

<b>Report No.</b> <b>ITT/109/20/09</b>	<b>INITIAL TYPE TESTING REPORT</b> This ITT report contains revised and/or additional grading machine settings to those given in EN 14081-4:2009.	<b>DATE OF ISSUE</b> March 2014
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Note. ITT reports for EN 14081-4 are numbered using the initials ITT followed by three numbers separated by slashes. The first number denotes the number of each report in chronological order. The second number denotes the number for the particular type of grading machine as given in EN 14081-4:2009. The third number gives the report number for the type of machine in chronological order.

## GRADING MACHINE

The settings in this ITT report are relevant to the **ViSCAN-PLUS** timber strength grading machine.

## MANUFACTURER

The manufacturer of the ViSCAN-PLUS timber grading machine is:

MiCROTEC s.r.l. - GmbH  
Via Julius Durst 98  
39042 Bressanone (BZ)  
Italy

## REFERENCE

Clause 5 of EN 14081-4:2009 contains the following paragraph:

‘The accepted grading machines and settings in this European Standard are based on initial type testing (ITT) and initial type calculation (ITC). When additional ITT and ITC documentation from the manufacturers has been evaluated by CEN/TC124/TG1 and the accepted values are given in an ITT report, which is the basis for certification by the Notified Bodies overseeing the producers factory production control (FPC). Those ITT reports may be used as ITT documentation before the information they contain becomes available in an amendment or revision of this European Standard, EN 14081-4.’

This ITT report is one of a number of reports to which the above paragraph refers and may therefore be used as documentation prior to a further revision of EN 14081-4, or until it is superseded by a later dated ITT report for the same grading machine.

## CHANGES TO SETTINGS LISTED IN EN 14081-4:2009

The settings listed in the following tables 20-1 to 20-17 which are the subject of the research report listed in the table titles, have been assessed by CEN TC124/WG2/TG1 and are approved for use in the production of structural timber to EN 14081-1 from the date of this ITT report.

The existing tables 20-1 to 20-4 given in ITT/16/20/01 and tables 20-1 to 20-4 given in ITT/30/20/02 and tables 20-1 to 20-5 given in ITT/36/20/03 and tables 20-1 to 20-7 given in ITT/52/20/04 and tables 20-1 to 20-7 given in ITT/58/20/05 and tables 20-1 to 20-11 given in ITT/67/20/06 and tables 20-1 to 20-13 given in ITT/82/20/07 and tables 20-1 to 20-13 given in ITT/97/20/08 are superseded by the tables given in this ITT report. Tables 20-14 to 20-17 are new tables.

On behalf of CEN TC 124/TG1  
Signature of convenor

Date     March 2014

**Table 20-15 — Settings for ViSCAN-PLUS (Model given in TG1/201403/12) (continued)**

Source country or countries	Source mark <sup>a</sup>	Species	Permitted timber size <sup>b</sup> (mm)	Grade <sup>c</sup> or grade combination	Model value			Comments and additional requirements
						E <sub>mod</sub>		
Austria Czech Republic Germany Finland Poland Romania Russia <sup>e</sup> Sweden Slovakia Ukraine	AT CZ  DE FI PL RO RU SE SK UA	Norway spruce <i>Picea abies</i>  Sliver fir <i>Abies alba</i>	27 ≤ t <sub>n</sub> ≤ 66 63 ≤ b <sub>n</sub> ≤ 319	T26 T18 T11  T26 T14  T24 T14 T10  T22 T14 T11  T22 T14 T10  T22 T13  T21 T13  T21 T11		13 700 10 800 7 200  13 700 8 000  12 700 9 000 7 200  12 400 9 900 7 700  12 000 9 800 7 200  12 000 7 800  11 300 8 300  11 300 6 600		Requirements for grading: – Timber temperature: > -10°C. – If the timber temperature is between -10°C and -20°C then E <sub>mod</sub> shall be adjusted to be more conservative by 2%. – Whenever the machine uses the measured moisture content and adjusts the indicating property for each individual piece, the moisture content of each piece shall be between 4% and 24% otherwise, the mean moisture content of the batch shall be between 8% and 24%, and all individual pieces in the batch may not fall four percentage points below the mean value. – High moisture content (HMC20) option <sup>d</sup> : The moisture content of each piece > 20% and timber temperature > 0°C. – Maximum feed speed: 180 pieces/min – Timber surface planed or sawn.  <i>Picea abies</i> and <i>Abies alba</i> are processed together in Europe, and this species combination is referred to WPCA according to EN 14081-1.  The same settings apply if the following machine operates in ViSCAN-PLUS mode: GoldenEye-706.

<sup>a</sup> Code identifying the country or region of origin in accordance with EN ISO 3166-1.

<sup>b</sup> Timber size shall be to EN 336.

<sup>c</sup> Grades prefixed by T are tensile strength classes given in EN 14080.

<sup>d</sup> This requires the machine to have the appropriate software (HMC20 – TG1/0609/17).

<sup>e</sup> Settings apply only to timber grown west of the Urals and north of the 55 degree line of latitude.

**Table 20-16 — Settings for ViSCAN-PLUS (Model given in TG1/201403/12) (continued)**

Source country or countries	Source mark <sup>a</sup>	Species	Permitted timber size <sup>b</sup> (mm)	Grade <sup>c</sup> or grade combination	Model value			Comments and additional requirements
						E <sub>mod</sub>		
Austria	AT	Norway spruce <i>Picea abies</i>	27 ≤ t <sub>n</sub> ≤ 66 63 ≤ b <sub>n</sub> ≤ 319	T18		10 100		<p>Requirements for grading:</p> <ul style="list-style-type: none"><li>– Timber temperature: &gt; -10°C.</li><li>– If the timber temperature is between -10°C and -20°C then E<sub>mod</sub> shall be adjusted to be more conservative by 2%.</li><li>– Whenever the machine uses the measured moisture content and adjusts the indicating property for each individual piece, the moisture content of each piece shall be between 4% and 24% otherwise, the mean moisture content of the batch shall be between 8% and 24%, and all individual pieces in the batch may not fall four percentage points below the mean value.</li><li>– High moisture content (HMC20) option <sup>d</sup>: The moisture content of each piece &gt; 20% and timber temperature &gt; 0°C.</li><li>– Maximum feed speed: 180 pieces/min</li><li>– Timber surface planed or sawn.</li></ul> <p><i>Picea abies</i> and <i>Abies alba</i> are processed together in Europe, and this species combination is referred to WPCA according to EN 14081-1.</p> <p>The same settings apply if the following machine operates in ViSCAN-PLUS mode: GoldenEye-706.</p>
Czech Republic	CZ			T11		7 700		
Germany	DE	Sliver fir <i>Abies alba</i>		T16		9 100		
Finland	FI			T8		6 500		
Poland	PL			T14		7 500		
Romania	RO			T13		6 500		
Russia <sup>e</sup>	RU							
Sweden	SE							
Slovakia	SK							
Ukraine	UA							

<sup>a</sup> Code identifying the country or region of origin in accordance with EN ISO 3166-1.

<sup>b</sup> Timber size shall be to EN 336.

<sup>c</sup> Grades prefixed by T are tensile strength classes given in EN 14080.

<sup>d</sup> This requires the machine to have the appropriate software (HMC20 – TG1/0609/17).

<sup>e</sup> Settings apply only to timber grown west of the Urals and north of the 55 degree line of latitude.

**Table 20-17 — Settings for ViSCAN-PLUS (Model given in TG1/201403/20) (continued)**

Source country or countries	Source mark <sup>a</sup>	Species	Permitted timber size <sup>b</sup> (mm)	Grade <sup>c</sup> or grade combination	Model value			Comments and additional requirements
						E <sub>mod</sub>		
Finland Poland Sweden	FI PL SE	Scots pine <i>Pinus sylvestris</i>	32 ≤ t <sub>n</sub> ≤ 55 86 ≤ b <sub>n</sub> ≤ 220	T26		13 400		Requirements for grading: – Timber temperature: > -10°C. – If the timber temperature is between -10°C and -20°C then E <sub>mod</sub> shall be adjusted to be more conservative by 2%. – Whenever the machine uses the measured moisture content and adjusts the indicating property for each individual piece, the moisture content of each piece shall be between 4% and 24% otherwise, the mean moisture content of the batch shall be between 8% and 24%, and all individual pieces in the batch may not fall four percentage points below the mean value. – High moisture content (HMC20) option <sup>d</sup> : The moisture content of each piece > 20% and timber temperature > 0°C. – Maximum feed speed: 180 pieces/min – Timber surface planed or sawn.  The same settings apply if the following machine operates in ViSCAN-PLUS mode: GoldenEye-706.
				T14		9 600		
				T10		6 900		
				T24		12 600		
				T14		10 300		
				T10		6 900		
				T24		12 600		
				T13		8 100		
				T22		11 000		
				T13		9 500		
				T21		10 800		
				T11		6 900		
				T18		9 700		
T10		6 900						
T16		9 400						
T10		6 900						
T14		7 600						
T13		6 900						
<sup>a</sup> Code identifying the country or region of origin in accordance with EN ISO 3166-1. <sup>b</sup> Timber size shall be to EN 336. <sup>c</sup> Grades prefixed by T are tensile strength classes given in EN 14080. <sup>d</sup> This requires the machine to have the appropriate software (HMC20 – TG1/0609/17).								