DIN EN 14081-2:2022-08 (E)

Timber structures - Strength graded structural timber with rectangular cross section - Part 2: Machine grading; additional requirements for type testing (includes Amendment A1:2022)

Contents

Page

European foreword 4

Introduction 6

1 Scope 7

2 Normative references 7

3 Terms and definitions 7

4 Symbols and abbreviations 9

5 Requirements for strength grading machines 10

6 Derivation of settings for machine control systems 11
6.1 Requirements on sampling 11
6.2 Requirements for grading process, destructive testing and calculation of grade determining properties 12
6.2.1 Grading process 12
6.2.2 Destructive testing 12
6.2.3 Calculations of grade determining properties 12
6.3 Requirements for a setting area 13
6.3.1 General 13
6.3.2 Standardized areas 13
6.4 Requirements for the derivation and verification of machine settings 13
6.4.1 Derivation of machine settings 13
6.4.2 Verification of machine settings 14
6.5 Fixed settings 16
6.6 Reporting 16

7 Additional verification requirements for a new grading machine or a change in scope of existing grading machines for machine control systems 18
7.1 Repeatability 18
7.2 Machine installation check 18

8 Derivation of settings for output control systems 19
8.1 General 19
8.2 Initial machine settings 19
8.3 Verification of machine settings 19
8.3.1 Sampling 19
8.3.2 Destructive testing and calculation of characteristic values 19
8.3.3 Requirements for verification of machine settings 19
8.4 Report 19

9 Requirements for adaptive settings 20
9.1 Method 20
9.2 Conditions 21

Annex A (informative) Guidelines for sampling a growth area for deriving machine settings 22

Annex B (informative) Prediction limit method 23

B.1 General 23
B.2 Model determination 23
B.3 Settings calculation 24

Annex C (normative) Determination of the global cost matrix 25

C.1 Introduction 25
C.2 Optimum grading 25
C.3 IP grading 25
C.4 Calculation of size matrix 26
C.5 Calculation of elementary cost matrix 26
C.5.1 Introduction 26
C.5.2 Factors for wrongly upgraded pieces 26
C.5.3 Factors for wrongly downgraded pieces 27
C.5.4 Examples of elementary cost matrices for C, T and D classes 27
C.6 Calculation of a global cost matrix 30

Annex D (informative) Settings for C and T-classes 31

Bibliography 36