



SPECIFICATION FOR INSPECTION AND APPROVAL OF PAINTED/PRIMED TRIM MOULDING (v.2022-10-26)

SUBSTRATE: Generally Radiata Pine (Pinus Radiata) from Chile, New Zealand or Australia, or Taeda Pine (Pinus Teada) or Elliotis Pine (Pinus Elliotis) from Brazil - unless other substrate agreed to in advance with the end-user.

KNOTS: A clear (knot-free) is available by special order. Standard grade product will be approximately 90% free of knots. Maximum knot size on any width substrate is 20mm. It must be noted that on narrow widths that knot diameters will be substantially less... and in most cases the product will be free of knots. Regardless of the presence of any knot - or any other defect in the wood - the repair and coating over any knot must completely and attractively mask the presence thereof. The final appearance of any painted/primed product supplied must match that of a product made from a smoothly sanded clear substrate.

MOISTURE CONTENT: 8 to 12 percent - by Kiln Drying.

MILLING TOLERANCES FOR RAW (UN-COATED/UNPAINTED) MOULDINGS: The tolerance coming off of the molder will be: Minus 0.1mm / Plus 0.1mm. HOWEVER: this raw wood will pick up moisture from the air and expand in size. So... the written tolerance that will be allowed during our inspections will be: Minus 0.2mm / Plus 0.38mm

TOLERANCE IN BOW AND CROOK: Maximum deviation shall not be greater than 1.50mm over a 1 meter length. Any deviation from the straight and level plane must be easily manipulated by hand during installation of the product, and the product must remain completely straight following installation.

TOLERANCE IN TWIST: Essentially zero. Again, any deviation - regardless of how slight - from the straight and level plane must be easily manipulated by hand during installation of the product.

TOTAL THICKNESS OF ANY PRIMER/PAINT COATINGS: For product with Primer Only: Thickness of the Primer will be approximately: 0.0012" (0.03mm) For product with Primer AND Paint: The Combined Thickness of both coatings will be approximately: 0.003" (0.075mm) Regardless of the thickness of any paint or coating - the controlling factor for quality will always be a uniform and attractive coating. There could potentially be an occasional piece that receive an extra coating of paint to assure a high quality appearance and this would create a slightly thicker coating.



TOTAL THICKNESS OF FINAL COMBINED COATINGS FILLER/PRIMER/PAINT: The total thickness of ALL coatings that are placed over the substrate will be between 0.008" and 0.015" (0.2mm and .038mm) Approximately 80% of pieces will be less than 0.008" (0.2mm)

TOLERANCE IN THICKNESS AND WIDTH (INCLUDES PRIMER AND PAINT): Total thickness of the filler AND primer AND/OR Paint will be 0.2mm on 80% of the pieces and no pieces will be thicker than 0.38mm.

GLOSS LEVEL TOLERANCE: Our specification at the time of inspection and testing will be: +/- 3. Important Note: It is our understanding that water based gloss paint will lose between 5% and 7% during the time period of 6 to 10 weeks after application. Customers requiring a specific Gloss Level - measured 6 to 10 weeks after production - should account for this by ordering a product that is approximately 5 points higher in gloss than the Gloss Level measured at the time of inspection in China.

TOLERANCE IN LENGTH: All pieces will be manufactured to a "Minus Zero" tolerance in length. Maximum "plus" tolerance in length shall not exceed: Plus .015" (3.8mm). Random testing should find that 85% of pieces will be within a Plus .08" (2.0mm) of the stated length.

OTHER ITEMS OF NOTE:

- * Extruded Coating allowed on four sides - but not required.
- * Finish Sanded and top-coat on the product face and edges.
- * Back Surface to be evenly and completely coated (Painted Primer not required on S3S products.)
- * Slight Chain marks on the back side is not a defect.

ADDITIONAL NOTE: The standard for determining the quality of the final finish shall be: defects in primer or paint - and/or the natural characteristics or defects found in wood products - shall not be visible to a person with average vision when the product is viewed at arms-length.