Artimber®

Emerging · Enhancing · Evolving

MACHINING TOLERANCE

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All Artimber Engineered Timber Flooring should be handled with care and remain in unopened packs until installed. Inspection on the parameters below should only be done immediately after boards have been removed from packaging.

- **Net length deviation of surface layer**

When nominal length $l_n \leq 1500$ mm, the absolute value of the difference between l_n and each measured value l_m is not greater than 1mm. When nominal length $l_n > 1500$ mm, the absolute value of the difference between l_n and each measured value l_m is not greater than 2 mm.

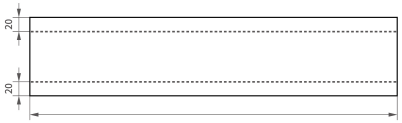

Figure 1 Length (l) measuring diagram

- **Net length deviation of surface layer**

The absolute value of the difference between nominal width w_n and average width w_a is not greater than 0.2 mm. The difference between the maximum width w_{max} and the minimum width w_{min} is not greater than 0.3 mm.

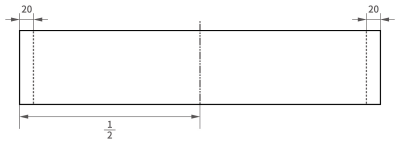

Figure 2 Width (w) measuring diagram

- **Thickness Deviation**

The absolute value of the difference between nominal thickness t_n and average thickness t_a is not greater than 0.5 mm. The difference between the maximum thickness t_{max} and the minimum thickness t_{min} is not greater than 0.5mm

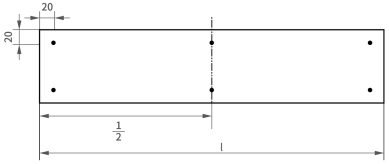

Figure 3 Thickness (t) measuring diagram

- **Squareness**

Lean one side of square ruler against the long side of flooring. Use feeler gauge to measure the maximum distance q_{max} between the other side of square ruler and the end of flooring, accurate to 0.02 mm. See Figure 4.

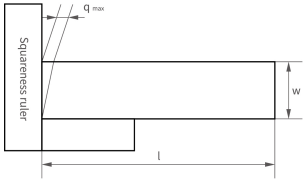

Figure 4 Squareness (q) measuring diagram

- **Edge squareness**

Place flooring on a horizontal test table. Along with the length direction of flooring; lean steel ruler or thin steel rope against two adjacent corners of flooring; use feeler gauge to measure the maximum chord height s_{max} between board side and steel ruler or thin steel rope, accurate to 0.01 mm/m.

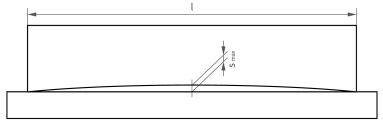

Figure 5 Edge squareness measuring diagram

- **Warpage**

Place the concave of flooring upward on a horizontal test table; lean steel ruler against two long sides of flooring, use feeler gauge to measure the maximum chord height c_{max}, accurate to 0.02 mm. The ratio between the maximum chord height c_{max} and the actual measured width (w) shall be the warpage f_w at the width direction, expressed as percentage, accurate to 0.01%. Measuring position is any corresponding part of the long side, shown in Figure 6. Longitudinally place the flooring on a horizontal test table along with the length direction. Lean steel ruler or thin steel rope against two adjacent corners of flooring; use feeler gauge to measure the maximum chord height (h_{max}). accurate to 0.02 mm/m. The ratio between the maximum chord height h_{max} and the actual measured length (l) shall be the warpage flat the width direction,expressed as percentage, accurate to 0.01%. Measuring position is any corresponding part of the end side, shown in Figure 7.

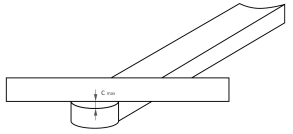

Figure 6 Measuring diagram of warpage (f_w) at the width direction

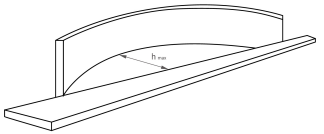

Figure 7 Measuring diagram of warpage (fi) at the length direction

- **Assembling gap and assembling height difference**

Tightly place 10 pieces of flooring in assembly on a flat and horizontal test table according to Figure 8. Use feeler gauge to measure the assembling gap and assembling height difference at 18 points, shown in Figure 8, accurate to 0.02 mm. Respectively calculate the average value, accurate to 0.01 mm.

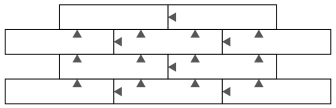

Figure 8 Measuring diagram of assembling gap and assembling height