

# American National Standard

for wood products –  
Structural Glued  
Laminated Timber

Sponsored By

American Institute  
of Timber Construction



# American National Standard

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American National Standards Institute, Inc.  
1430 Broadway  
New York, NY 10018

Published by  
American Institute of Timber Construction  
7012 S. Revere Parkway, Suite 140, Englewood, CO 80112-5092

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Printed in the United States of America

American National Standard  
**for Wood Products –  
Structural Glued  
Laminated Timber**

**Sponsor**

**AMERICAN INSTITUTE OF TIMBER CONSTRUCTION**

**Approved October 10, 2002**

**AMERICAN NATIONAL STANDARDS INSTITUTE, INC.**

**Abstract**

This Standard contains requirements for the production, inspection, testing, and certification of structural glued laminated timber.

**FOREWORD** (This Foreword is not a part of American National Standard ANSI/AITC A190.1-2002)

This Standard is a revision of American National Standard ANSI/AITC A190.1--1992. It contains requirements for the manufacture and quality control of structural glued laminated timber. See Section 9, *History of Project*, for further information.

Development of consensus for this Standard was accomplished by the Canvass method.

Suggestions for improvement of this Standard will be welcome. They should be sent to the American Institute of Timber Construction, 7012 S. Revere Parkway, Suite 140, Englewood, CO 80112-5092

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# Structural Glued Laminated Timber

Effective October 10, 2002 (See Section 8)

This Standard, which was initiated by the American Institute of Timber Construction (AITC), has been developed under the provisions of the American National Standards Institute (ANSI) as a revision of American National Standard, *Structural Glued Laminated Timber* (ANSI/AITC A190.1-1992). See Section 9, *History of Project*, for further information.

## 1. PURPOSE

The purpose of this Standard is to establish nationally recognized requirements for the production, inspection, testing and certification of structural glued laminated timber, and to provide material suppliers, producers, distributors and users with a basis for common understanding of the characteristics of this product.

## 2. SCOPE

This Standard covers minimum requirements for the production of structural glued laminated timber, including sizes and tolerances, grade combinations, lumber, adhesives, appearance grades, and manufacture. It also covers the quality control system for the laminator, plant qualification, daily quality control, and the functions of an accredited inspection and testing agency, and marking. Definitions of words used in the trade are included, as well as guides for specifying and for field reinspection. These requirements are intended to permit the use of any suitable method of manufacture which will produce a product equal to or superior in quality and performance to that specified, provided such method is approved in accordance with the requirements of this Standard.

Annexes are a part of this Standard. Appendices are not a part of this Standard but are recommended and included.

## 3. REFERENCED PUBLICATIONS

Publications referenced in this Standard may be obtained from the organizations indicated. Later issues of publications referenced in the annexes of this standard shall be used only if the Technical Review Board referred to in 7.2 determines that the publication is applicable and consistent with the intent and requirements of this Standard.

- (a) American Institute of Timber Construction  
7012 S. Revere Parkway, Suite 140  
Englewood, CO 80112-5092
- (b) APA – The Engineered Wood Association  
7011 South 19th Street  
Tacoma, WA 98411-0700
- (c) ASTM  
100 Barr Harbor Drive  
West Conshohocken, PA 19428-2959
- (d) Standard Grading Rules (approved by the Board of Review of the American Lumber Standard Committee). See Appendix C.

## 4. REQUIREMENTS

**4.1 General** --- All structural glued laminated timber represented as conforming to this Standard shall meet all of the requirements specified herein, and shall be inspected and tested in accordance with Section 5 and marked in accordance with Section 6. The principal reliance for assuring conformance to this Standard is placed on the manufacturer's continuing quality control of the production operations and periodic inspection thereof by an accredited inspection and testing agency. This quality control system includes:

- (a) A check of each step of the production process,
- (b) Physical tests on samples representing finished production, and
- (c) A visual inspection of the finished production.

**4.2 Sizes and Tolerances** --- The size and shape of the laminated timber shall be as agreed upon between buyer and seller.

**4.2.1 Tolerance for Dimensions** --- The tolerances permitted at the time of manufacture shall be as follows:

**Width** --- Plus or minus 1/16 in.

**Depth** --- Plus 1/8 in. per ft. of depth. Minus 3/16 in. or 1/16 in. per ft. of depth, whichever is larger.

**Length** --- Up to 20 ft., plus or minus 1/16 in. Over 20 ft., plus or minus 1/16 in. per 20 ft. of length or fraction thereof.

**4.2.2 Tolerance for Camber or Straightness** --- The tolerances are applicable at the time of manufacture without allowance for dead load deflection. Up to 20 ft., the tolerance is plus or minus 1/4 in. Over 20 ft. increase tolerance 1/8 in. per each additional 20 ft. or fraction thereof, but not to exceed 3/4 in.

The tolerances are intended for use with straight or slightly cambered members and are not applicable to curved members such as arches.

**4.2.3 Tolerance for Squareness of Cross Section** --- The tolerances shall be within plus or minus 1/8 in. per ft. of specified depth unless a specially shaped section is specified.

## 4.3 Lumber for Laminating

**4.3.1 Species** --- For purposes of this Standard, softwood and hardwood species shall be approved for use in glued laminated timber by a) clear wood strength

values derived by procedures established in ASTM D2555, or b) procedures to establish design stresses for structural glued laminated timber described in ASTM D3737, or c) by criteria proposed by a Technical Advisory Committee and determined to be in conformance with this Standard by the Technical Review Board.

**4.3.2 Sawn Lumber Grading** --- Sawn lumber is visually graded, mechanically graded, or proof graded.

#### **4.3.2.1 Visually Graded Lumber**

Lumber shall be graded under standard grading rules approved by the Board of Review of the American Lumber Standard Committee (ALS), or written special laminating grading rules. See Appendix C for approved grading rules. Such grades of lumber shall be modified, as necessary, to comply with requirements set forth in the laminating specifications for the species as determined by performance criteria proposed by a Technical Advisory Committee and determined to be in conformance with this Standard by the Technical Review Board.

**4.3.2.2 Mechanically Graded Lumber** --- Mechanically graded lumber used in glued laminated timber shall be graded under standard grading rules approved by the Board of Review of the American Lumber Standard Committee or special rules proposed by a Technical Advisory Committee and determined to be in conformance with this standard by the Technical Review Board. E-rated, machine stress rated and machine evaluated lumber are three commercial designations of mechanically graded lumber. Such grades shall be modified, as necessary, according to requirements set forth in the laminating specifications for the species.

**4.3.2.3 Proof Graded Lumber** --- Proof graded lumber is lumber that is qualified for tensile strength by proof testing each piece in tension. Proof testing must be under the supervision of an accredited inspection and testing agency. Such proof graded lumber must be subjected to quality control based on full size tension tests as set forth in AITC 406. Proof testing is limited to individual pieces of lumber without end joints.

**4.3.3 Manufactured Lumber** --- Manufactured lumber is intended primarily for, but not limited to, tension laminations. It consists of 2 or more pieces bonded together in accordance with the requirements set forth in AITC 401. Multiple piece laminations which have been edge bonded are not considered to be manufactured lumber provided they are graded as separate pieces as set forth in 4.3.7.

**4.3.4 Laminated Veneer Lumber (LVL)** --- Laminated veneer lumber used in the production of structural glued laminated timber shall be a product comprised of graded veneers securely bonded together with wet-use adhesives. The grain of all veneers shall be approximately parallel longitudinally. Laminated veneer lumber shall meet the more restrictive requirements of AITC 402 and ASTM D5456 applicable for use in glued laminated timber.

#### **4.3.5 Ripping of Lumber**

- (a) Lumber --- Lumber to be ripped shall be graded so that resulting pieces conform to all applicable grade requirements including knot size, slope of grain and density or rate of growth.
- (b) Mechanically Graded Lumber --- When mechanically graded lumber is ripped, it shall be regraded using the grade determining mechanical or physical property and applicable visual requirements. Proof graded lumber shall be proof tested after ripping to the requirements established for the ripped size. Regrading requirements for mechanically graded and proof graded lumber are permitted to be waived if the modulus of elasticity and tensile strength performance of the ripped pieces are monitored by quality control procedures approved by an accredited inspection and testing agency.
- (c) Ripping After End Jointing --- Ripping is permitted on laminations after end jointing visually graded lumber and on completed members after bonding (resawing) if the procedures are done in accordance with documentation approved by an accredited inspection and testing agency.

**4.3.6 Grade Combinations** --- Grade combinations shall be developed in accordance with ASTM D 3737 or shall be obtained by performance testing and analysis in accordance with recognized standards.

**4.3.7 Laminations** --- All lumber shall be identified by grade prior to bonding. The lumber shall not exceed 2 in. in net thickness. At the time of bonding, variations in thickness across the width of a lamination shall not exceed plus or minus 0.008 in. The variation in thickness along the length of an individual piece of lumber or the lamination shall not exceed plus or minus 0.012 in. The thickness variation shall occur randomly across the width and along the length such that the cumulative effect does not contribute to side-to-side depth variations greater than that allowed in 4.2.1. Warp and cup shall not be so great that they will not be straightened out by pressure in bonding. All bonding surfaces including face, edge and end joints shall be smooth and, except for minor local variations, shall be free of raised grain, torn grain, skip, burns, glazing or other deviations from the plane of the surface that might interfere with the contact of sound wood fibers in the mating surfaces. For dry-service conditions, wane up to 1/6 the width at each edge of interior laminations is permitted. Wane is permitted to be used in wet-service conditions where moisture accumulation in the wane areas will not occur. All bonding surfaces shall be free from dust, foreign matter, and exudation which are detrimental to satisfactory bonding.

Lumber for multiple piece laminations (laminations consisting of 2 or more pieces of lumber across the width) shall be graded as individual pieces of lumber except for manufactured lumber that has been qualified by the

accredited inspection and testing agency.

#### **4.3.8 Laminating with Gap-Filling Adhesives ---**

When gap-filling adhesives which meet the requirements of 4.4.1.2 are used, all requirements of this Standard apply except:

- (a) Variations in thickness of laminations or bonded assemblies of laminations are permitted to exceed the thickness limitations specified in 4.3.7 but the maximum bond line thickness shall not exceed 1/16 in.
- (b) The net thickness of bonded assemblies of laminations is permitted to exceed 2 in.
- (c) Bond line pressure shall be as recommended by the adhesive manufacturer.

**4.3.9 Moisture Content ---** The moisture content of laminations shall not exceed 16% at the time of bonding. An exception applies when it is known that the equilibrium moisture content of the laminated timber in use will be 16% or more: the moisture content of laminations at the time of bonding shall not exceed 20%. The range of average moisture contents of laminations to be assembled into a single timber shall not exceed 5 percentage points if the average moisture content of any lamination exceeds 12%. Moisture content shall be based on the average moisture content of the cross section. The moisture content of a lamination shall be the average moisture content along its length. Both end jointing and face bonding procedures for lumber with moisture content above 16% shall be approved by an accredited inspection and testing agency .

Moisture content determinations shall be based on ASTM D4442 or D4444. In-line moisture meters used for lumber segregation shall be calibrated using one of these standards.

**4.3.10 Wood Inserts ---** Wood inserts are permitted to be used to meet appearance grade requirements. The moisture content of inserts shall be in accordance with 4.3.9. The same general type of adhesive required for face joint bonding shall be used for bonding inserts.

##### **4.3.10.1 Application of Inserts**

- (a) Insert depth shall be limited to 1/2 in. for laminations less than 6 in. in nominal width and 3/4 in. for laminations 6 in. or wider for compression members and bending members other than in the outer 5% of the depth within the tension zone of bending members.
- (b) The depth for inserts located in the outer 5% of the depth of a bending member within the tension zone or in any lamination in tension members shall be limited to 1/4 in. for laminations less than 6 in. in nominal width and 3/8 in. for laminations 6 in. and wider.

When for specific loading of a member, engineering calculations are used to determine the zones in the tension portion of bending members which are

loaded to less than 50% of the design strength in bending, the depth of the insert is permitted to be that given in (a).

Inserts used in this tension portion of bending members or in tension members shall be tapered at each end with a slope not steeper than 1:16.

- (c) Adhesives and the methods of attaching inserts must meet the durability requirements for the end use.

#### **4.4 Adhesives**

**4.4.1 Adhesives ---** Adhesives shall conform to ASTM D2559. Each shipment of adhesive shall be identified with the name of the manufacturer, the name or designation of the adhesive, the adhesive manufacturer's lot number and the expiration date after which the adhesive should not be used.

**4.4.1.1 Urea Adhesives ---** Urea-formaldehyde adhesives shall not be used in structural glued laminated timber. Adhesive combinations containing urea shall not be used in preservatively treated glued laminated timber except as set forth in 4.4.1.1(a).

- (a) Melamine-urea-formaldehyde and Melamine-urea-resorcinol-formaldehyde --- Combinations in which the melamine resin solids content is at least 60% by weight of the total resin solids, or in resorcinol modified systems, where the combination of melamine and resorcinol resin solids content is at least 60% by weight of the total resin solids, and which meet the requirements of ASTM D 2559 are permitted to be used; except that they shall not be used for hardwoods or woods chemically treated before or after bonding. They are permitted to, however, be used to end joint untreated wood to wood treated with pentachlorophenol in light hydrocarbon solvent provided the end joint is located in a dry-use exposure condition. Melamine-urea-formaldehyde combinations shall not be used when the service conditions result in exposure to the combined effects of a moisture content of wood in excess of 16% and a temperature of 120° F or greater.

Exception: Combinations containing urea are permitted to be used as wet-use adhesives for untreated wood or for wood that is to be chemically treated before or after bonding provided such combinations shall conform to ASTM D2559, shall be tested per ASTM D3434 with the exception that the requirements of paragraph 8.3.1 of ASTM D3434 be limited to not less than 800 cycles and equal to a phenol-resorcinol-formaldehyde control adhesive that meets the requirements of D2559. Qualification is required for each species-adhesive-treatment combination to be used in production.

**4.4.1.2 Gap-filling adhesives ---** Gap filling adhesives must meet all of the requirements of 4.4.1. In addition, they must meet the requirements of Tests T107 and T110 when tested with a 1/16-in.-thick bond line. Gap-filling adhesives must comply with ASTM D2559 by being

tested using shims to maintain at least the maximum bond line thickness being qualified for approval.

**4.4.1.3 New Adhesive Types** --- New adhesive types as defined in AITC 405 shall be qualified by the procedures set forth therein.

**4.4.2 Adhesive Lot Testing** --- Each new lot of adhesive previously qualified under 5.6.1.6 shall be tested for strength and durability in accordance with 4.4.2.1 and/or 4.4.2.2 and 4.4.2.3 prior to shipment of the members manufactured with this lot. Samples for this testing shall be made-up separately prior to use of the adhesive in production or taken from the first production run. Tests shall be made on specimens which have been manufactured from the species to be used in the production of glued laminated timber. Testing of a new lot of adhesives for face joint bonding will satisfy the requirements for edge joint bonding.

Where gap-filling adhesives are to be evaluated, test specimens shall be cut from samples specially made by using shims or by a similar method to maintain a maximum 1/16 in. bond line thickness.

**4.4.2.1 Face Joint Bonding, Strength and Wood Failure** --- Shear tests shall be performed on each new lot of adhesives in accordance with Test T107. The shear strength of all specimens to be evaluated shall be averaged and this average shall equal or exceed 90% of the average clear wood shear strength parallel to grain as determined from ASTM D2555. When species groups are used, the procedures for assigning values for groups given in ASTM D2555 shall be used. The shear value for 12% moisture content shall be used for moisture contents of 12% or less. The wood failure of the sheared or broken surfaces of all specimens to be evaluated for qualification or lot verification testing of adhesives shall be averaged and this average shall equal or exceed 80% for adhesives used with softwoods and non-dense hardwoods, or shall equal or exceed 60% for adhesives used with dense hardwoods.

**4.4.2.2 End Joint Bonding: Strength and Wood Failure** --- End joint specimens shall be prepared using the same adhesive curing procedures used in production. End joint adhesives shall be tested and evaluated by use of Test T119. A minimum of 4 end joints shall be tested for adhesive lot testing. Average wood failure of all specimens tested shall be as required in 4.4.2.1 for the shear test. Average strength required of all the specimens tested shall be as determined by the qualification test required in 5.6.1.1.

**4.4.2.3 Durability of Adhesive Bonds: Face and End Joint Bonding** --- Delamination tests shall be performed on each new lot of adhesives in accordance with Test T110. After one complete cycle, softwoods shall have no more than 5% delamination and hardwoods shall have no more than 8% delamination. Face and end joint test specimens shall be prepared using the same adhesive curing procedures used in production.

## 4.5 Manufacture

**4.5.1 Laminating** --- The selection and preparation of lumber and adhesives shall be in accordance with 4.3 and 4.4. Mixing of the adhesive, the interval between mixing and spreading, spreading, assembly time, assembly pressure, temperature and curing time of the adhesive shall be based on recommendations of the adhesive manufacturer with subsequent qualification and daily quality control. Ingredients for each adhesive mix shall be determined by weight. Liquids are permitted to be measured by volume only after the containers have been calibrated on a weight basis. Automatic adhesive mixing equipment is permitted to be used provided appropriate mix proportions can be maintained within limits prescribed by the adhesive manufacturer. The mix ratio shall be verified by procedures described in Test T122.

The mixed adhesive shall be applied uniformly to wood surfaces in an amount adequate to meet the performance requirements of this Standard. Determination of the adhesive spread rate shall be made in accordance with Test T102. No adhesive shall be used after expiration of its storage or pot life, as determined by the adhesive manufacturer.

Lumber surface temperature at the time of bonding may be critical to achieving satisfactory adhesive bonds. Adjustments in assembly time, quantity of adhesive spread and curing conditions shall be made depending upon the lumber and ambient temperature. The adequacy of adjustments shall be demonstrated by shear and cyclic delamination tests at the lowest and highest temperatures at which laminating takes place.

Assembly pressure at the bond line (except for gap filling adhesives) shall be a minimum of 100 psi and a maximum of 250 psi with the lower pressures for softwoods and the higher pressures for dense hardwoods. In no case shall pressures exceed the design value in compression perpendicular to grain for the species being bonded.

The temperature of the adhesive mix shall be measured with sufficient frequency to assure that the working life of the adhesive is not exceeded.

**4.5.1.1 Face Joint Assembly and Bonding** --- Face joints shall have pressure applied uniformly starting at any point, but progressing continuously outward toward the ends or along the length of the member. Pressure shall be maintained for a sufficient period of time so as to ensure close contact between laminations and not over-stress bond lines during development of bond strength. Pressures shall be checked prior to substantial cure and adjustments made as required. Nailing of the structural portion of laminations in lieu of clamping pressure shall not be permitted.

**4.5.1.2 Edge Joint Assembly and Bonding** --- Edge joint bonding shall not be required unless specified by the designer as a response to structural requirements. When edge joint bonding is a structural requirement, edge joints shall be tested in the same manner as face joints and the

same requirements for wood failure and shear strength apply. When edge joints are not pre-bonded, they shall be staggered laterally in adjacent laminations by at least the net thickness of the lamination. When edge joints are pre-bonded in accordance with the requirements of 4.5.1.1, they need not be staggered laterally.

When multiple-piece laminations are not edge bonded, it is intended that the edges of the pieces be reasonably close to each other. Edge spacing in top and bottom laminations is permitted to be up to 1/4 in. for the full length with an occasional 3/8 in. gap permitted. Edge spacing in interior laminations shall not exceed 3/8 in. for nominal widths of 10 in. and less, 1/2 in. for 12 in. nominal widths and 5/8 in. for 14 in. nominal widths. For nominal widths wider than 14 in., the allowable opening shall be proportional to the opening allowed for a nominal width of 14 in. Openings shall be cumulative across multiple-piece laminations containing 3 or more pieces.

When multiple piece face laminations (not edge bonded) are used, gaps at edge joints, which are exposed to view, shall be filled with filler material or wood inserts.

**4.5.1.3 Curing Schedules** --- The laminator's procedures and quality control manual shall include curing schedules for each adhesive formulation used. A separate schedule shall be established for each untreated species-adhesive combination and for each treatment-species-adhesive combination. The schedules shall include time-temperature relationships.

**4.5.2 End Joint Assembly and Bonding** --- The individual pieces of lumber in a lamination shall be joined by end joints meeting the requirements of this Standard when the length of the lamination is longer than the lumber used. End joints for bending, tension and compression members shall be qualified in accordance with this Standard (see 5.6.1.1).

End joints shall be pre-bonded or assembled and bonded integrally with the face joint operation. For plane scarf joints, the thickness tolerance in end joint areas at the time of face joint bonding shall be within plus 0.020 in. to minus 0.005 in. of the thickness of the lumber being end jointed. For finger joints, a thickness tolerance of plus 1/32 in. is allowed in the assembled thickness. The thickness of exposed tips of plane scarf joints or finger joints which occur across the full width of the face of the lamination shall not exceed 1/32 in. on the outer tension face(s) of bending or tension members.

When end joints are bonded integrally with the face joint bonding of laminations, they must be positively maintained in alignment while the face joint bond is accomplished. Positioning and alignment methods shall permit checking of tolerances with gauges. End joints for the production of curved members shall be pre-bonded unless the assembled thickness tolerance of the end joint area and alignment can be maintained by other methods. End joints shall be bonded in accordance with the requirements for face joint bonding with appropriate modifications to the adhesive spreading, assembly times, application of pressure and curing times for the methods used.

**4.5.2.1 End Joints in Inner Laminations of Bending Members** --- End joints with lower Qualification Stress Levels (QSL) than those required for outer tension zone laminations are permitted in inner tension and compression zones of bending members provided:

- (a) The laminations of each qualification stress level (QSL) of end joints used are clearly marked on the edges to identify the strength level unless the end joint configuration is such that the end joint with the lower QSL is readily distinguishable from the end joint with the higher QSL used in outer laminations when viewed from the edge of the laminations.
- (b) The end joint with the lower QSL is qualified for the maximum stress level for which it is used.
- (c) The end joint with the lower QSL is not used in the outer tension zone nor in the outer 10% of the depth on the tension side, whichever is greater.
- (d) End joints with QSL levels less than 75% of the QSL of the outer tension zone shall not be used in the outer compression zone of bending members.
- (e) The stress value at which the end joint with the lower QSL is qualified is determined by straight-line interpolation from the outer tension lamination to the mid-depth of the member. For this procedure, the stress at the outer tension lamination shall be the higher QSL required for a given combination and the stress at the mid-depth of the member is zero.

**4.5.2.2 End Joints Used for Repair**---Laminating repair procedures using end joints which are integrally bonded in the repair process shall be evaluated by an accredited inspection and testing agency using the same test criteria and manufacturing tolerances that are applicable to production end joints. The procedure for testing and evaluation in AITC 403 shall be followed.

If structural repairs using end joints are made to laminations containing end joints that have been previously proof loaded, the member containing the repaired lamination shall not be marked as a member containing proof loaded end joints.

**4.5.2.3 Knots In or Near End Joints**---Knots or knotholes in plane scarf joints shall be limited to those permitted for the lumber grade. In no case shall they exceed 1/4 the nominal width of the piece in laminations occupying the outer 10% on each side of bending members and in any lamination of tension members.

Finger joints shall not contain knots except that an occasional occurrence of a single pin knot, not to exceed 3/8 in. diameter, is permitted in finger joints in tension members and in finger joints in the outer 10% of depth on the tension side of bending members. Also an occasional single knot up to 1/2 in. diameter is permitted in joints in the remainder of bending members and in compression members.

In bending members, knots exceeding 3/8 in. diameter are not permitted within 2 knot diameters or 6 in., whichever is less, of finger joints in the inner and outer tension zones (in no case less than 10% of the depth of bending

members), nor shall knots over 1/2 in. diameter occur within one knot diameter of finger joints in the balance of the laminations.

In tension members, knots larger than 3/8 in. are not permitted within 2 knot diameters or 6 in., whichever is less, of finger joints in any lamination.

In compression members, knots larger than 3/4 in. are not permitted within one knot diameter of finger joints.

Measurement of knot diameter for spacing near end joints shall be parallel to the longitudinal axis of the piece of lumber. The distance of knots from finger joints shall be measured from the edge of the knot nearest the joint to the closest part of the joint.

**4.5.2.4 Spacing of End Joints**---Spacing between finger joints in single piece laminations is determined by measuring the distance between any portion of joints in adjacent laminations in a direction parallel to the longitudinal axis of the single piece laminations.

The spacing of scarf joints is determined by measuring the distance between tips along the face joint bond of adjacent single piece laminations. Furthermore, a plane at a right angle to the axis of a member that intersects one plane scarf joint in a lamination shall not intersect any part of another plane scarf joint in an adjacent lamination.

For multiple-piece laminations, an end joint shall be considered in the same manner as a lamination consisting of a single piece when end joints in the pieces of the lamination are within 6 in. of each other. If only one piece of a multiple-piece lamination has an end joint within a 6 in. cross section, and an end joint occurs in one piece of an adjacent lamination closer than 6 in., this combination shall be considered on the same basis as a single piece lamination provided the combined width of the 2 end joints does not exceed the width of the lamination.

In those areas of members consisting of multiple-piece laminations where specific joint spacing is required, the sum of the widths of the end joints of multiple-piece lamination in any 2 laminations in any 6 in. of length shall not exceed the width of a single lamination; nor shall more than 3 end joints in adjacent laminations closer together than 6 in. appear on either side of members in this area.

Concentrations of end joints shall be avoided. End joints shall be dispersed as follows:

- (a) Tension members --- When for specific loading of a member engineering calculations are used to determine that the member is loaded to less than 75% of the design value, one single occurrence of 2 joints in adjacent laminations spaced closer than 6 in. is permitted for any 30 ft. of length.
- (b) Tension portion of bending members --- The minimum spacing of end joints in adjacent laminations in tension portion of bending members

for the outer 1/8 of the depth of the member plus one lamination shall be 6 in. This spacing applies over the central 75% of the zone stressed in tension.

There are no minimum spacing requirements for the remaining portion of the tension zone.

When, for specific loading of a member, engineering calculations are used to determine zones in the tension portions of bending members which are loaded to 50% or more of the design value in bending, the minimum spacing requirements apply only to these zones.

- (c) Compression members and compression portion of bending members --- There are no requirements for minimum spacing of end joints in compression members or in the compression portion of bending members.
- (d) Occasional occurrences of end joints spaced closer than the above minimums are permitted when consideration is given to the combined structural effect of location within the member and the occurrence of other strength-reducing characteristics.
- (e) When end joints are proof loaded in accordance with either Test T118 or T121, there are no requirements for minimum spacing of end joints.
- (f) When the outer lamination on the tension side of a member is repaired by the procedures described in AITC 403, the repair shall be made in such a manner that no end joint in the outer lamination or the next inner lamination occurs within 6 in. on either side of the repair tip(s).
- (g) No specific end joint spacing is required in arches.

**4.5.2.5 Spacing of End Joints Within the Same Lamination**

- (a) End joints shall not be spaced less than 6 ft. apart in the same lamination in tension members or in the outer 10% of total depth of bending members on the tension side except for an occasional occurrence of two end joints less than 6 ft. apart along lamination lengths. End joint spacing in the same lamination is permitted to be less than 6 ft. in the remainder of bending members or throughout compression members.
- (b) There are no requirements for spacing of end joints in the same lamination for any type of member provided the full length of the lamination is proof loaded in tension by Test 121 and meets the requirements in AITC 406, and the laminations are resurfaced after end jointing to the tolerances set forth in 4.3.7.

**4.6 Appearance Grades** --- Glued laminated timber shall be finished to a framing, industrial, architectural or premium grade as defined in Annex B unless otherwise agreed upon by buyer and seller.

## 5. QUALITY CONTROL SYSTEM

**5.1 General** --- The quality control system of the laminator shall be approved by an accredited inspection and testing agency. The quality control system shall meet the requirements of Section 5.

**5.2 Conformity with Standard** --- The production of structural glued laminated timber for conformity with this Standard shall be in accordance with a quality control system that is established, implemented, and maintained by the laminator and is approved and audited by the accredited inspection and testing agency.

**5.3 Plant Manuals** --- Production procedures and the plant quality control system shall be fully described in the plant's procedures manual and quality control manual. Production check points, physical testing and visual inspection procedures shall be included in the quality control manual. These manuals shall have the approval of an accredited inspection and testing agency and shall be reviewed periodically by that agency.

**5.4 Quality Control Records**---Records of quality control procedures shall be maintained by the laminator. The following records shall be kept by the laminator for at least 5 years.

- (a) Qualification test results,
- (b) Daily tests on finished production, including shear tests, cyclic delamination tests and end joint strength tests,
- (c) Production line test results – daily check sheet listing each phase of production to be checked. Items shall be initialed as having been checked with comments indicating compliance. When noncompliance is found, the action and correction of the procedure shall be noted, and
- (d) Documentation of any engineering analysis performed in accordance with 5.7.3.2.

### 5.5 Inspection And Test Procedures

**5.5.1 General** --- Inspection and test procedures for structural glued laminated timbers to be used to meet the requirements of this Standard are:

- (a) Plant qualification including qualification tests as required in 5.6.
- (b) Daily quality control as required in 5.7, consisting of:
  1. A continuous detailed check of each step of the process at production checkpoints including in-line tests,
  2. Physical tests of finished production, and
  3. Visual inspection of finished production.
- (c) Auditing by an accredited inspection and testing agency.

**5.6 Plant Qualification**---The laminator shall pass all qualification tests and shall meet all other requirements of this Standard and provide verification of such

qualification by an accredited inspection and testing agency.

**5.6.1 Qualification Tests**---The following tests are required for plant qualification:

- (a) End joint qualification Test T119 described in 5.6.1.1,
- (b) Adhesive qualification procedure described in 5.6.1.6,
- (c) Adhesive lot test described in 5.6.1.7,
- (d) All other applicable qualification tests as shown in 5.6.1 and mandatory 400 series standards in Annex A, and
- (e) physical tests used by the plant for daily quality control listed in 5.7.2.

A summary of the tests for qualification is shown in Table 1.

**5.6.1.1 End Joint Qualification Test**---End joints from each production line shall be qualified by Test T119 and the average test value and the 5% tolerance limit with 75% confidence shall be determined. Test T119 shall be performed on all species or groups of species which have closely similar strength and bonding characteristics. Qualification of end joints in any width also qualifies all narrower widths. Where both nominal 1 in. and nominal 2-in. thick lumber are used in production, both shall be tested when the joint geometry is judged to be significantly different by the accredited inspection and testing agency. Wood failure shall be as specified in 4.4.2.1 for face joint bonding. The strength value at the 5% tolerance limit with 75% confidence shall equal or exceed 1.67 times the Qualification Stress Level (QSL) for end joints used in bending and compression members and 2.1 times the QSL for end joints used in tension members. See 5.6.1.2 for determination of QSL.

This end joint qualification test applies to all grades of lumber of the adhesive-species-treatment group tested.

Qualification of an adhesive-species-treatment group using treated lumber also qualifies bonding procedures for untreated lumber using the same process.

Table 1 – SUMMARY OF QUALIFICATION TESTS

Test Performed On	Minimum Number of Samples	Minimum Number of Specimens per Sample	AITC Test Number and Type of Test	Requirements or Limitations for	References Within this Standard
Face and Edge Joints	2 beams <sup>a, b</sup>	10	T107 Shear	Strength and Wood Failure	5.6.1
	2 beams <sup>a, b</sup>	3	T110 Cyclic Delamination	Bond Line Openings	5.6.1 4.4.2.3
End Joints	1 <sup>a</sup>	30	T119 Tension	Strength and Wood Failure	5.6.1
	1 <sup>a, c</sup>	5	T110 Cyclic Delamination	Bond Line Openings	5.6.1 4.4.2.3
The following tests are required in addition to the above requirements when these processes and/or materials are used in the plant.					
Proof Loaded End Joints	2	30	T118 Bending -or- T121 Tension	Strength  Strength	5.6.1.4 5.6.1.1
End Joints for Repair	10 Repairs	2	T119 (Modified) Tension	Strength and Wood Failure	5.6.1.5 5.6.1.1
	1 (Test Block) -or- 1 (Test Block)	5  10	T106 Strip Tension T107		AITC 403
Manufactured Lumber	1	102	T123 Tensile Properties	Strength	5.6.4 AITC 401
LVL	Per Applicable Requirements in ASTM D5456 and AITC 402	Per Applicable Requirements in ASTM D5456 and AITC 402	T123 Tension Plus Referenced ASTM Tests T107, T110	Strength  LVL/LVL plus LVL/Wood	ASTM D5456
			T116	Long Span E	AITC 402 B3.4 – 6.2.2
Radially Reinforced Curved Members	1	10			AITC 404
Proof Graded Lumber	1	102	T123 Tensile Properties	Strength	
			T116	Long Span E	AITC 406

<sup>a</sup> For each adhesive-species-treatment combination used (LVL is considered a separate species for testing requirements).

<sup>b</sup> When edge joint bonding is a structural requirement.

<sup>c</sup> End joints are permitted in specimens used for face joint bonding.

<sup>d</sup> End joint repair procedures must be verified for adequacy by supplemental full scale beam tests in addition to AITC Test T119. Reference AITC 403 and ASTM D198.

The QSL value required for end joints is for nominal 2x6 lumber. For other widths in nominal 2 in. thick lumber, the QSL's are multiplied by the following factors:

Table 2—Adjustment Factors to the QSL for Wider Width Lumber Used in Test T119

Size	All Species Except Southern Pine	Southern Pine
2 x 8	0.95	0.98
2 x 10	0.90	0.95
2 x 12	0.85	0.93

### 5.6.1.2 Qualification Stress Level (QSL)

- (a) Bending Members--For end joints used in bending members, QSL for nominal 2 x 6 laminations is determined by the highest tabular design bending value based on normal duration of load and dry-service conditions as modified, if necessary, by stress distribution associated with transformed section analysis. An exception is permitted for end joints for inner laminations as included in 5.6.1.3.
- (b) Tension Members--For members loaded in tension throughout their depth, the same provisions of (a) apply except that QSL is equal to the highest tabular design value for tension parallel to grain based on normal duration of load and dry-service conditions..
- (c) Compression Members--For members loaded in compression parallel to grain throughout their depth, the same procedure in (a) applies except that QSL is determined by the highest tabular design value for compression parallel to grain based on normal duration of load and dry-service conditions. The qualification of end joints in nominal 2x6 laminations applies to all widths.

**5.6.1.3 Qualification Stress Level (QSL) for Inner Laminations of Bending Members** --- End joints with Qualification Stress Levels (QSL) lower than those required in outer laminations shall not be used in inner lamination of bending members unless the requirements of 4.5.2.1 are met.

**5.6.1.4 Proof Loaded End Joint Qualification**---When proof loaded end joints are to be used, such end joints must be qualified by Test T118 for bending proof loading; or by Test T121 for tension proof loading.

**5.6.1.5 End Joints Used in Lamination Repair**--End joints used in lamination repairs must be qualified by testing in accordance with the procedures given in AITC 403.

**5.6.1.6 Adhesive Qualification** --- Each adhesive-species-treatment-combination used for face, edge and end joint bonding shall be qualified for use prior to production in accordance with applicable provisions of this section and section 4.4. ASTM D2559 requires that an adhesive manufacturer list the species of wood that are recommended for use with the approved adhesive. For

qualification purposes, species with comparable bonding characteristics are permitted to be grouped in accordance with guidelines in 5.6.2 upon approval by an accredited inspection and testing agency. The criteria for strength and wood failure as specified in 4.4.2.1, 4.4.2.2 and 4.4.2.3 shall be met. Samples to be used for in-plant qualification shall be prepared using representative product manufacturing processes.

**5.6.1.7 Adhesive Lot Testing**---The lots of adhesive on hand at time of qualification shall be tested by use of the procedure required for new lots of adhesive in 4.4.2. Wood failure, strength and durability shall be as required in 4.4.2.2 and 4.4.2.3.

**5.6.2** All inspection and test procedures required in 5.5.1 for daily quality control must be performed as a part of the qualification procedure.

**5.6.3 Groups of Species With Comparable Strength and Bonding Characteristics** --- The species or species groups within the following groupings need not be qualified separately.

Group 1 --- Douglas Fir Larch\*

Group 2 --- Southern Pine

Group 3 --- Hem-Fir, Mountain Hemlock, Douglas Fir South, Sitka Spruce

Group 4 --- Softwood Species including Englemann Spruce, Lodgepole Pine, Ponderosa Pine, Spruce-Pine-Fir and other Western Species.

Group 5 --- California Redwood

\* Larch shall require separate qualification for face bonding because of galactan content if deemed necessary by the accredited inspection and testing agency.

Other requirements with regard to separate species group qualifications are as follows:

- (a) When a plant has qualified adhesives for a face joint bond on Group 1 species, a separate qualification is not required on Groups 3, 4 and 5.
- (b) When end joints of both Douglas Fir-Larch and Hem-Fir have been separately qualified, it is not necessary to qualify the combined species, provided the end joint cure cycle used is controlled by the more restrictive requirement.
- (c) When end joints have been qualified for Group 1 species, a separate qualification is not required for Group 3 species. When end joints have been qualified for Groups 1 and 2 species, a separate qualification for Group 4 species is not required for qualification stress levels (QSL) of 2000 psi or less. When the QSL exceeds 2000 psi, a qualification is required.

When qualification of end joints for a lower strength species is required, and the plant has been previously qualified for the wider widths of Group 1 or 2

Species, Test T119 needs to be performed on the nominal 6 inch width only. The strength of the wider widths is determined by the continuous daily quality control tests of the lower strength species.

- (d) Red Oak and White Oak are to be considered in the same group. Other hardwoods listed in the hardwood laminating specification, AITC 119, are to be considered on an individual basis.

**5.6.4 Laminated Veneer Lumber (LVL)** -- When LVL is used in the production of glued laminated timber, the qualification of LVL for use as laminations in glued laminated timber shall be in accordance with AITC 402.

**5.6.5 Manufactured Lumber** -- When manufactured lumber is used in the production of glued laminated timber, the qualification of manufactured lumber for use as laminations in glued laminated timber shall be in accordance with AITC 401.

**5.7 Daily Quality Control** --- Daily quality control shall consist of the following:

**5.7.1 In-Line Tests** --- In-line tests conducted at production checkpoints shall include the checking of moisture content, surfacing, temperature, end joints, edge joints, face joints, adhesive mixing, adhesive spread, assembly time, pressure and curing conditions.

**5.7.2 Physical Tests** --- A summary of daily quality control tests is shown in Table 3.

**5.7.2.1 Sampling** --- Face joint, edge joint and end joint strength and durability shall be monitored daily by physical tests. Face, edge and end joint bonding for each combination of species, type of adhesive and treatment used during the work shift shall be represented by this sampling. Species of similar strength and bonding characteristics, when bonded concurrently, can be grouped together and the test of one species can apply to all species in this group for a given sampling period. The sampling of species from day-to-day should be approximately in proportion to the volume of production of each species used in the plant.

For face and edge joints, 10 or more bond lines shall be tested. If production member(s) contains less than 10 bond lines, a minimum of 10 specimens shall be prepared, but each bond line shall be tested.

Where manufactured lumber and sawn lumber of the same species are used during the same shift, daily quality control tests for face, edge and end joint bonding need be run only on the material which has controlling test values as determined during qualification.

**5.7.2.2 Face and Edge Joints** --- A minimum of one sample shall be taken from every 50,000 board feet, or portion thereof, which is bonded during each work shift.

All samples shall be cut from the ends of production members or from special samples. In either case, samples

shall be representative of production members made under the production conditions.

**5.7.2.3. End Joints** --- A lot size shall be established by the laminator and approved by the accredited inspection agency. The number of end joints to be tested by AITC Test T119 shall be based on the production of end joints for the outer tension zone of bending members (a minimum of 10% of depth) and for the full depth of tension members. The number of end joints to be tested is 1 end joint per 200 of these joints, but no less than 2 end joints per lot, shift, or every 50,000 board feet or portion thereof of production.

When no end joints are produced for the outer tension zone in a bending member or for a tension member, a minimum of two specimens per lot, shift, or every 50,000 board feet, or portion thereof, shall be tested.

The end joints tested shall be made using lumber meeting the requirements for the highest grade of lumber required in the outer 5% of depth on the tension side of a bending member for the combination used to determine the QSL.

In addition, a minimum of one end joint shall be tested by Test T105 following:

- (a) Any major change in end joint production variables, including the curing sequence and
- (b) Change of end joint cutter heads.

Test T115 is permitted to be substituted for Test T105 where plain scarf joints and integrally bonded end joints are used. The selection of test specimens and evaluation of test results from all samples shall be in accordance with procedures approved by an accredited inspection and testing agency.

**5.7.2.4 Separate Production Lines** --- The procedures for testing of end joints in 5.7.2.3, 5.7.2.7, and 5.7.2.8 shall be applicable to each end joint production process or separate end joint fabrication line.

**5.7.2.5 Tests for Face Joint Bonding** --- Shear tests on bond lines between laminations shall be conducted in accordance with Test T107. The shear strengths of all specimens to be evaluated shall be averaged and this average shall equal or exceed the values specified in 4.4.2.1. The wood failure on the sheared or broken surfaces of all specimens to be evaluated shall be averaged and this average shall equal or exceed 70% for adhesives used with softwoods and non-dense hardwoods and 50% for adhesives used for dense hardwoods.

**5.7.2.6 Tests for Edge Joint Bonding** --- Where edge joint bonding is a structural requirement, shear tests shall be conducted as for face joint bonding with appropriate modification of width depending upon the thickness of the lamination. The criteria specified in 5.7.2.5 shall be met.

Table 3 – SUMMARY OF PHYSICAL TESTS – FOR DAILY REQUIREMENTS

Test Performed on:	Minimum Number of Specimens per Sample per Sampling Period	AITC Test Number and type of test	Requirements or Limitations for	References Within this Standard
Face and Edge Joints <sup>a, b</sup>	10	T107 Shear	Strength and Wood Failure	5.7.2.1 5.7.2.5
	1	T110 Cyclic Delamination	Bond Line Openings	5.7.2.10
End Joints <sup>a, c, f</sup>	2	T119 Tension	Strength and Wood Failure	5.7.2.7 5.7.2.5
	Varies <sup>d</sup>	T105 <sup>e</sup>	Wood Failure	5.7.2.3
	1	T110 Cyclic Delamination	Bond Line Openings	5.7.2.10
The following tests are required in addition to the above Requirements when these processes and/or materials are used in the plant.				
Proof Loaded End Joints	All joints tested in production.	T118 Bending or T121 Tension	Strength	5.6.1.4 5.6.1.1
End Joints for Repair	1 -or- 5 -or- 10 Plus 1	T119 Tension - or- T106 Tension - or- T107 Shear	Strength and Wood Failure	AITC 403 5.6.1.5 5.6.1.1
	1	T110 Cyclic Delamination	Bond Line Openings	AITC 403
Manufactured Lumber	Varies <sup>d</sup>	T123 Tensile Properties	Strength	5.6.4 AITC 401
LVL	Per Applicable Test	T107, T110	Strength and Wood Failure	AITC 402
		T116	Long Span E	B-6
Radially Reinforced Curved Members	Per Manufacturer's Procedures and QC Manual			AITC 404
Proof Graded Lumber	Varies <sup>d</sup>	T116	Long Span E	AITC 406
	Varies <sup>d</sup>	T123 Tensile Properties	Strength	

<sup>a</sup> For each adhesive-species-treatment combination used (LVL is considered a separate species for testing requirements).

<sup>b</sup> When edge joint bonding is a structural requirement.

<sup>c</sup> In outer tension zone(s). When no outer tension laminations are produced during sampling period, make test end joints from outer tension zone material.

<sup>d</sup> Sample size varies with quality control requirements per each laminator's qualification.

<sup>e</sup> Test T115 should be used for plane scarf joints and integrally bonded end joints.

<sup>f</sup> End joints are permitted in specimens used for face joint bonding.

**5.7.2.7 Tests for End Joint Bonding** --- End joints shall be tested daily for strength and wood failure in accordance with Test T119. The criteria for wood failure shall be as specified in 5.7.2.5 for face joint bonding. Strength quality control requirements shall be based on lot sampling. Lot quality control shall be monitored with a continuous quality control program. Control limits for lot sample average strength shall be established to maintain the qualification stress level requirement of 5.6.1.1.

**5.7.2.8 Tests for Proof Loaded End Joints** --- When proof loaded end joints are used, all of the daily production line checks and daily tests required for end joints shall be performed. In addition all quality control procedures set forth in Test T118 or T121, whichever is applicable shall be followed.

**5.7.2.9 Tests for End Joints Used in Lamination Repair** --- When end joints are used in the repair of laminations, daily quality control and tests set forth in AITC 403 shall be performed.

**5.7.2.10 Tests for Integrity of Adhesive Bonds** --- Cyclic delamination tests made in accordance with Test T110 shall be conducted on samples from face joints and end joints, and on edge joints when edge joint bonding is a structural requirement. End joints are permitted in the specimens used for face joint bonding.

When the lamination repair procedure is used, a cyclic delamination sample is to be made in combination with each required strength test sample.

Delamination after one complete cycle shall not exceed 5% for softwoods and 8% for hardwoods. If delamination exceeds these values after one cycle, a second cycle shall be performed on the same specimens, in which case the delamination shall not exceed 10%.

### 5.7.3 Visual Inspection of Finished Production

**5.7.3.1 General** --- All production shall be inspected both visually and by measurements for conformance to the requirements of this Standard as to:

- (a) Dimensions (width, depth and length),
- (b) Shape, including camber and squareness of cross section,
- (c) Type, quality and location of structural bondlines,
- (d) Appearance grade,
- (e) Lumber species and placement of grades,
- (f) Moisture content,
- (g) Adhesive type--If adhesive appears to have the wrong color, the type must be ascertained from records or determined by suitable test if records do not correspond with the visual observation, and
- (h) Bond line--If bond line thicknesses do not fall within the range of 0.006 in. plus or minus 0.004 in.

(except gap-filling adhesives which are permitted to have bond line thicknesses up to 1/16 in.), investigation of the production procedures shall be made to assure conformance with this Standard. Infrequent occurrences of separations of bond lines shall be limited (in the judgment of a qualified inspector), to no greater than the lamination characteristics permitted at the bond line. Any separation of bond lines shall require investigation of records and production procedures, and may require additional physical tests. Probes, increment borings or other means shall be used to evaluate the degree of separations.

**5.7.3.2 Minor Variations**--A member conforms to this Standard when minor variations of a limited extent in non-critical locations exist, or when structural damage or defects have been repaired and, in the judgement of a qualified person, the member is structurally adequate for the use intended. A qualified person is one who is familiar with the job specifications and applicable design requirements and has first hand knowledge of the manufacturing process.

## 6. MARKING

**6.1** Structural glued laminated timber represented to comply with this Standard shall be distinctively marked.

**6.1.1 Non-Custom Members**---Non-custom members shall be marked with the following:

- (a) Identification of this Standard, **ANSI/AITC A190.1-2002**,
- (b) Identification of the accredited inspection and testing agency (see 7.1),
- (c) Identification of the laminating plant,
- (d) The species or species group of lumber in the timber,
- (e) The applicable laminating specification and combination symbol (When design values for shear ( $F_v$ ) compression perpendicular to grain ( $F_{c\perp}$ ) and bending ( $F_b$ ) are other than the published tabular values for a combination, these design values must be included in the mark.),
- (f) Identification of structural use denoted by the symbols **B**---simple span bending member, **C**---compression member, **T**---tension member, **CB**---continuous or cantilevered span bending member,
- (g) Appearance grade denoted by **FRAMING** --- Framing, **IND** --- Industrial, **ARCH** --- Architectural and **PREM** --- Premium, as defined in Annex B.
- (h) **DO NOT CHEMICALLY TREAT** if the member is produced with melamine-urea-formaldehyde adhesives for end joint, edge joint or face joint bonding, unless the adhesive conforms to the

requirements of the Exception to 4.4.1.1 (a) of this Standard.

- (i) **PROOF LOADED END JOINTS** if the member has the required laminations proof loaded,
- (j) A lot number or job identification number, and
- (k) Alternate Tension Laminations --- When alternate tension laminations are used, a mark shall be added to the member to identify the alternate face lamination grade used (e.g. C14-24).

**6.1.1.1 Frequency of Marking** --- Non-custom and other required marks in this section shall be placed on non-custom members at intervals of 8 ft. or less in order that each piece cut from a longer piece will have at least one each of the required marks.

**6.1.2 Custom Members**---For members laminated to meet specific job specifications (custom members) the marking need consist of only items (a), (b), and (c) in 6.1.1. Custom-made timbers shall bear at least one mark containing the required identification. When long members shipped to a job are to be cut later into several members for use in the structure, the frequency of marking required for non-custom members shall be followed.

**6.1.2.1 One Hour Fire Rating** --- Members manufactured to provide a one-hour fire rating shall be manufactured to the specified layup except that a core lamination shall be removed, the tension zone moved inward, and the equivalent of one additional nominal 2 in. thickness outer tension lamination added. These members shall be marked with **1-HOUR FIRE RATING** designation.

**6.1.3 Top Stamp Requirements** --- Bending members which are straight or slightly cambered shall be marked with a top stamp with letters approximately 2 in. high. Custom members shall be stamped on the top at both ends. Non-custom members shall be stamped along the top at intervals set forth in 6.1.1.1.

**6.1.4 Certification of Conformance** --- When a Certificate of Conformance is issued, all glued laminated timber covered by the certification must be appropriately marked with the mark of the accredited inspection and testing agency.

**6.1.5 Dual Manufacture** --- This Standard is applicable to glued laminated timber manufactured in a single plant, or partly in one plant and partly in another. When more than one plant is involved, each plant must be qualified under this Standard and the Certificate of Conformance shall so indicate. The mark placed on the member(s) shall be the mark of the last plant involved in the manufacturing process.

**6.1.6 Marking Truss Members** --- When trusses are shipped, each assembly, subassembly, or separate part shall be marked.

**6.1.7 Withdrawal of Marking** --- Marking and/or certification of the product shall be removed and certificates (if required) withdrawn if any one of the

following conditions is met.

- (a) Physical tests, visual inspection, and review of production records indicate that a marked or certified product is not in conformance with the requirements of this Standard.
- (b) Investigation shows that the product does not conform to the requirements of the Standard.
- (c) The product is structurally inadequate for the use intended due to failure to meet the specifications for the product.

## **7. ACCREDITED INSPECTION AND TESTING AGENCY**

**7.1 General**--- An accredited inspection and testing agency is defined as one that:

- (a) Operates an inspection system which audits the quality control system of laminators,
- (b) Provides the facilities and the personnel to perform the inspection and to verify the testing as described herein,
- (c) Determines the individual plant's ability to produce in accordance with this Standard,
- (d) Provides periodic inspection of the plant's production operations and production quality to assure compliance with this Standard,
- (e) Enforces the proper use of the inspection agency quality marks and certificates,
- (f) Has no financial interest in, or is not financially dependent upon, any single company manufacturing any portion of the product being inspected or tested,
- (g) Is not owned, operated or controlled by any such company,
- (h) Provides an arbitration review board to arbitrate disputes between the agency and the laminator. Such a board shall include, but not be limited to, three persons:
  1. A recognized independent authority in the field of engineered timber construction to serve as chairman,
  2. At least one registered engineer knowledgeable in the design and use of structural glued laminated timber, and
  3. At least one person knowledgeable in glued laminated timber quality control and manufacturing.
- (i) Maintains or participates in a Technical Advisory Committee of laminator members and advisors for review of appropriate documents, procedures and applicable research and development.

**7.2 Technical Review Board**---The sponsor of this Standard, American Institute of Timber Construction, shall provide a Technical Review Board with the

following functions:

- (a) Interpretation of this Standard
- (b) Processing of appeals to the suitability of this Standard
- (c) Determination of the applicability and consistency of later issues of documents referenced in this Standard

**7.2.1 Membership**---The Technical Review Board shall consist of five voting members. The representation of the Board members shall be as follows:

- (a) One member representing laminators receiving testing and inspection services from the Sponsor.
- (b) One member representing the majority of laminators that receive inspection and testing services from an accredited agency other than the sponsor.
- (c) Three recognized authorities in the field of structural glued laminated timber. At least one professional engineer or architect; at least one representative of an educational or research organization.
- (d) The Chairman of the Technical Review Board shall be nominated by the Technical Advisory Committees of all accredited agencies. Final selection shall be made by the sponsor.
- (e) The sponsor shall provide a non-voting secretary.

**7.2.2 Selection** – The sponsor shall conduct a selection process that ensures the criteria of 7.2.1 have been satisfied.

**7.2.2.1** Members representing laminators shall be nominated by the laminators whom they represent.

**7.2.2.2** The members representing category 7.2.1 (b) shall be nominated by the accredited agencies. Final selection shall be made by the sponsor.

**7.2.3 Expenses** --- The expenses of the administration of the Technical Review Board shall be apportioned as follows:

- (a) Direct administrative expenses shall be borne by the sponsor.
- (b) Expenses incurred by the representatives of the laminators shall be borne by the accredited agencies corresponding to their representation.
- (c) Expenses incurred by the members of Sections 7.2.1 (c) and 7.2.1 (d) shall be prorated appropriately among all accredited inspection and testing agencies as determined by the sponsor.

## 8. EFFECTIVE DATE

The effective date of this Standard is the date upon which reference to the Standard may be made by producers, distributors, users and consumers, and other interested parties. The effective date of this Standard is October 10,

2002.

## 9. HISTORY OF PROJECT

Commercial Standard CS 253-63, Structural Glued Laminated Timber, was developed at the request of the American Institute of Timber Construction (AITC) and was published in 1963.

In 1970, AITC requested that the National Bureau of Standards initiate a revision of CS 253-63 under the Procedures for the Development of Voluntary Product Standards. A proposed revision was approved by the Standing Committee in June 1972. The recommended revision was then circulated for acceptance in July 1972. The response to this circulation indicated that certain changes to the Standard were necessary. A new proposal was approved by the Standing Committee in October 1972. The new recommended Standard was circulated for acceptance in January 1973. The response to this circulation indicated a consensus among producers, distributors and users, in accordance with the published procedures. This edition of the Standard was designated PS 56-73, Structural Glued Laminated Timber, and became effective on July 1, 1973.

This Standard was also processed through ANSI and was given the designation ANSI A190.1-1973. Amendment 1 to this Standard was developed in accordance with the Department of Commerce Procedures for the Development of Voluntary Product Standards and became effective on July 19, 1976. In 1982, AITC requested that this Standard be revised as American National Standard ANSI/AITC A190.1-1983.

The revision was accomplished under the ANSI canvass process and was approved by the ANSI Board of Standards Review on June 3, 1983.

In 1991, AITC requested this Standard be revised as American National Standard ANSI/AITC A190.1-1992. This revision was again accomplished under the ANSI canvass process and approved by the ANSI Board of Standards Review on March 16, 1992.

In 2002, AITC requested this Standard be revised as American National Standard ANSI/AITC A190.1-2002. This revision was again accomplished under the ANSI canvass process and approved by the ANSI Board of Standards Review on October 10, 2002.

## 10. DEFINITIONS

For the purposes of this Standard, the following definitions shall apply:

**Accredited inspection and testing agency** --- an organization that conforms to 7.1.

**Assembly Time** --- Total assembly time is the interval of time between spreading of the adhesive on the laminations and application of final pressure to the entire assembly. Assembly time may be separated into open and closed assembly periods.

**Bending Members** --- Members that are stressed

principally in bending such as beams, girders and purlins.

**Bond Line** --- The layer of adhesive which attaches two adherents.

**Bonded Assembly of Laminations** --- A bonded member intended to be bonded to other assemblies or other laminations to form a completed glued laminated member.

**Camber** --- The small amount of curvature built into a glued laminated timber to offset anticipated deflection or to facilitate roof drainage.

**COV** --- Coefficient of Variation. A statistical term equal to the sample standard deviation divided by the sample average.

**Compression Members** --- Members that are stressed principally in axial compression such as columns, compression chords of trusses, and arches.

**Curing Time** --- The period of time which an adhesive takes to attain a specified degree of cure.

**Curved Members** --- Members which are designed so that significant curvature remains after deflection due to service loads has taken place, such as curved beams and arches.

**Custom Members** --- Members that are manufactured to meet specific job specifications.

**Delamination** --- The separation of layers in an assembly because of failure of the adhesive, either in the adhesive itself or at the interface between the adhesive and the lamination.

**Depth** --- The cross-sectional dimension which is measured parallel to the direction of the principal load on the member in bending.

**Dry service conditions** --- Environmental exposure conditions that result in a member moisture content of less than 16% in service.

**Eased Corner** --- Slightly rounded surfacing of corner of member to remove sharp edge.

**Equilibrium Moisture Content** --- Any piece of wood will give off or take on moisture from the surrounding atmosphere until the moisture in the wood comes to equilibrium with that in the atmosphere. The moisture content of the wood at the point of balance is called the equilibrium moisture content and is expressed as a percentage of the oven-dry weight of the wood.

**E-Rated Lumber** --- Lumber that has been non-destructively tested to determine the modulus of elasticity.

**Five Percent Tolerance Limit with 75% Confidence** --- A statistical term describing the lower estimate bound of the fifth percentile that ensures that the population fifth percentile equals or exceeds the estimate 75% of the time.

**Full Size End Joint Tension Test** --- Testing in tension parallel to grain of the full lamination cross section containing the end joint.

**Gap-Filling Adhesive** --- An adhesive that has the

capability of filling voids of up to 1/16 in between two mating surfaces and possesses the required strength and durability.

**Hardwood, Non-Dense** --- Any hardwood having an average specific gravity of 0.42 or less when determined by oven-dry weight and green volume.

**In-Line Tests** --- Tests conducted during manufacture rather than on finished production.

**Inserts** --- Wood strips inserted in the sides and faces of glued laminated timber.

**Joint Area** --- Describes the area of the bond line and is usually expressed in square feet.

**Joint, Edge** --- The joint formed by two or more pieces of lumber laid edge to edge to form a full width lamination

**Joint, End** --- A joint formed by joining pieces of lumber end to end with adhesives.

**Joint, Face** --- The joint occurring between the wide faces of laminations.

**Joint, Finger** --- An end joint made up of several meshing fingers of wood.

**Joint, Scarf** --- An end joint formed by joining with adhesive the ends of 2 pieces that have been tapered to form sloping plane surfaces. In some cases, a step or hook is machined into the scarf to facilitate alignment of the 2 ends, in which case, the plane is discontinuous and the joint is known as a stepped or hooked scarf joint.

**Laminated Veneer Lumber** --- Lumber made by laminating veneers in which the grain of all the veneers is essentially parallel to the longitudinal axis of the piece.

**Laminating** --- The process of bonding laminations together with adhesive, including the preparation of the laminations, the mixing and spreading of adhesive, the assembly of the wood and adhesive into members by applying pressure to the bond lines and curing the adhesive in the complete assembly.

**Lamination** --- A full width and full length of wood composed of one or several pieces of lumber in width or length.

**Lot** --- A definite quantity of product or material accumulated under conditions that are considered uniform for sampling purposes.

**Lot, Adhesives** --- Generally used by adhesive manufacturers to identify a "batch" or "blending" of adhesive.

**Machine Stress Rated (MSR) Lumber and Machine Evaluated Lumber (MEL)** --- Lumber that has been evaluated by mechanical stress-rating equipment and includes a strength test for qualification. This lumber is also required to meet certain visual requirements as set forth in the grading rules.

**Manufactured Lumber** --- Two or more pieces or strips of lumber structurally bonded to form a single piece of lumber. It is intended primarily for tension laminations.

**Mechanically Graded Lumber** --- the result of a process using mechanical or physical evaluation, combined with visual grading, to sort lumber into categories for the assignment of design properties. Mechanically graded lumber includes E-rated, machine stress rated (MSR), and machine evaluated lumber (MEL).

**Moisture Content** --- The amount of water contained in the wood, usually expressed as a percentage of the weight of oven-dry wood.

**Multiple-Piece Lamination** --- A lamination which contains 2 or more pieces of lumber across the width of the lamination. The edges may or may not be bonded. If not bonded, the edge joints in adjacent laminations must be staggered at least the net thickness of the lamination.

**Non-custom Members** --- Members that are not manufactured for a specific job specification.

**Occasional** --- For purposes of this Standard, where there is provision within the scope of the applicable rule or standard that allows for random variation in production practices, a frequency of occurrence of not more than 5% (1 in 20) shall apply. When the term occasional applies to lumber grading, a frequency of occurrence of not more than 10% (1 in 10) shall apply.

**Physical tests** --- Physical tests as presented in this Standard include in-line tests and mechanical tests for quality control.

**Pot Life (working life of mixed adhesive)** --- The period of time during which an adhesive, after mixing with catalyst, solvent or other compounding ingredients, remains suitable for use.

**Production Check-Points** --- Those locations in production where an individual production step has been completed and is checked for conformance to the requirements of this Standard.

**Proof Loading** --- Application of a known load to a lamination, either tension or bending.

**Proof Grading** --- Grading of lumber by strength testing of each piece in tension to a predetermined level in order to ensure single member performance.

**QSL** --- Qualification Stress Level. The property established by dividing the end joint qualification lower 5<sup>th</sup> percentile with 75% confidence by a factor: either 1.67 for bending or compression members or 2.1 for tension members.

**Relative Humidity** --- The ratio of actual pressure of existing water vapor to maximum possible pressure of water vapor in the atmosphere at the same temperature, expressed as a percentage.

**Representative Sample** --- Portions or sections of glued laminated timber that represent specific conditions surrounding the manufacturing process.

**Ripping** --- The process of sawing any width lumber to develop narrower lumber.

**Sample** --- A group of specimens collected for testing.

**Storage Life** --- The period of time during which a packaged adhesive can be stored under specified temperature and humidity conditions and remain suitable for use.

**Structural Glued Laminated Timber** --- An engineered, stress rated product of a timber laminating plant comprising assemblies of specially selected and prepared wood laminations securely bonded together with adhesives. The grain of all laminations is approximately parallel longitudinally. The laminations may be comprised of pieces end joined to form any length, of pieces placed or bonded edge-to-edge to make wider ones or pieces bent to curved form during bonding.

**Tension Members** --- Members that are stressed principally in axial tension, such as the tension chords in trusses and tension tie members.

**Test Specimen** --- All or part of a sample that has been selected for testing.

**Wet-service conditions** --- Environmental exposure conditions that result in a member moisture content of 16% or greater in service.

**Wet-use adhesives** --- Adhesives that comply with ASTM D2559.

**Width** --- The cross-sectional dimension which is measured perpendicular to the direction of the principal load on the member in bending.

**Wood Failure** --- That portion of a bonded surface which in cyclic delamination or strength tests exhibits ruptured wood fiber as opposed to failure at the bond line.

## Annex A (Mandatory Information)

This Annex is a part of American National Standard, *Structural Glued Laminated Timber*.

### 11. Referenced Documents

From time to time, these referenced documents are updated and revised. Newer versions of these documents shall be used if they have been reviewed and determined to be applicable and consistent with this standard by the Technical Review Board (see section 7.2 (c)).

**AITC Test T102-1992**, *Adhesive Spread Measurement*

**AITC Test T103-1992**, *Calibration of Plant Pressure System: Bolts or Screw Type Jacks*

**AITC Test T104-1992**, *Calibration of Torque Wrenches*

**AITC Test T105-1992**, *Diagnostic Tests for Finger Joint Quality*

**AITC Test T106-1992**, *Strip Tension Test for End Joints Used in Lamination Repair*

**AITC Test T107-1992**, *Shear Test*

*AITC Test T110-1992, Cyclic Delamination Test*

*AITC Test T115-1992, Machining Test for End Joints*

*AITC Test T118-1992, Bending Proof Loading for End Joints*

*AITC Test T119-1992, Full Size End Joint Tension Test*

*AITC Test T121-1992, Tension Proof Loading for End Joints*

*AITC Test T122-1992, Mix Ratio Check for Automatic Adhesive Mixing Machines*

*AITC Test T123-1992, Sampling, Testing and Data Analysis to Determine Tensile Properties of Lumber*

*AITC 401-1992, Standard for Qualification of Solid Sawn and Manufactured Lumber for Use in Structural Glued Laminated Timber*

*AITC 402-1992, Standard for Laminated Veneer Lumber (LVL) Used In Structural Glued Laminated Timber*

*AITC 403-1992, Standard for the Use of End Joints for Lamination Repair*

*AITC 404-1992, Standard for Radially Reinforcing Curved Glued Laminated Timber to Resist Radial Tension*

*AITC 405-1992, Standard for New Wet-Use Structural Adhesive Types*

*AITC 406-1992, Standard for Proof-Graded Lumber for Glued Laminated Timber*

*AITC 119-96, Standard Specifications for Structural Glued Laminated Timber of Hardwood Species*

*ASTM D 2555-96 Standard Methods for Establishing Clear Wood Strength Values*

*ASTM D 2559-96 Standard Specification for Adhesives for Structural Laminated Wood Products for Use Under Exterior (Wet Use) Exposure Conditions*

*ASTM D 3434-96 Standard Test Method for Multiple-Cycle Accelerated Aging Test (Automatic Boil Test) for Exterior Wet Use Wood Adhesives*

*ASTM D 3737-01a Standard Method for Establishing Stresses for Structural Glued-Laminated Timber (Glulam) Manufactured from Visually Graded Lumber*

*ASTM D 4442-92 Standard Test Methods for Direct Moisture Content Measurements of Wood and Wood-Base Materials*

*ASTM D 4444-92 Standard Test Methods for Use and Calibration of Hand-Held Moisture Meters*

*ASTM D 5456-99a Standard Specification for Evaluation of Structural Composite Lumber Products*

## **Annex B (Mandatory Information)**

This Annex is a part of American National Standard, *Structural Glued Laminated Timber*.

## **12. Standard Appearance Grades for Structural Glued Laminated Timber**

### **12.1 Framing Appearance Grade**

- 12.1.1. Laminations are permitted to possess the natural growth characteristics of the lumber grade.
- 12.1.2. Voids appearing on the edge of laminations need not be filled.
- 12.1.3. Loose knots and open knot holes in the wide face of laminations exposed to view need not be filled. Gaps in edge joints appearing on the wide face of laminations exposed to view need not be filled.
- 12.1.4. Members are required to be surfaced “hit or miss” on two sides only to match conventional framing lumber sizes. The following appearance requirements apply only to these two sides. Misses and low laminations are permitted. The maximum area of low laminations shall not exceed 25% of the surface area of a side. Wane (limited to a maximum of 1/4 in. measured across the width) is permitted on a cumulative basis. The accumulative depth of hit or miss and wane shall not exceed 10% of the width of the member at any glue-line. The frequency of occurrence shall not exceed one in 10 pieces of lumber used.
- 12.1.5. In accordance with the provisions in 12.1.4, wane (limited to 1/4 in. measured across the width) is permitted in all combinations and is not limited in length. Occasional wane approximately one foot in length and not exceeding the permissible depth of a low lamination shall be permitted in all combinations without regard to the cumulative effects indicated in 12.1.4. Wane permitted in specific laminating combinations up to 1/6 the lumber width on each side is not limited in length.
- 12.1.6. Hit or miss surfaces may change the net finished sizes and tolerances given in 4.2. Depending on the degree of hit or miss, it may be necessary for the designer to compensate for the resulting loss of cross section.

### **12.2. Industrial Appearance Grade**

- 12.2.1. Laminations are permitted to possess the natural growth characteristics of the lumber grade.
- 12.2.2. Voids appearing on the edge of laminations need not be filled.
- 12.2.3. Loose knots and open knot holes in the wide face of laminations exposed to view shall be filled. This restriction does not apply for glued laminated timber truss members. Gaps in edge joints appearing on the wide face of laminations exposed to view need not be filled.
- 12.2.4. Members are required to be surfaced on two sides only. The following appearance requirements apply only to these two sides.

Occasional misses, low laminations or wane (limited to a maximum of 1/4 in. measured across the width) are permitted on a cumulative basis. The cumulative depth of the misses, low laminations, and wane shall not exceed 10% of the width of the member at any glue line. The frequency of occurrence shall not exceed one in 10 pieces of lumber used. The maximum area of low laminations shall not exceed 5% of the surface area of a side, and no more than two low laminations shall be adjacent to one another.

- 12.2.5. In accordance with provisions in 12.2.4, wane (limited to 1/4 in. measured across the width) is permitted in all combinations, and is not limited in length. Occasional wane approximately one foot in length and not exceeding the permissible depth of a low lamination shall be permitted in all combinations without regard to the cumulative effects indicated in 12.2.4. Wane permitted in specific laminating combinations up to 1/6 the lumber width on each side is not limited in length.

### 12.3. Architectural Appearance Grade

- 12.3.1. Laminations are permitted to possess the natural growth characteristics of the lumber grade.
- 12.3.2. In exposed surfaces, voids measuring over 3/4 in. shall be filled by the fabricator with a wood-tone colored filler that reasonably blends with the final product or with clear wood inserts selected for similarity to the grain and color of the adjacent wood.
- 12.3.2.1. For appearance grading purposes, measurement of voids shall be in the direction of the length of the lamination and shall not exceed 3/4 in. except that a void may be longer than 3/4 in. if its area does not exceed 1/2 sq. in. Void measurement limitations apply only to the surfaces of the member exposed in the final structure. All characteristics shall be considered with respect to their effects on general appearance.
- 12.3.3. The wide face of laminations exposed to view shall be free of loose knots. Open knot holes shall be filled. Voids greater than 1/16 in. wide in edge joints appearing on the wide face of laminations exposed to view shall be filled.
- 12.3.4. Exposed faces shall be surfaced smooth. Misses and wane are not permitted.
- 12.3.5. The corners of the member exposed to view in the final structure shall be eased with a minimum radius of 1/8 in.

### 12.4. Premium Appearance Grade

- 12.4.1. Laminations are permitted to possess the natural growth characteristics of the lumber grade.
- 12.4.2. In exposed surfaces, voids shall be filled by the fabricator with a wood-tone colored filler that

reasonably blends with the final product or with clear wood inserts selected for similarity to the grain and color of the adjacent wood.

- 12.4.3. The wide face of laminations exposed to view shall be selected for appearance and shall be free of loose knots. Voids shall be filled. Knot size shall be limited to 20% of the net face width of the lamination. Not over two maximum size knots or their equivalent shall occur in a 6 ft length. Voids greater than 1/16 in. wide in edge joints appearing on the wide face of laminations exposed to view shall be filled.
- 12.4.4. Exposed faces shall be surfaced smooth. Misses and wane are not permitted.
- 12.4.5. The corners of the member exposed to view in the final structure shall be eased with a minimum radius of 1/8 in.

## Appendix A—Field Reinspection Practices (Non-mandatory information)

This Appendix is not a part of American National Standard, *Structural Glued Laminated Timber*, but is included for information purposes only.

**A1. General**—Compliance with bonding provisions of job specifications can be checked and verified during the manufacture of structural glued laminated timber provided such compliance is based on performance testing and on an inspection of conditions and procedures during all stages of the manufacturing process. A different condition exists in attempting to determine compliance with requirements for bond line quality in finished production, and such determination other than by visual inspection is not always practicable and feasible. For example, indisputable proof of the structural integrity of bond line quality in a finished member may be satisfactorily established in some cases only at the risk of rendering the member unfit or worthless for the purpose for which it was produced. In order to protect the seller against unfairness in situations of this kind and also to provide fair and equitable treatment to the purchaser, the provisions of this appendix are offered in the interest of fair trade practice.

**A2. Complaint Adjustment Responsibility**—The shipment of structural glued laminated timber should comply with job specifications in all respects but any complaint requiring an adjustment in the invoice or material should be filed with the seller in writing within 15 days after receipt of unwrapped products, or 15 days after unwrapping wrapped products. If a purchaser requests adjustment from the seller on any material claimed by the purchaser to be unsatisfactory, such material should be held intact in the same form as shipped for such reasonable time as may be necessary to permit inspection by the accredited inspection and testing agency and should be protected from damage or from conditions

that would cause serious degrade or deterioration in quality.

**A3. Purchaser and Seller Responsibility After Reinspection**---To the extent that material deficient in quality is determined through reinspection to be a responsibility of the seller, the purchaser should be relieved of responsibility for accepting such material, but the purchaser should be obligated to accept such material as complies with the job specifications or for which the purchaser is responsible.

**A4. Reinspection Costs**---If it is determined through reinspection that the material under complaint meets the specified requirements, the purchaser should be obligated to accept such material and pay the cost of reinspection, but if it does not meet specified requirements, the seller should be obligated for this cost.

## Appendix B—Reference Documents (Non-mandatory information)

This Appendix is not a part of American National Standard, *Structural Glued Laminated Timber*, but is included for information purposes only.

AITC 200-92	<i>Inspection Manual</i>
AITC 109-98	<i>Standard for Preservative Treatment of Structural Glued Laminated Timber</i>
AITC 110-97	<i>Standard Appearance Grades for Structural Glued Laminated Timber</i>
AITC 111-79	<i>Recommended Practice For Protection, of Structural Glued Laminated Timber During Transit, Storage and Erection</i>
AITC 113-93	<i>Standard for Dimensions of Structural Glued Laminated Timber</i>
AITC 117-93	<b>DESIGN</b> , <i>Standard Specifications for Structural Glued Laminated Timber of Softwood Species</i>
AITC 117-93	<b>MANUFACTURING</b> , <i>Standard Specifications for Structural Glued Laminated Timber of Softwood Species</i>
AITC Test 124	<i>Reinspection or Testing of Individual Lots of E-rated Lumber for Conformance to Specifications</i>
AITC Technical Note 7	<i>Calculation of Fire Resistance of Glued Laminated Timbers</i>
APA EWS S580	<i>Preservative Treatment of Glulam Beams</i>
APA EWS Y110	<i>Glued Laminated Timber Appearance Classifications for Construction Applications</i>
APA EWS Y117	<i>Glulam Design Properties and Layup</i>

## Combinations

APA EWS Y245 *Calculating Fire Resistance of Glulam Beams and Columns*

## Appendix C (Non-mandatory information)

**Standard Grading Rules (approved by the Board of Review of the American Lumber Standard Committee):**

*Standard Specifications for Grades of California Redwood Lumber*

Redwood Inspection Service  
405 Enfrente Drive, Suite 200  
Novato, California 94949

*Official Grading Rules for Eastern White Pine, Norway Pine, Jack Pine, Eastern Spruce, Balsam Fir, Eastern Hemlock, Tamarack, Aspen and Cottonwood*

Northern Softwood Lumber Bureau  
272 Tuttle Road, P.O. Box 87A  
Cumberland Center, Maine 04021

*Standard Grading Rules For Northeastern Lumber*

Northeastern Softwood Lumber Manufacturers Association  
272 Tuttle Road, P.O. Box 87A  
Cumberland Center, Maine 04021

*Standard Grading Rules for Southern Pine Lumber*

Southern Pine Inspection Bureau  
4709 Scenic Highway  
Pensacola, Florida 32504

*Standard Grading Rules for West Coast Lumber*

West Coast Lumber Inspection Bureau  
P.O. Box 23145  
6980 S.W. Varnes Street  
Portland, Oregon 97223

*Standard Grading Rules for Western Lumber*

Western Wood Products Association  
Yeon Building  
522 SW Fifth Avenue, Suite 500  
Portland, Oregon 97204-2122

*Standard Grading Rules for Canadian Lumber*, United States Edition

National Lumber Grades Authority  
406 First Capital Place  
960 Quayside Drive  
New Westminster, B.C., Canada V3M 6G2

## Appendix D—Guide for Specifying (Non-mandatory information)

This Appendix is not a part of American National Standard, *Structural Glued Laminated Timber*, but is

included for information purposes only.

The following is a recommended guide for specifying structural glued laminated timber.

**D1. Scope**---All structural glued laminated timber shall be as shown detailed on the plans and specified herein.

**D2. Shop Details**---Shop details shall be furnished by the \_\_\_\_\_ and approval obtained from buyer before work is commenced.

**D3. Manufacture**---Materials, Manufacture and Quality Control shall be in conformance with ANSI/AITC A190.1-2002, *Structural Glued Laminated Timber*.

**D4. Laminating Combinations**---Lamination combinations shall meet the requirements of ANSI/AITC A190.1-2002, *Structural Glued Laminated Timber*, and shall provide allowable design values of:

\_\_\_\_\_ psi in bending ( $F_{bx}$ ),

\_\_\_\_\_ psi in bending ( $F_{by}$ ),

\_\_\_\_\_ psi in tension parallel to grain ( $F_t$ ),

\_\_\_\_\_ psi in compression parallel to grain ( $F_c$ ),

\_\_\_\_\_ psi in compression perpendicular to grain (top) ( $F_{c\perp x}$ ),

\_\_\_\_\_ psi in compression perpendicular to grain (bottom) ( $F_{c\perp y}$ ),

\_\_\_\_\_ psi in horizontal shear ( $F_{vx}$ ),

\_\_\_\_\_ psi in horizontal shear ( $F_{vy}$ ),

\_\_\_\_\_ psi in modulus of elasticity ( $E_x$ ),

\_\_\_\_\_ psi in modulus of elasticity ( $E_y$ ).

*The design values for loads applied perpendicular to the wide faces of the laminations causing bending about the x-x axis are designated by the subscript x. The design values for loads applied parallel to the wide faces of the laminations causing bending about the y-y axis are designated by the subscript y.*

*(Check one of the following.)*

Above design values are based on:

DRY service condition (when the moisture content of the member will be less than 16% in service).

WET service condition (when the moisture content of the member will be equal to or greater than 16% in service).

**D5. Adhesives**---Adhesives shall meet the requirements of *(check one)*:

DRY-SERVICE for dry condition of service.

WET-SERVICE for wet conditions of service.

*See explanation of service conditions under laminating combinations above.*

**D6. Appearance**---Appearance of members shall be *(check one)*:

FRAMING GRADE

INDUSTRIAL GRADE

ARCHITECTURAL GRADE

PREMIUM GRADE

OTHER (Specify)

**D7. Protection**---Surfaces of members shall be *(check one or more)*:

NOT SEALED

END SEALED

SURFACE SEALED

OTHER (Specify)

**D.7.1** Surface sealers increase resistance to soiling, control grain raising, minimize checking and serve as a moisture retardant. Surface sealers fall into the two classifications: Penetrating sealers and Non-Penetrating Sealers. Penetrating sealers have a low solid content. They provide limited protection and are suitable for use when final finish requires staining. Non-penetrating sealers have higher solid content and provide maximum protection by sealing the surface of the wood. They should not be specified when final finish requires a natural or stained finish.

Members shall be *(check one)*:

NOT WRAPPED

LOAD WRAPPED

BUNDLE WRAPPED

INDIVIDUALLY WRAPPED

**D8. Quality Marks and Certificates**--- *(Check one)*:

Members shall be marked with a Quality Mark indicating conformance with ANSI/AITC A190.1-2002, *Structural Glued Laminated Timber*.

Members shall be marked with a Quality Mark and, in addition, a Certificate of Conformance shall be provided to indicate conformance with ANSI/AITC A190.1-2002, *Structural Glued Laminated Timber*.

**D9. Optional Considerations**---The following specifications are sometimes desired. They are covered here briefly for your consideration and convenience.

**D9.1 Preservative Treatment**---When the conditions of service are such that pressure preservative treatment to prevent attack by fungi or insects is required, information such as the following should be given in your specification:

( ) The preservative shall be \_\_\_\_\_

( ) The retention shall be \_\_\_\_\_

*(Note: Refer to AITC 109, Treating Standard for Structural Glued Laminated Timber, for complete data.)*

**D9.2 Steel and Hardware---** The \_\_\_\_\_ shall furnish connection steel and hardware for joining timber members to each other and to their supports exclusive of anchorage embedded in masonry, setting plates and items field-welded to structural steel. Metal shapes to have one coat of shop applied paint containing rust inhibitor.

# American Institute of Timber Construction

A national non-profit technical organization of laminators and fabricators devoted to expanding proper use of engineered timber construction, providing identification of products conforming to this Product Standard through the Quality control and Inspection functions of the AITC Inspection Bureau.

Look for this  
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**QUALITY**



For additional information on structural glued laminated timber  
and engineered timber construction, write or call.

## AMERICAN INSTITUTE OF TIMBER CONSTRUCTION

7012 S. Revere Parkway, Suite 140

Englewood, CO 80112-5092

Phone: 303-792-9559

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**ANSI/AITC A190.1-2002**