

Report No. ITT/111/05/09	INITIAL TYPE TESTING REPORT This ITT report contains revised and/or additional grading machine settings to those given in EN 14081-4:2009.	DATE OF ISSUE 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 **GoldenEye-702** timber strength grading machine.

MANUFACTURER

The manufacturer of the GoldenEye-702 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paragraph refers and may therefore be used as documentation prior to a further revision of EN 14081-4, or until it is superseded by a later dated ITT report for the same grading machine.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 5-1 to 5-27, which are the subject of the research reports 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 5-1 to 5-10 in EN 14081-4 and tables 5-1 to 5-13 in ITT/02/05/01 and tables 5-1 to 5-15 in ITT/22/05/02 and tables 5-1 to 5-15 in ITT/33/05/03 and tables 5-1 to 5-16 in ITT/37/05/04 and tables 5-1 to 5-17 in ITT/54/05/05 and tables 5-1 to 5-19 in ITT/69/05/06 and tables 5-1 to 5-21 in ITT/84/05/07 and tables 5-1 to 5-21 are superseded by the tables given in this ITT report. Tables 5-22 to 5-27 are new tables.

On behalf of CEN TC 124/TG1

Signature of convener



Date March 2014

Table 5-24 — Settings for GoldenEye-702 (Model given in TG1/201403/11rev) (continued)

Source country or countries	Source mark ^b	Species	Permitted timber size ^c (mm)	Grade ^d or grade combination	Model value			Comments and additional requirements
					f _{mod}	E _{mod}	ρ _{mod}	
Austria	AT	Norway spruce <i>Picea abies</i>	27 ≤ t _n ≤ 66 63 ≤ b _n ≤ 319	T28	40,8	12 700	422	Requirements for grading: – Timber temperature: > -20°C. – Whenever the machine uses the measured moisture content and adjusts the settings model 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 20%, and all pieces in the batch shall not deviate by more than four percentage points from the mean. – Maximum feed speed: 450 m/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 GoldenEye-702 mode: GoldenEye-706.
Czech Republic	CZ			T18	29,2	9 000	374	
Germany	DE			T11	8,0	4 100	296	
Finland	FI	Sliver fir <i>Abies alba</i>		T28	40,8	12 700	422	
Poland	PL			T16	21,5	6 300	360	
Romania	RO			T11	12,3	4 100	296	
Russia ^e	RU			T26	39,1	11 500	409	
Slovakia	SK			T18	29,4	9 300	374	
Ukraine	UA			T11	8,0	4 100	296	
				T26	39,1	11 500	409	
				T14	15,6	4 100	309	
				T24	35,6	10 800	397	
				T14	21,4	6 700	323	
				T10	12,6	4 100	296	
				T22	32,1	10 000	385	
				T14	19,7	8 800	333	
				T11	16,0	7 100	296	

^a These settings are approved to permit each piece of timber to be graded as if it is two pieces of timber of smaller widths. The timber is subsequently cut lengthwise into two pieces with the correct grade marked on each piece. This requires the machine to have the appropriate software, and the timber sizes before and after grading, to be as required by that software. The sizes of the two pieces after splitting must be within the permitted timber size. This note is valid for all approved source countries and species for this machine.

^b Code identifying the country or region of origin in accordance with EN ISO 3166-1.

^c Timber size shall be to EN 336.

^d Grades prefixed by T are tensile strength classes given in EN 14080.

^e Settings apply only to timber grown west of the Urals and north of the 55 degree line of latitude.

Table 5-25 — Settings for GoldenEye-702 (Model given in TG1/201403/11rev) (continued)

Source country or countries	Source mark ^b	Species	Permitted timber size ^c (mm)	Grade ^d or grade combination	Model value			Comments and additional requirements
					f _{mod}	E _{mod}	ρ _{mod}	
Austria Czech Republic Germany Finland Poland Romania Russia ^e Slovakia Ukraine	AT	Norway spruce <i>Picea abies</i>	27 ≤ t _n ≤ 66 63 ≤ b _n ≤ 319	T22	32,1	10 000	385	Requirements for grading: – Timber temperature: > -20°C. – Whenever the machine uses the measured moisture content and adjusts the settings model 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 20%, and all pieces in the batch shall not deviate by more than four percentage points from the mean. – Maximum feed speed: 450 m/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 GoldenEye-702 mode: GoldenEye-706.
	CZ			T14	25,5	8 800	333	
				T10	8,0	4 100	296	
	DE	Sliver fir <i>Abies alba</i>		T22	32,1	10 000	385	
	FI			T13	14,2	4 100	296	
	PL			T21	30,4	10 000	385	
	RO			T13	15,3	4 100	296	
	RU			T21	30,4	10 000	385	
	SK			T11	8,0	4 100	296	
	UA			T18	25,5	6 900	372	
				T11	8,0	4 100	296	
				T16	20,8	4 100	359	
				T8	8,0	4 100	296	
				T14	14,4	4 100	296	
				T13	8,0	4 100	296	

^a These settings are approved to permit each piece of timber to be graded as if it is two pieces of timber of smaller widths. The timber is subsequently cut lengthwise into two pieces with the correct grade marked on each piece. This requires the machine to have the appropriate software, and the timber sizes before and after grading, to be as required by that software. The sizes of the two pieces after splitting must be within the permitted timber size. This note is valid for all approved source countries and species for this machine.

^b Code identifying the country or region of origin in accordance with EN ISO 3166-1.

^c Timber size shall be to EN 336.

^d Grades prefixed by T are tensile strength classes given in EN 14080.

^e Settings apply only to timber grown west of the Urals and north of the 55 degree line of latitude.

Table 5-26 — Settings for GoldenEye-702 (Model given in TG1/201403/19) (continued)

Source country or countries	Source mark ^b	Species	Permitted timber size ^c (mm)	Grade ^d or grade combination	Model value			Comments and additional requirements
					f _{mod}	E _{mod}	ρ _{mod}	
Finland Poland Sweden	FI PL SE	Scots pine <i>Pinus sylvestris</i>	32 ≤ t _n ≤ 55 86 ≤ b _n ≤ 220	T26	35,2	11 600	<div>Requirements for grading:</div> <div><div>– Timber temperature: > -20°C.</div><div>– Whenever the machine uses the measured moisture content and adjusts the settings model 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 20%, and all pieces in the batch shall not deviate by more than four percentage points from the mean.</div><div>– Maximum feed speed: 450 m/min.</div><div>– Timber surface planed or sawn.</div></div> <div>The same settings apply if the following machine operates in GoldenEye-702 mode: GoldenEye-706.</div>	
				T14	27,1	9 000		
				T10	6,6	6 400		
				T24	33,9	11 000		
				T13	12,6	6 400		
				T22	29,5	10 400		
				T13	23,2	6 800		
				T21	29,3	10 400		
				T11	6,6	6 400		
				T18	22,9	8 200		
				T10	6,6	6 400		
				T16	19,7	6 500		
T10	7,5	6 400						
T14	9,2	6 400						
T13	6,6	6 400						

^a These settings are approved to permit each piece of timber to be graded as if it is two pieces of timber of smaller widths. The timber is subsequently cut lengthwise into two pieces with the correct grade marked on each piece. This requires the machine to have the appropriate software, and the timber sizes before and after grading, to be as required by that software. The sizes of the two pieces after splitting must be within the permitted timber size. This note is valid for all approved source countries and species for this machine.

^b Code identifying the country or region of origin in accordance with EN ISO 3166-1.

^c Timber size shall be to EN 336.

^d Grades prefixed by T are tensile strength classes given in EN 14080.