Rule**

Standard Grading Rules for Canadian Lumber (Jan 2014)

**SPS 1**

Special Products Standard for Fingerjoined Structural Lumber (Nov 2014)

**SPS 3**

Special Products Standard for Fingerjoined "Vertical Use Only" Lumber (Nov 2014)

## PART A -PRODUCT SPECIFICATION FOR FACE-GLUED LUMBER – VERTICAL USE ONLY

### 3.0 PRODUCT DESCRIPTION

#### 3.1 GENERAL

This Standard applies to **Stud grade** face-glued lumber (herein referred to as *face-glued lumber*) to be used as a member loaded in axial compression where bending and tension design load components do not exceed the duration for wind or seismic loading as defined in the applicable engineering design standard and where the in-service moisture content of the wood will not exceed 19%.

#### 3.2 FACE-GLUED LUMBER - VERTICAL USE ONLY

Face-glued "Vertical Use Only" lumber produced to the requirements of SPS 5 is interchangeable with non-face-glued lumber of the same grade and length except in the following respects:

- a) It can only be used in accordance with the applications described in Section 3.1; and
- b) It cannot be visually re-graded or re-manufactured into a higher stress grade even if the quality of the lumber containing bonded faces would otherwise warrant such re-grading.

Lumber represented as conforming to the requirements of this Standard, shall be manufactured by a process in which the quality of the bonded face produced is continuously in accordance with all of the requirements specified herein. Product conformance shall be recorded by the maintenance of records and charts on the results of the inspection and test procedures.

#### 3.3 SPECIAL APPLICATIONS

##### 3.3.1 HEAT RESISTANT ADHESIVES

Face-glued "Vertical Use Only" lumber is manufactured with a heat resistant adhesive that meets the requirements of ASTM D7374 or ASTM 7470.

**Note:** See ASTM D7374–08 (2015) "Practice for Evaluating Elevated Temperature Performance of Adhesives Used in End-Jointed" for background on standard fire rated assembly.

#### 4.0 GRADE DESCRIPTION

This Standard applies to visual grade face-glued lumber in all the species groups as defined in Section 6 for the Stud grade only as specified in the NLGA Standard Grading Rules.

### 5.0 STANDARD SIZES

SPS 5 - Vertical Use Only face-glued lumber shall be in sizes 2x3 through 2x6 only and in lengths not to exceed 12' (3.66m).

Thicknesses and widths for face-glued lumber produced in accordance with this Standard are shown in Table 1.

**TABLE 1 – STANDARD THICKNESS AND WIDTHS (FROM CSA O141)**

Nominal Dimension	Actual Dimension			
	Imperial Units (inches)		Metric (mm)	
Thickness	Dry	Green	Dry	Green
2	1- <sup>1</sup> / <sub>2</sub>	1- <sup>9</sup> / <sub>16</sub>	38	40
Width	Dry	Green	Dry	Green
3	2- <sup>1</sup> / <sub>2</sub>	2- <sup>9</sup> / <sub>16</sub>	64	65
4	3- <sup>1</sup> / <sub>2</sub>	3- <sup>9</sup> / <sub>16</sub>	89	90
5	4- <sup>1</sup> / <sub>2</sub>	4- <sup>5</sup> / <sub>8</sub>	114	117
6	5- <sup>1</sup> / <sub>2</sub>	5- <sup>5</sup> / <sub>8</sub>	140	143

### 6.0 VISUAL REQUIREMENTS

#### 6.1 SPECIES

The lumber used in the manufacture of face-glued lumber may be of any species in the species combinations specified in the NLGA rules. These species may be combined in any combination that preserves the species combination.

#### 6.2 WOOD QUALITY

##### 6.2.1 GENERAL

**6.2.1.1** The face-glued lumber shall be formed from components that shall not be less than ½" actual size (12.5 mm) in thickness.

**6.2.1.2** Face-glued lumber shall be formed in wood that meets the visual requirements of Section 6.2.2 prior to gluing.

##### 6.2.2 WOOD QUALITY FOR EACH COMPONENT

**6.2.2.1 Knots or Holes:** shall not occupy more than ¼ of the cross-section in each component in order to respect the restriction of the cross- section of the grade.

**6.2.2.2 Wane:** shall not exceed half the thickness and half of the width.

**6.2.2.3 Compression wood:** severe compression wood is not permitted.

**6.2.2.4 Honeycomb and decay:** not permitted in the glued bonded face area.

**6.2.2.5 Pitch:** shall not exceed half the thickness and half of the width.

**6.3 FINISHED PRODUCT LUMBER QUALITY**

**6.3.1 Visual Grade**

The finished product shall be visually graded in accordance with the Stud provisions of the NLGA Standard Grading Rules for Canadian Lumber except as provided in Sections 6.3.2, 6.3.3 and 6.3.4.

**6.3.2 White Specks**

White specks are unlimited if only occurring on one side of the bonded face. White specks are not permitted to overlap in the same cross-section on the 2-bonded faces. White speck to white speck shall not be bonded in the same cross-section.

**6.3.3 Offset**

**Offset** between surfaces of the lumber must not exceed  $\frac{1}{16}$ " (1.6 mm) on occasional pieces.

**6.3.4 Wane**

Wherever possible, wane on the two components forming the face-glued lumber shall not be placed at the bonded face.

**6.4 MOISTURE CONTENT**

Green and dry lumber shall not be mixed within the same piece.

**7.0 ADHESIVE REQUIREMENTS**

**7.1 ADHESIVE SPECIFICATION**

**7.1.1 GENERAL**

The adhesive used for face gluing shall meet either Section 7.1.2 or Section 7.1.3 of this Standard.

**7.1.2 RESORCINOL AND PHENOL RESORCINOL ADHESIVES**

The adhesive used for face gluing shall meet the requirements of CSA O112.7-M1977, *Resorcinol and Phenol-Resorcinol Adhesives for Wood*. The adhesive may be mixed with the minimum amount of inert fillers required for its performance in the particular process being used.

**7.1.3 ALTERNATE ADHESIVES**

The adhesive used for face gluing shall meet either the requirements of CSA O112.9-10 or meet the requirements of ASTM D2559 and the high temperature requirements of CSA O112.9-10 when evaluated for one of the softwood species specified in the Standard.

**7.2 SEPARATE APPLICATION ADHESIVES**

Separate application adhesives are not permitted.

**7.3 ADHESIVE MIXING**

Mixing of the adhesive shall be performed in accordance with the instructions supplied by the adhesive supplier for the particular adhesive.

**7.4 BONDED FACE FABRICATION**

**7.4.1 ADHESIVE APPLICATION**

The adhesive shall be applied to the bonded face profiles in a manner that will ensure that all of the gluing surfaces between the surfaces receive sufficient amount of adhesive resulting in squeeze out of excess glue when the gluing pressure is applied. The adhesive may be applied to one or both pieces forming the bonded faces.

**7.4.2 HEAT DAMAGE**

The procedure used to apply heat to the bonded face shall be such as to ensure that neither the wood surfaces in the gluelines nor the wood itself are damaged by excess heat.

**Note:** *In Radio Frequency (RF) curing, wood damage may result from excessively long exposure of the bonded face to the RF field. When the wood is pre-dried in a kiln, excessive drying temperatures (above 350° F or 175° C) may reduce the strength of the wood. In either situation both the strength and the long-term durability of the bonded face may be impaired.*

**7.4.3 ASSEMBLY PRESSURE**

The pressure applied during the bonded face assembly process, and while the glue-line is being cured, shall be that required for the particular lumber size, species, bonded face design and process used.

Pressure shall be applied uniformly over the entire area to be bonded.

**8.0 PROPERTY REQUIREMENTS FOR FACE-GLUED LUMBER**

**8.1 MODULUS OF RUPTURE (MOR)**

The process lower fifth percentile for edge bending modulus of rupture ( $MOR_{5th}$ ) shall equal or exceed the bending strength (MOR) test value for the size and species group for stud grade as provided in Table 2 and when subjected to a short-term test load and tested in accordance with Section 9.1.

$$MOR_{5th} \geq MOR$$

**8.2 SHEAR PARALLEL TO GRAIN (Fv)**

The process lower fifth percentile for shear strength parallel to grain ( $Fv_{5th}$ ), shall equal or exceed the shear strength parallel to grain (Fv) test value for the species group as provided in Table 2 when subjected to a short-term test load and tested in accordance with Section 9.2.

$$Fv_{5th} \geq Fv$$

**TABLE 2 – TEST VALUES FOR FACE-GLUED LUMBER** <sup>[1]</sup>

Species Group & Size		Modulus of Rupture (psi)	Shear Strength (psi)
S-P-F	2x3 2x4	2290	285
	2x5	2020	
	2x6	1880	
Hem-Fir (N)	2x3 2x4	2610	305
	2x5	2300	
	2x6	2150	
D Fir-L (N)	2x3 2x4	2030	380
	2x5	1800	
	2x6	1680	
North Species	2x3 2x4	1690	230
	2x5	1490	
	2x6	1390	

<sup>[1]</sup> Derived from the design values of the U.S. National Design Specification for Wood Construction and CSA O86 Engineering in Wood

### 8.3 WOOD FAILURE

#### 8.3.1 GENERAL

Any separation of the glue line in the final product shall be investigated. If necessary, additional physical testing shall be undertaken.

*Note: Inclusion of this provision in the current standard has been adopted from CSA O122-M89.*

#### 8.3.2 AVERAGE WOOD FAILURE

The “Average” wood failure of the test results shall equal or exceed 80% wood failure.

#### 8.3.3 MINIMUM WOOD FAILURE

“All” of the test results shall equal or exceed 60% wood failure.

### 8.4 FINAL GRADE

The final grade of the face-glued lumber shall be determined by the lower of the visual grade of the lumber or the stress grade determined by strength tests on the bonded faces.

## 9.0 FACE-GLUED LUMBER PROPERTY EVALUATION PROCEDURES

### 9.1 MODULUS OF RUPTURE (MOR)

Modulus of rupture (MOR) shall be determined by applying a test load that will induce a maximum stress not less than the characteristic bending strength value for the grade under consideration.

Specimens shall be tested on edge using third point loading and a span to depth ratio of 21 whenever possible. The specimen depth is the surfaced dry width as provided in Section 5, Table 1. If a span to depth ratio of 21 cannot be achieved the span shall be the maximum span possible.

The maximum strength-reducing characteristic as determined by visual grading shall be located in the middle third of the test span wherever possible, or as close to the middle third as possible.

For test equipment where the load is applied vertically, when there is more than 5 inches (127mm) of lumber overhanging beyond either of the reaction supports, the calculated MOR shall be corrected for the weight of the overhanging portions. Corrections are not required provided it can be demonstrated that neglecting the correction ensures a lower MOR value. Corrections are not required where specimens are tested with the load applied in a horizontal direction.

## 9.2 SHEAR PARALLEL TO GRAIN (Fv)

### 9.2.1 TEST BLOCK SIZE

**9.2.1.1** Shear test specimens shall be selected from normal production.

**9.2.1.2** One block shall be sawn from each specimen in clear wood with no apparent strength reducing characteristics. Care shall be taken in preparing the test blocks to make loaded surfaces smooth and parallel to each other and perpendicular to height.

**9.2.1.3** The test blocks shall be prepared as illustrated in Appendix II.

**9.2.1.4** After test block preparation, test blocks shall be subjected to the pressure-vacuum-dry treatment as specified in Appendix I.

The shear area shall be measured to the nearest 0.1 mm at the glue line after the pressure-vacuum-dry treatment and prior to testing.

### 9.2.2 SHEAR PARALLEL TO GRAIN TEST PROCEDURE

Each test block shall be tested in accordance with ASTM D905. Crosshead movement shall provide approximately a uniform rate of loading not to exceed 0.50 inch per minute.

### 9.2.3 MULTIPLE BONDED FACE TEST BLOCKS

For test blocks having multiple bonded faces, repeat the test procedure defined previously to evaluate every bonded face present in the test block. Report the minimum shear value and the wood failure from the bond line with the minimum shear value from each test block with multiple bonded faces.

### 9.2.4 WOOD FAILURE READING PROCEDURE

Only trained personnel shall read wood failure.

*Note: ASTM D5266 has been found useful in estimating the percentage of wood failure in adhesive bonded surfaces.*

**9.2.5 CALCULATION AND REPORT**

Shear strength shall be calculated from the recorded failing load and the measured shear area. The percentage of wood failure shall be determined on this area.

The specimen shear stress value shall be taken from the minimum test block value.

*Note: A maximum of one specimen may be rejected if a grade defect is detected after the shear block test and the test block shear strength is below the minimum required shear strength.*

The Agency may request a facility to hold the test blocks intact for examination by the Agency.

**9.3 ENVIRONMENTAL CONDITIONS**

**9.3.1 MEASUREMENT OF MOISTURE CONTENT AT TIME OF TEST**

For each test block, a moisture content measurement using a resistance type moisture meter shall be made on each side of the joint and sufficiently back from the base of the joint so that the meter readings are not influenced by the presence of the adhesive. Each of the readings shall be recorded as the moisture content of the specimen(s) segment at the time of test.

**9.3.2 TEMPERATURE**

**9.3.2.1 EQUIPMENT**

The temperature of the test equipment shall, at the time of the test, be in the range of 10 to 30° C (50 to 90° F) inclusive. If the proof loading equipment is operated at temperatures below 10°C (50°F), the equipment shall be calibrated at a temperature within ±5°C (10°F) of the temperature at which the equipment will be operated.

**9.3.2.2 TEST SPECIMENS**

Test specimens shall be stored under the same environmental conditions (within ±5°C or ±10°F) as the production until the start of the face-glued lumber property evaluation procedures.

**10.0 GRADE STAMP REQUIREMENTS**

**10.1 GENERAL FOR FACE-GLUED LUMBER**

A grade stamp on face-glued lumber indicates that the grading process meets the requirements of the Agency's qualification and quality control procedures. All previous grade stamps shall be removed or obliterated.

**10.2 GRADE STAMP REQUIREMENTS**

For all face-glued "vertical use only" lumber produced in conformance with the requirements of this Standard, the grade stamp on each piece shall contain:

- a) the grade;
- b) the species or species combination identification;
- c) the seasoning designation;
- d) the registered symbol of the agency;
- e) the facility identification;
- f) the expressions "SPS 5" and "CERT FACE-GLUED LBR - VERTICAL USE ONLY"

**PART B - QUALIFICATION AND QUALITY CONTROL REQUIREMENTS**

**11.0 EQUIPMENT**

The facility's test equipment shall meet the following requirements:

**11.1 MOR TEST EQUIPMENT ACCURACY**

The test span and location of the load points shall be capable of being set to within ±1/16" (1mm).

The load-measuring device shall be accurate to within ±2% of the actual load.

The load shall be applied through a crosshead. The rate of the crosshead movement shall not exceed 5 inches per minute (2mm/second) during specimen testing.

**11.2 SHEAR PARALLEL TO GRAIN TEST EQUIPMENT ACCURACY**

*Note: The shear test specimen is not a standard ASTM D905. See Appendix II.*

The load-measuring device shall be accurate to within ±2% of the actual load.

The rate of loading shall be within 0.015 to 0.5 inches per minute (0.38 to 12.7 mm/minute).

**11.3 PRESSURE-VACUUM-DRY TREATMENT EQUIPMENT**

**11.3.1 PRESSURE VESSEL**

An autoclave or similar pressure vessel designed to safely withstand and maintain a pressure of at least 100±1 psi (0.7 MPa ± 10 KPa) is required for impregnating the specimens with water. The pressure vessel shall be equipped with a means of obtaining a vacuum of at least 25 inches (635mm) of mercury (at sea level), and a means of obtaining a pressure of at least 75±1 psi (0.52 MPa ± 10 KPa) (gauge pressure). The vessel shall be equipped with a gauge(s) to register vacuum and pressure.

**11.3.2 DRYING OVEN**

The drying oven shall be capable of maintaining the conditions necessary to dry specimens to a moisture content of 19% or less.

*Note: These drying conditions are those obtainable in cross-flow, laboratory type ovens of the circulating type. They can also be obtained by using a non-circulating configuration in which air heated by a space heater is passed over the specimens and vented.*

*Conditions that affect the drying rate include cross-flow air velocity, humidity, air temperature and the arrangement, size and number of specimens in the oven. Circulating type ovens that provide a cross-flow air velocity of 250 ± 50 fpm (75 ± 15 m/min) in the centre of the drying chamber and maintain an air temperature of 160° ± 5°F (71 ± 3°C) should be capable of achieving the specified drying rate.*

**12.0 QUALITY CONTROL MANUAL (PLANT STANDARD)**

**12.1 GENERAL**

The Quality Control Manual (Plant Standard) is a written description of the manufacturing operation, broken down by station (see Appendix V).

**12.2 QUALITY CONTROL PERSONNEL**

The quality control personnel shall be directly responsible to the facility management, and not subordinated to production or sales.

Persons responsible for quality control shall possess and demonstrate to the satisfaction of the inspection agency that they have adequate knowledge of the manufacturing process, which shall include:

- a) Inspection and test procedures used to control the process;
- b) Operation and calibration of the recording and test equipment used;
- c) Maintenance and interpretation of quality control records.

Also, the quality control personnel shall be responsible for carrying out and maintaining records of various inspections, and test procedures detailed in the Quality Control Manual, and for formally advising the facility management of circumstances resulting from the inspections and test procedures that indicate corrective action may be necessary in the production process.

**12.3 PREPARATION, REVISION AND APPROVAL**

Each facility shall:

- a) Prepare a Quality Control Manual in compliance with this Standard and shall submit the manual to the Agency for approval;

- b) Regularly review and update its Quality Control Manual to reflect current production practices and procedures, quality control policies and quality control program procedures and resubmit to the Agency; and

- c) Upon approval, implement the updated program in accordance with the Manual.

The contents of the Quality Control Manual must be approved by the Agency at the time of qualification. Qualification shall apply only to the manufacturing, quality control procedures and limits set forth in the Quality Control Manual.

The Agency shall be notified in advance of any changes in the Quality Control Manual that may affect product quality. Failure to have such changes approved prior to implementation, or failure to maintain the process in compliance to the requirements of the Quality Control Manual, shall be grounds for disciplinary action.

**12.3.1 QUALITY CONTROL PROCEDURES**

The Quality Control Manual shall include detailed procedures specifying how each of the following is to be performed and controlled:

- a) Lay-up machine and test equipment operation and all calibration;
- b) Quality control sampling, testing and analysis;
- c) Documentation and record keeping;
- d) Identification and trace-ability;
- e) Non-conformance; and
- f) Corrective action.

**12.3.2 AGENCY**

The Quality Control Manual shall identify the Agency. CLSAB and ALSC accredited Agencies shall include in their certification and quality control procedures an explanation of the following:

- a) That their face-glued lumber certification and quality control procedures comply with the ALSC Glued Lumber Policy and the CLSAB Regulations;
- b) That the responsibility for the certification and quality control procedures is that of the Agency; and
- c) That the CLSAB and the ALSC Board shall monitor whether the certification and quality control procedures are being carried out by the Agency.

**13.0 QUALIFICATION AND SAMPLING REQUIREMENTS**

**13.1 GENERAL**

A facility requesting initial qualification shall provide the Agency with evidence that all the requirements of Part A of this standard have been met. Upon receipt of the request, the Agency Supervisor will visit the facility to determine that:

- a) The facility is capable of operating within the requirements of its Quality Control Manual;
- b) The facility personnel possess ability to undertake the requirements described in Section 12; and
- c) The calibration of the test equipment conforms to the requirements of the Quality Control Manual.

Each item shall be qualified before issuing grade stamps.

**13.2 NEW PRODUCTION LINE START-UP OR MAJOR CHANGE REQUIREMENTS (To be performed by the Facility)**

During start-up of a new production line or when a major change to the face-glued lumber process occurs, the facility shall immediately notify the agency. Prior to grade stamps being issued for lumber from the new production line or to continue grade-stamping privileges in the case of a major change(s), the facility shall provide the agency with test results of fifty-three (53) bending strength, fifty-three (53) shear parallel to grain, and fifty-three (53) wood failure tests. The specimens shall be tested in accordance with Section 9 and the test results shall meet the requirements set forth in Section 13.5.

The samples for these tests shall be obtained from a single size, consisting of a specific species or species combination and using a procedure, approved by the agency that ensures the samples obtained are representative of the item to be qualified.

The bending strength, shear strength parallel to grain and wood failure tests are required in the initial start-up of a gluing plant or when there is a major change to the gluing process. They are intended to verify the adequacy of the glueline profile chosen, and do not substitute for the test qualification requirements called for in Section 13.3 of this Standard.

Grade stamping shall be contingent upon verification of the item in accordance with Section 13.3 of this Standard.

**13.3 INITIAL QUALIFICATION SAMPLING (To be performed by the Agency)**

An Agency Supervisor shall randomly select the following for each size to be qualified:

- a) **53** specimens of face-glued lumber for bending strength (MOR) evaluations to be tested in accordance with Section 9.1 of this Standard.
- b) **53** specimens of face-glued lumber for shear strength parallel to grain (Fv) evaluations to be tested in accordance with Section 9.2 of this Standard.
- c) From the **53** specimens selected in Section 13.3b), wood failure assessment shall be performed in accordance with 9.2.4 of this Standard.

For items **a)** and **b)** above, additional samples to increase the total number for bending strength or shear assessments to **78, 102, 125** or **148** may be selected to qualify the bending or shear strength.

**13.4 RE-QUALIFICATION SAMPLING**

The Quality Control Supervisor shall randomly select the following samples for each item and for each property to be re-qualified:

When the bending strength modulus of rupture is required to be re-qualified, **28** specimens for the bending strength (MOR) evaluations shall be selected. The specimens shall be tested in accordance with Section 9.1 of this Standard.

- a) When the shear strength parallel to grain is required to be re-qualified, **28** specimens for the shear strength parallel to grain evaluations shall be selected. The specimens shall be tested in accordance with Section 9.2 of this Standard.
- b) When the wood failure is required to be re-qualified, wood failure assessment shall be performed from the **28** specimens selected in Section 13.4a).

For items **a)** and **b)** above, additional samples to increase the total number for bending strength or shear assessments to **53, 78, 102** or **148** may be selected to re-qualify the bending or shear strength.

**13.5 DECISION RULES**

**13.5.1 INITIAL QUALIFICATION RULES**

Results of shear tests shall determine whether or not grade stamps may be issued for the item being qualified.

An item shall be considered qualified when all of the following requirements are met:

**13.5.1.1 BENDING STRENGTH**

Not more than **1** of the **53** bending strength results shall have bending strength (MOR) value less than the species group value as provided in Table 2.

When the additional specimen sampling procedure referred to in Section 13.3 is used to qualify for bending strength, the test results shall not exceed **2** in a **78, 3** in a **102, 4** in a **125** or **5** in a **148** specimen sample.

**13.5.1.2 SHEAR STRENGTH PARALLEL TO GRAIN**

Not more than **1** of the **53** shear test results shall have shear strength parallel to grain (Fv) value less than the species group value as provided in Table 2.

When the additional specimen sampling procedure referred to in Section 13.3 is used to qualify for shear strength parallel to grain, the test results shall not exceed **2** in a **78, 3** in a **102, 4** in a **125** or **5** in a **148** specimen sample.

**13.5.1.3 WOOD FAILURE**

The “Average” wood failure of the test results for the 53 specimens shall equal or exceed 80% wood failure. “All” of the 53-specimen test results shall equal or exceed 60% wood failure.

**13.5.2 RE-QUALIFICATION RULES**

An item shall be considered re-qualified when all of the following requirements are met:

**13.5.2.1 BENDING STRENGTH**

“All” of the 28 bending strength tests shall equal or exceed the bending strength (MOR) value for the species group as provided in Table 2.

When the additional specimen sampling procedure referred to in Section 13.4 is used to qualify for bending strength, the test results shall not exceed 1 in a 53, 2 in a 78, 3 in a 102, 4 in a 125 or 5 in a 148 specimen sample.

**13.5.2.2 SHEAR STRENGTH PARALLEL TO GRAIN**

“All” of the 28 shear tests shall equal or exceed the characteristic shear strength parallel to grain (Fv) value for the species group as provided in Table 2.

When the additional specimen sampling procedure referred to in Section 13.4 is used to qualify for bending strength, the test results shall not exceed 1 in a 53, 2 in a 78, 3 in a 102, 4 in a 125 or 5 in a 148 specimen sample.

**13.5.2.3 WOOD FAILURE**

The “Average” wood failure of the test results for the 28 specimens shall equal or exceed 80% wood failure. “All” of the 28-specimen test results shall equal or exceed 60% wood failure.

**13.6 SUBSEQUENT QUALIFICATION**

**13.6.1 NEW ITEM**

Separate qualification sampling and testing outlined in Section 13.3 is required for each new item for which a grade stamp is desired.

**13.6.2 MAJOR CHANGES**

The qualification procedures outlined in Section 13.2 shall be required for any major changes and/or process conditions, which in the opinion of the Agency may affect the quality of the product.

**Note:** Major changes may include but are not necessarily limited to: any new adhesive, a change to the bonded face profile, joining of green or green-frozen lumber and/or producing a grade(s) that has higher design values than those initially qualified. Species change to a species group with higher design values.

**13.7 NON-PRODUCTION OF FACE-GLUED LUMBER**

When a certified facility does not produce face-glued lumber for a period exceeding one year, all grade qualifications for that facility shall become void. The requirements for initial qualification shall be satisfied prior to further production of face-glued lumber.

**14.0 EQUIPMENT CALIBRATION**

Records of all calibrations and spot-check verifications shall be maintained for at least six (6) years.

**14.1 TEST EQUIPMENT**

The test equipment shall be certified by an independent certification organization acceptable to CLSAB prior to initial qualification and once a year thereafter.

Procedures for calibration of the test equipment shall be consistent with the applicable sections in ASTM E4, except that the percentage error shall not exceed ± 2.0%.

It is the responsibility of the facility to maintain the operating condition of its test equipment in accordance with requirements set forth in their Quality Control Manual and this Standard.

The test equipment shall be spot-checked in accordance with procedures set forth in the Quality Control Manual and the spot-check shall be performed at a frequency level listed in Table 3 and whenever there is reason to suspect the equipment may be out of calibration or damaged.

The Agency shall be notified immediately if damage to the test equipment or a spot-check device has occurred. Re-calibration of the test equipment or spot-check devices by an independent certification organization may be required by the Agency.

TABLE 3 – TEST EQUIPMENT CALIBRATION FREQUENCY

Equipment	Minimum Spot Check Frequency
Bending Proof Loader	At least once a week with a proof ring
Shear Tester	At least once a week
Other Test Equipment	As per manufacturer's specifications, the Quality Control Manual, or this Standard, whichever period is more frequent.

**14.2 CALIBRATION DEVICES**

An independent certification organization acceptable to CLSAB shall certify and calibrate devices necessary to conduct the required spot-checks on the test equipment. This is to be done prior to initial qualification and once a year thereafter.

Procedures for the certification and calibration of calibration spot-check devices shall be consistent with applicable sections of ASTM E4 except that the percentage error shall not exceed ± 2.0%.

A copy of all certification documents shall be made available to the Agency.

**15.0 QUALITY CONTROL REQUIREMENTS**

Verification of bonded face quality shall be as follows:

**15.1 QUALITY CONTROL PROCEDURES**

The quality control procedures described herein are intended to detect non-conformance. The properties being considered are:

- i) Bending strength;
- ii) Shear strength parallel to grain; and
- iii) Wood failure.

The quality control procedures adopted by the facility shall be fully documented in their Quality Control Manual.

Verification of product quality includes two independent procedures:

- i) One dealing with the quality, strength and resistance to moisture of the face-glued lumber bonded faces; and
- ii) One dealing with the grade of the lumber containing face-glued lumber bonded faces. Verification of lumber grades shall follow the provisions set forth in the NLGA Grading Rules.

**15.2 QUALITY CONTROL SAMPLING**

**15.2.1 SAMPLING METHOD**

The sampling method shall be approved by the Agency and documented in the Quality Control Manual.

Specimens shall be sampled from grade stamped production, except as permitted in Section 1.5.5.2. The sampling method shall include procedures for selecting the face-glued lumber specimens for bending and shear strength tests and which portion will be tested for shear and wood failure.

**15.2.2 SAMPLING FREQUENCY**

**15.2.2.1 BENDING STRENGTH SAMPLING**

**One (1)** specimen per hour per shift (8 hours) with no fewer than **five (5)** specimens collected during a production shift of less than five (5) hours shall be obtained for bending strength assessment.

**15.2.2.2 SHEAR STRENGTH PARALLEL TO GRAIN SAMPLING**

**Two (2)** test blocks from each specimen at least 2 feet apart from each other shall be obtained during each **one (1)** hour or part thereof of operation.

Under exceptional circumstances, the Agency may request the facility to increase its frequency of inspection and/or testing.

**15.2.2.3 WOOD FAILURE SAMPLING**

**Two (2)** wood failure evaluations from each specimen shall be obtained during each **one (1)**-hour or part thereof of operation.

Wood failure evaluations shall be determined from the same test blocks as identified in Section 15.2.2.2.

Under exceptional circumstances, the Agency may request the facility to increase its frequency of inspection and/or testing.

**15.3 QUALITY CONTROL TESTING**

Testing for bending strength, shear strength parallel to grain and wood failure shall be performed in accordance with the procedures described in Part A, Section 9 of this Standard.

**15.4 ANALYSIS OF QUALITY CONTROL TESTS**

All production from a shift or part thereof shall be held in inventory pending the results of the quality control evaluation of Sections 6, 7 and 8 of this Standard for that production period.

Test results shall be entered on Agency approved control forms. The control forms shall be designed so that the process properties qualified under Sections 13.3 and 13.5.1 are recorded and **“IN-CONTROL”** and **“OUT-OF-CONTROL”** situations shall be readily detectable.

**15.4.1 IN-CONTROL**

When all of the process properties referred to in Section 15.4 remain **“IN-CONTROL”**, the item from which the quality control sample was drawn shall be deemed to be in compliance with the property requirements of this Standard.

**15.4.2 OUT-OF-CONTROL**

The requirements of this section relate to the conditions described in Appendices III and IV.

When any of the process properties described in Section 15.4 goes **“OUT-OF-CONTROL”**, the item from which the quality control sample was drawn shall be held pending results of the following tests (as applicable):

- a) An examination of the test procedures, calibration and/or calculations shall be made to determine whether there were errors;
- b) If no such errors are identified, proceed to Section 15.4.2.1;
- c) Held production deemed to be **“OUT-OF-CONTROL”** after evaluations in accordance with Section 15.4.2.1 shall be rejected. The grade stamps shall be obliterated or removed.

**15.4.2.1 BENDING STRENGTH, SHEAR STRENGTH PARALLEL TO GRAIN & / OR WOOD FAILURE**

When the production represented by a specific time frame from which the quality control sample was drawn fails to meet the bending strength, shear strength or wood failure requirements prescribed in Sections 8.1, 8.2 and 8.3, production from this time frame shall be held pending the results of a **28**-specimen bending tests or the results of **28** test blocks drawn from **14** shear / wood failure test specimens, for whichever of the

test(s) that went “**OUT OF CONTROL**”.

These confirmation samples shall be randomly selected and tested in accordance with Section 13.4.

**a) BENDING STRENGTH**

When the test results for bending strength (MOR) fail to meet requirements of Section 13.5.2.1, the held item shall be deemed to be in non-compliance with the requirements of this Standard and all grade stamps shall be obliterated from the face-glued lumber.

**b) SHEAR STRENGTH PARALLEL TO GRAIN**

When test results indicate the process is “**IN-CONTROL**” for shear, the facility shall proceed to proceed to Section 15.4.2.1c) for wood failure evaluation.

When the test results for shear strength parallel to grain (Fv) fail to meet requirements of Section 13.5.2.2, the held item shall be deemed to be in non-compliance with the requirements of this Standard and all grade stamps shall be obliterated from the face-glued lumber.

**c) WOOD FAILURE**

When shear test results indicate the process is “**IN-CONTROL**” and the wood failure test results confirm that the “**IN-CONTROL**” requirements have been regained, the held item shall be deemed to comply with the wood failure requirements of this Standard.

When the test results for wood failure fail to meet requirements of Section 13.5.2.3, the held item shall be deemed to be in non-compliance with the requirements of this Standard and all grade stamps shall be obliterated from the face-glued lumber.

The Agency may request a facility to hold the wood failure test samples for examination.

**15.5 IDENTIFICATION AND TRACEABILITY**

Each package of face-glued lumber leaving the facility production line shall be identified with the time and date it left the production line.

The reason for this is traceability of an item in the event that further testing is required or in the event of a non-conformance situation.

**15.6 QUALITY CONTROL RECORDS**

Facility control records shall include:

- a) Equipment calibration and maintenance data;
- b) Quality control tests; and
- c) All face-glued lumber production stoppages as a result of quality control requirements and a report of the corrective actions taken.

Separate records shall be maintained for each item produced.

All records shall include the date when performed and shall be retained for at least six (6) years. These records shall be made available to the Agency upon request.

**16.0 REINSPECTION PROVISIONS**

**16.1 GENERAL**

Response to complaints on face-glued lumber involving visual grade, size, moisture content, tally, bond-line strength or assigned design values, shall be based on the applicable requirements within this section of the standard, and by the requirements set forth in the NLGA Standard Grading Rules for Canadian Lumber (See Section 1.2) of this Standard.

Sample selection and testing shall be performed by the agency whose logo appears on the lumber (or by an independent accredited testing organization approved by the original grading Agency). Only certified test equipment calibrated to a national standard and using a process mutually agreed upon by the Agency, the seller, and the buyer shall be used.

**16.2 BENDING STRENGTH AND/OR SHEAR STRENGTH PARALLEL TO GRAIN SAMPLING & EVALUATION**

In the case of a dispute pertaining to bending strength or shear strength parallel to grain or assigned design values, a random sample of the item under complaint shall be obtained as follows:

- a) 80 specimens for the bending modulus of rupture property evaluations to be tested in accordance with Section 9.1 of this Standard in such a way that the compression face is randomly generated;
- b) 80 specimens for the shear strength parallel to grain evaluations to be tested in accordance with Section 9.2 of this Standard.

Testing shall be undertaken in accordance with procedures set forth in Section 9.1 and 9.2 of this Standard using test equipment calibrated to a national standard and certified by an independent accredited testing organization.

Test results of the lumber in dispute shall be assessed as follows:

- a) For the bending modulus of rupture, not more than 6 specimens out of 80 shall have an MOR value that is less than the corresponding 5<sup>th</sup> percentile value as provided in Table 2 for the grade and size.
- b) For the shear strength parallel to grain, not more than 6 specimens out of 80 shall have a shear parallel to grain strength value that is less than the corresponding 5<sup>th</sup> percentile value as provided in Table 2 for the grade and size.

## APPENDICES

### APPENDIX I - PRESSURE-VACUUM-DRY TREATMENT

Specimens shall be subjected to the following pressure-vacuum-dry treatment, which is a modification of Method B of ASTM D1101.

#### Procedures

If the initial moisture content of the test specimens is 20% or more, dry the specimens using air at a temperature of  $160^{\circ}\text{F} \pm 5^{\circ}$  ( $71\text{C} \pm 3^{\circ}$ ) to an initial moisture content of 19% or less.

Place the test specimens in the pressure vessel and weight them down. Admit sufficient water at a temperature of  $65^{\circ}$  to  $85^{\circ}\text{F}$  ( $18.3^{\circ}$  to  $29.4^{\circ}\text{C}$ ), so that the test specimens are completely submerged.

Separate the test specimens by stickering, wire screens or other means so that all end grain surfaces are freely exposed to water.

Draw a vacuum of 20" to 25" (508 to 635mm) of mercury and hold it for 30 minutes, then release the vacuum and apply a pressure of  $75 \pm 5$  psi ( $0.520 \pm 0.034$  MPa) for a period of two hours.

Dry the test specimens using air at a temperature of  $160^{\circ} \pm 5^{\circ}\text{F}$  ( $71^{\circ} \pm 3^{\circ}\text{C}$ ). The air circulation and number of specimens in the oven at any time shall be selected such that the specimens are dried to moisture content of 19% or less.

During drying, place the specimens at least 2" (50mm) apart, with the end grain surfaces and bonded face orientation parallel to the direction of airflow.

Dry the specimens until the moisture content (MC) of each specimen has reached 19% or less.

### APPENDIX II - BLOCK SHEAR TEST SPECIMEN SIZE

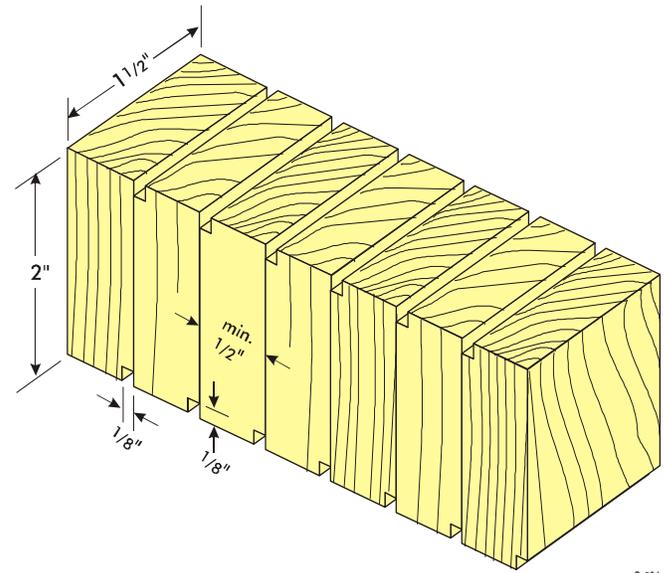


FIGURE 1 - STRAIGHT BLOCK WITH SAW KERF

The test specimen shall be tested in a jig that firmly holds the specimen against a flat surface while the shear force is applied along each bondline (see for example Figure 2).

The saw kerfs shall be positioned as shown in Figure 2.

**Note:** The ASTM D905 shear test jig may be used provided the specimen is suitably supported on the underside.

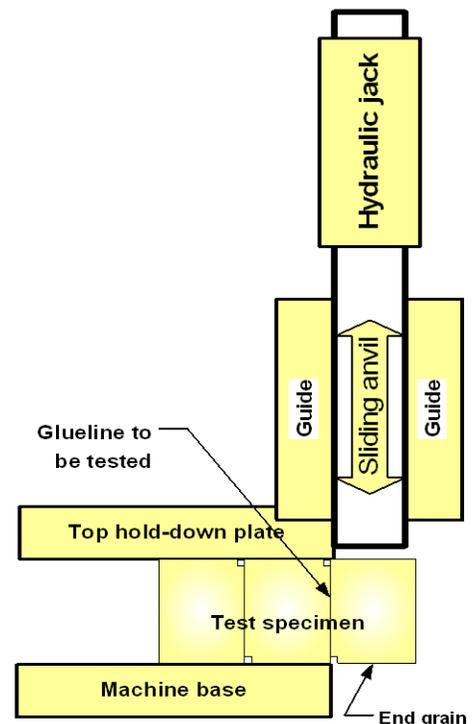


FIGURE 2 - CROSS-SECTION OF TYPICAL STRAIGHT BLOCK SHEAR TEST JIG

APPENDIX III – “OUT-OF-CONTROL” FLOW CHART FOR BENDING STRENGTH

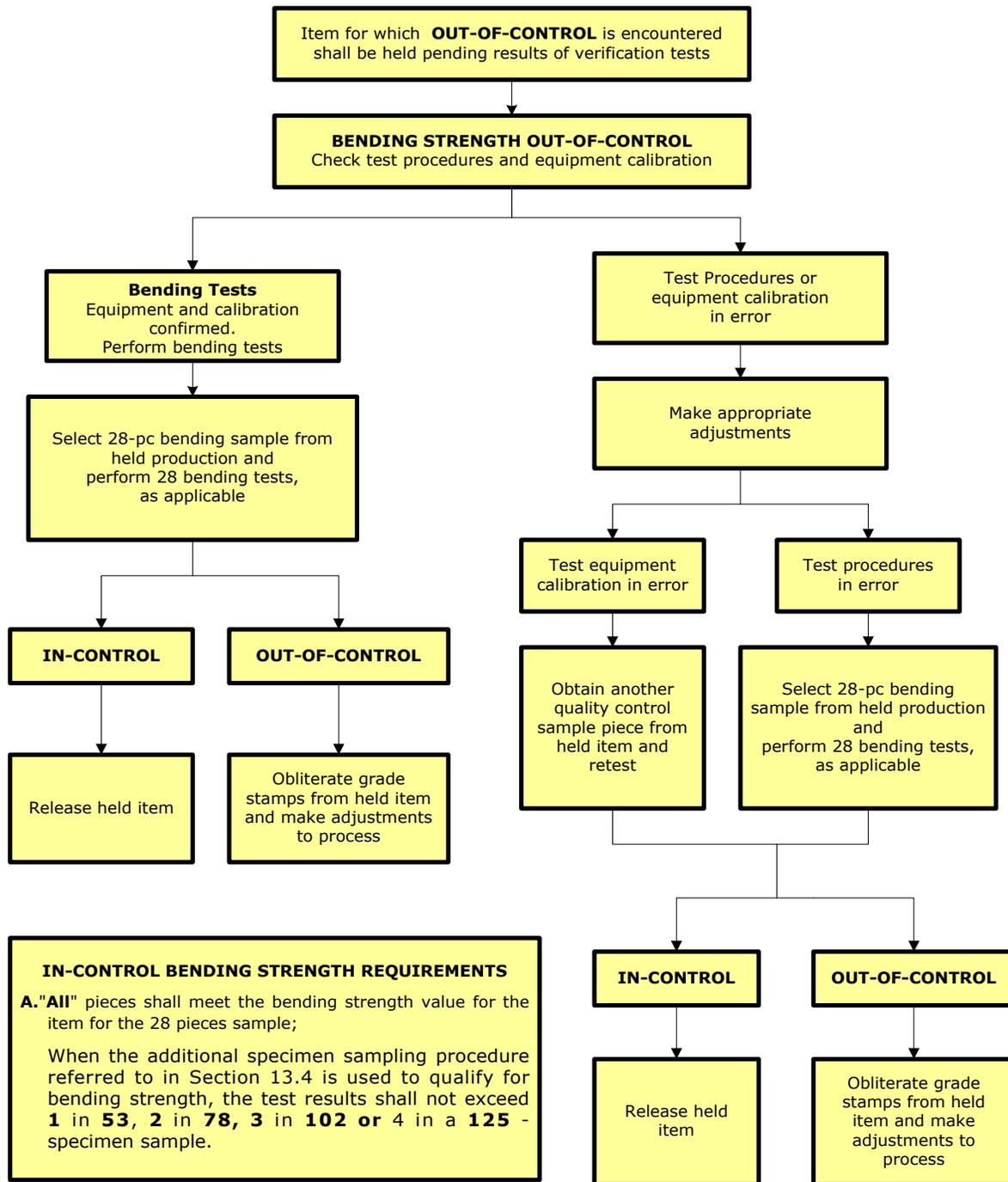
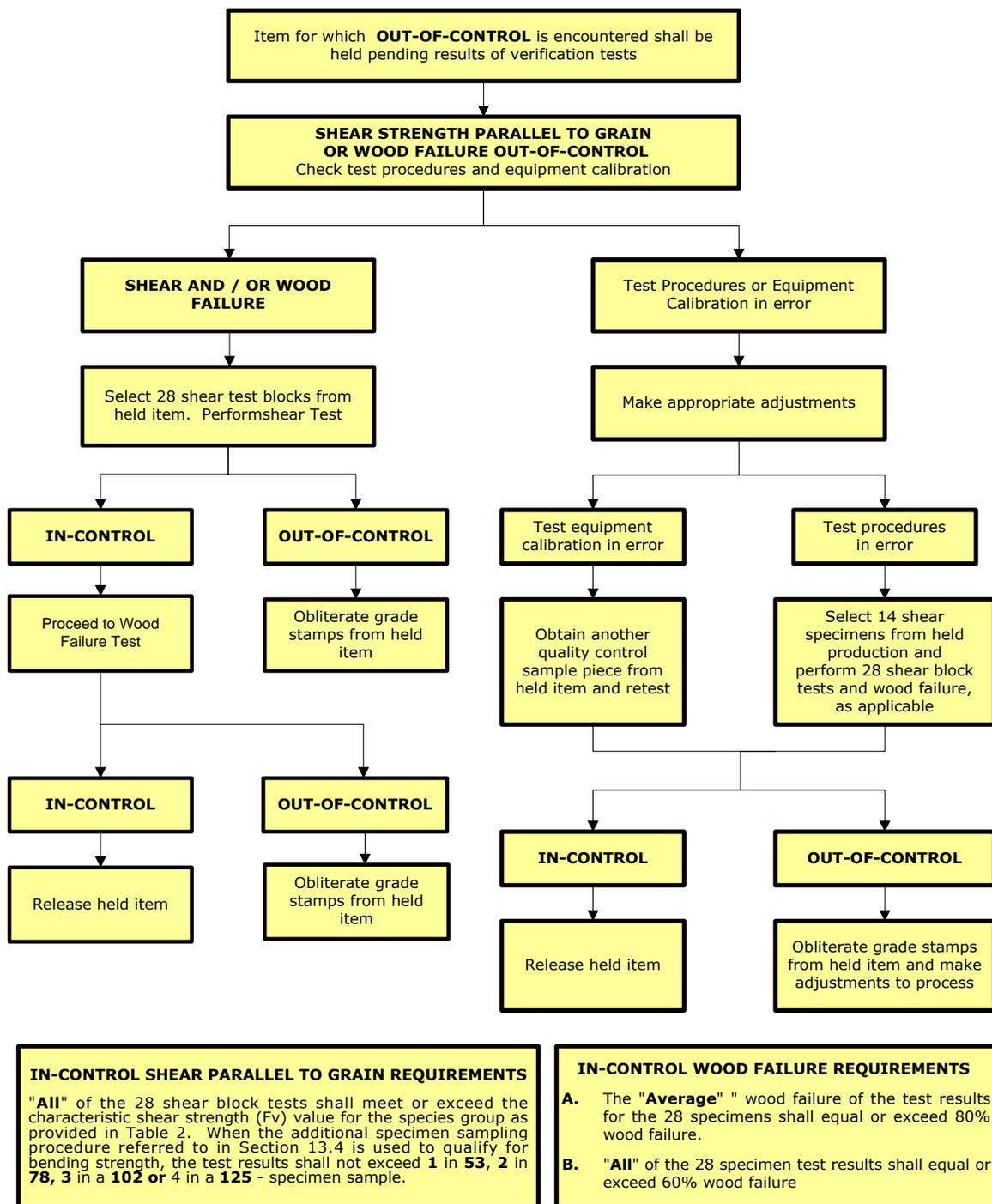


FIGURE 3 - BENDING STRENGTH FAILURE VERIFICATION FLOW CHART

**APPENDIX IV – “OUT-OF-CONTROL” FLOW CHART FOR SHEAR PARALLEL TO GRAIN OR WOOD FAILURE**



**FIGURE 4 - SHEAR PARALLEL TO GRAIN AND WOOD FAILURE VERIFICATION FLOW CHART**

## APPENDIX V - QUALITY CONTROL MANUAL CONTENTS

The Quality Control Manual (Plant Standard) is a written description of the manufacturing operation, broken down by station.

For each station in the sequence of manufacture, a description is required of the function performed by the equipment, the skills the operator requires, the responsibility of the operator in charge of that station, and (if required) what checks are instituted to ensure that the equipment and operator are performing within the desired limits.

Examples of typical stations are:

- a) **Input grading:** a station where defects are removed from the ends of the lumber prior to machining of the fingerjoint;
- b) **Machining of the fingerjoints and/or the bonded face:** this station would be concerned primarily with set-up tolerances and criteria for changing cutter heads;
- c) **Glue mixing:** this station would be concerned with measuring the prescribed proportions of adhesive and hardener, ensuring thorough blending at the prescribed temperature levels;
- d) **Make-up station:** this station may consist of top dead rolls mounted above the in-feed table (ahead of the crowder and retard system). It provides assistance to the operator with assembly of the joint.

The Quality Control Manual provides details of all test procedures used, the wood failure criteria used (if any) and the records to be kept of in-process checks that are made. The details of the Quality Control Manual will vary with the process used. Some aspects of it may be common to all lumber sizes, grades and species groupings, while other aspects may vary with size, grade and species.

An important part in the Quality Control Manual is special provisions for shut down and start-up of the gluing line, particularly during temporary stoppages. The latter is of particular significance in preheat processes, in which the glue may be spread on heated wood, and has to be put under gluing pressure within a limited time to avoid pre-cure of the glue.

Another important section covers the provisions made for the absence of any operator with specialized skills essential to the process.

In general, the Quality Control Manual specifies, in writing, one or more sets of facility operating conditions that are known to result in a product that is in continuous conformance with the requirements of this Standard. The qualification applies only to product(s) produced within the specified limits of the Quality Control Manual.

## APPENDIX VI - THE USE OF WOOD FAILURE ASSESSMENT IN PROCESS CONTROL

Wood failure is a mandatory requirement of this Standard. However Section 7.4.1 requires that sufficient glue must be applied to the joint.

Trained personnel should be able to read single blocks from a standard set with an accuracy of  $\pm 15\%$ , and be within  $\pm 5\%$  of the average for the set.

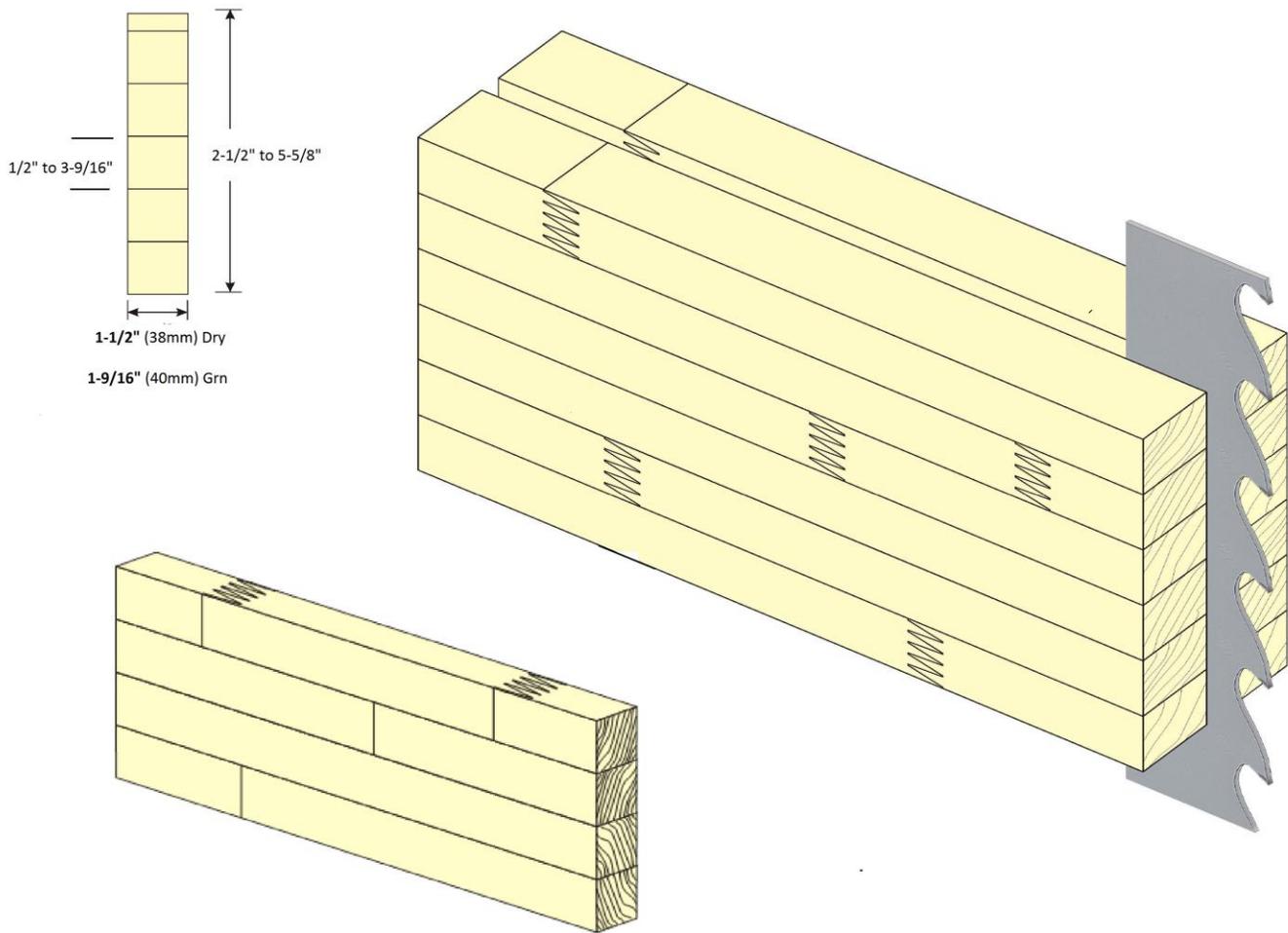
## APPENDIX VII - AGENCY ADMINISTRATION

This Standard shall be administered by an accredited Agency. Agency approval of a facility to grade stamp face-glued lumber shall be contingent upon the facility's compliance with the procedures and requirements of this Standard.

Inspections shall include amongst other things reporting on the following:

- a) Examination of samples from the facility's inventory, the facility's records and procedures, to verify compliance to the requirements of Part A of this Standard and the Plant Standard.
- b) Examination of the shear test equipment including observations on:
  - i) wear and damage;
  - ii) lubrication and operations of moveable parts;
  - iii) record of weekly calibration
- c) Examination of the test equipment, including the apparatus for measuring temperature, pressure and time, and the drying chamber.
- d) Inspection of the glue mixing equipment and procedures, including the accuracy of the weighing equipment, mixing proportions, and cleanliness of the facility.
- e) Verification of the wood failure measurement and procedures.
- f) Examination of the control system used to prevent overheating of the wood in the gluing surface.

**APPENDIX VIII - EXAMPLES OF CROSS-SECTIONS FALLING WITHIN THE SCOPE OF SPS 5**



**General Instruction No. 1**

**NLGA - SPS 5**

**Nov 5, 2015**

NLGA Special Product Standard "SPS 5" consists of **21 pages**, each dated "**Revised Nov 5, 2015**"

This Standard, like all NLGA Standards, is subject to periodic review and may be amended from time to time.

Check the publication section of our website ([www.nlga.org](http://www.nlga.org)) for the latest edition date of NLGA SPS 5.