

QUALITY GUIDELINE – FINISHED GOODS, WOOD

These standard guidelines should at all times be adhered to unless a specification is provided or other is agreed in writing between supplier and PalletBiz.

1. Tolerances:

- Thickness of top, cross and bottom boards should be within the tolerances provided in the product specifications. If no tolerances are given to the current order/product specification, then all tolerances should be kept on the level -0/+2 mm.
- Sizes of blocks/stringers should be within the tolerances mentioned in specifications. If no tolerances are given to the current order/product specification, then all tolerances should be kept on the level -0/+2 mm.
- Overall length and width of the pallet/wooden packaging should not exceed +/- 3 mm. considering the tolerances given in the product specification.

2. Nailing:

- Nails should be quality ring nails as default
- Protruding / Nails sticking out is not allowed
- The number of nails should be as per specification and evenly positioned. As default, 3 nails are used in the blocks and 2 nails elsewhere unless other is clearly specified.

3. Stamping:

If stamping is required, these must be 100 % visible as per requirements for the receiving and/or inspecting party; whether it is IPPC Heat-Treatment stamps or other. Both digital printing and burn marks are acceptable as long as it is readable and either black or dark blue. Visible on both sides of the product.

4. Cracks:

Major cracks in the elements >100 mm visible at the end of the board and from both sides of the board.

5. Moisture level:

Moisture level of the wooden packaging should not exceed 22 % in case of Kiln Dried (KD) material, unless other moisture content is clearly specified. In case of overseas (container) shipments, the maximum content should be 15%.

6. Bending and twisting of elements:

Bending and twisting elements in angles cannot exceed 15 degrees.

7. Knots:

- Knots are permissible without limitation when the diameter is a maximum of 10 mm.
- Knots with a diameter of more than 10 mm are permissible if the knots have intergrown to a minimum of ¼ of their circumference and
- The diameter of a knot along every length of a board corresponding to the board width does not exceed ¼ of the board width on stringers and ⅓ of the board width on other boards
- The sum of the diameters of several knots along every length of a board corresponding to the board width does not exceed ⅓ of the board width on stringers and of the board width on other boards.
- Knots with a diameter of maximum 10 mm shall not be included in the calculated sum of the knot diameters.

8. Round edge/Wane:

Wane is not permitted on stringers, central bottom boards, and on the outer edges of outer deck boards and outer bottom boards.

9. General appearance of elements:

No fungus, bark, rot or insect holes is allowed in the packaging. No excess saw dust or other substance is allowed.

If more than 5% of the delivery will be rejected during entry control – PalletBiz keep the right to reject the full load. If more than 3 deliveries will be fully rejected due to non-conformities, PalletBiz keep the right to significantly decrease or cancel the PO's from supplier in question.