

## **GENERAL RULES (All Species)**

**(NOTE:** Characters included in a higher grade are automatically accepted in lower grades)

*Flooring shall be Tongued and Grooved and End Matched (unless otherwise indicated). Flooring shall not be considered of standard grade unless the lumber from which the flooring is manufactured has been properly kiln dried. The NOFMA standard is that flooring is manufactured at a 6% - 9% Moisture Content with a 5% allowance for pieces outside that range up to 12% Moisture Content, and to fit a "GO NO-GO" NOFMA flooring gauge.*

*NOFMA members are required to mark all bundles of standard grade flooring with the grade and color (or species if applicable).*

*Plank Flooring designated by a grade name listed in this Grading Rule Book **must** conform to that grade description.*

*Members may manufacture Plank Flooring under other grade names and descriptions which are registered with the NOFMA office to qualify for Complaint Inspection Services.*

### **Packaging**

*To determine the (nominal) length of a piece of flooring, 3/4" end match allowance shall be added to the actual face length when measuring.*

*Individual strips may range in length from 9" minimum to 102" maximum.*

*The average length as referred to in the Official Flooring Grading Rules apply to the total footage of any one shipment consisting of 1,000 sq. ft. or greater amounts.*

*The percentages under 4', as referred to in the Official Flooring Grading Rules apply to the total footage of any one shipment consisting of 1,000 sq. ft. or greater amount.*

*Bundled flooring- an individual bundle contains pieces from 6" over to 6" under the nominal length of the bundle. Bundle lengths ranging from 1 1/4' to 8', as the stock will produce.*

*For 3/4 x 2 1/4" Flooring- a 12 run, 8' nominal length bundle, containing 24 bd. ft. of flooring is designated "standard packaging".*

## **NOFMA OAK FLOORING GRADING RULES**

**(NOTE:** Characters included in a higher grade are automatically accepted in lower grades.)

**CLEAR OAK**

*A flooring product of mostly heartwood with a minimum number of character marks and discoloration, providing a uniform appearance while allowing for all heartwood natural color variations.*

*Will admit the following: 3/8" bright sapwood entire length of strip or equivalent if not extending further than 1" for 1/3 length of piece; small burls and fine pin worm holes; and equivalent characters such as small tight checks; in the absence of these, one thin brown streak 3" long to be allowed every 6'.*

*Standard Packaging - Bundles to be 1-1/4' to 8'.*

**SELECT OAK**

*A flooring product with coloration variations produced by differences of natural heartwood and sapwood, along with characters described.*

*The face may contain: unlimited sound sapwood; slight imperfections in milling; a small tight knot every 3'; pin worm holes; burls and a reasonable amount of slightly open checks. Brown streaks should not extend the entire length of a piece. Two flag worm holes to every 8' are permitted. Slight imperfections in face work (torn grain) admitted. An intermittent, brown machine burn across the face not exceeding 1/4" width admitted. Also, a slight quantity of bark on the back or sides admitted. Will admit pieces with 1/2 tongue. Spot filling is generally required for open characters.*

*Standard Packaging - Bundles to be 1 1/4' to 8'.*

**#1 COMMON OAK**

*A flooring product which contains prominent variations in coloration and varying characters.*

*The following are not admitted: broken knots over 1/2" in diameter, large grub worm holes; and splits extending through the piece. Open characters such as checks and knot holes are admitted, but must be sound and readily fill. Not more than 20" scant stock in thickness allowed to every 5'. Minor imperfections in machining permitted. Shall admit sticker stain; varying wood characteristics, such as flag worm holes, heavy streaks, checks, and worm holes; and an occasional dark machine burn across the face not exceeding 1/2" wide, 1/64" deep and not more than two each 3'. 1/4 tongue allowed. Extremely dark pieces are not to be included.*

*Standard Packaging - Bundles to be 1-1/4' to 8'.*

**#2 COMMON OAK**

*May contain sound natural variations of the forest product and manufacturing imperfections.*

*The purpose of this grade is to furnish a floor suitable for homes, general utility use, or where character marks and contrasting appearance is desired.*

*The following are not admitted: shattered or rotten ends, large broken knots, excessive bad millwork, shake, advanced rot, and similar unsound defects. Dark machine burns exceeding 3/64" deep not admitted. Knot holes and open characters which will readily fill are admitted. A limited number of pieces with no tongue which may be face nailed are admitted.*

*Standard Packaging - Bundles to be 1-1/4' to 8'*

## **HARD MAPLE GRADING RULES**

*NOFMA recognizes 3/4", 25/32" and 33/32" as standard thicknesses for the manufacture of Hard Maple. NOFMA members may, at their option, produce either 25/32" or 3/4" thick Hard Maple flooring.*

### **CLEAR HARD MAPLE**

*Shall have the face practically free of all defects, but the natural color of the wood shall not be considered a defect. The highest standard grade, combines appearance and durability.*

*Will admit the following: variations in the natural color of the wood (with use of some finishes, slight shadows and color variation may appear); an occasional small, firm pin knot, not over 1/8" in diameter, provided it does not occur on edges or ends of strips; occasional dark green or black spots or streaks not over 1/4" wide and 3" long (or its equivalent) which may contain a tight check not over 1/2" long, provided it is boxed within the piece; bird's eyes and small burls; slightly torn grain; or similar defect which can be readily removed by the ordinary method of sanding the floor after it is laid; a slightly shallow place not over 12" long on underside of the flooring if it does not extend to either end of the piece. Pieces with 1/2" tongue for no more than 25% of the length are allowed. The wood must be sound and free of shake. Bark streaks shall not be permitted.*

*Bundles shall be 1-1/4' to 8' as the stock will produce. Not over 55% of the total footage shall be in bundles under 4'; Not more than 25% of the total footage shall be in 2' bundles, and not more than 10% of the footage shall be in 1-1/4' bundles.*

### **#1 COMMON HARD MAPLE**

*A floor with varying wood characteristics and colors to include distinct color variations, numerous streaks, stained sapwood, sound knots, and checks. All defects must readily fill.*

*Will admit the following: sound tight knots, provided they do not occur on edges or ends of strips; slight imperfections in machining; distinct color variations; sticker stain/shadow; numerous dark green or black spots or streaks, provided they do not occur in combination with predominantly dark heartwood; slight checks not exceeding 3" in length (may be slightly open) and running parallel with and well inside the edges and ends of the strips; dark spots or*

*streaks with slight checks in center; small rough spots (torn grain) which cannot be wholly removed by ordinary method of sanding the floor after it is laid; slightly torn edges; short tongue if sufficient to hold properly in the floor; shallow or waney back, if piece has sufficient bearing of full thickness to support it in the floor; small bark streaks where bark is as sound as surrounding wood; and slight variation in angle of end matching. The face shall be free of shake and wood must be sound.*

*Bundles shall be 1-1/4' to 8', as the stock will produce. Not over 60% of the total footage shall be in bundles under 4', not more than 27% of the total footage shall be in 2' bundles; and not more than 15% of the footage shall be in 1-1/4' bundles.*

### **#2 COMMON HARD MAPLE**

*Must be of such character as will lay and give a good serviceable floor. The wood must be firm, serviceable and may contain all defects common to maple. Pieces with 1/4 full tongue admitted.*

*#2 Common grade will not admit- knot holes over 3/8" in diameter or unsound knots where the unsound portion is over 1" in diameter; voids on ends or edges; or shake, heart checks, badly split ends and imperfections in manufacture which would materially impair the serviceability of the floor.*

*Bundles shall be 1-1/4' to 8', as the stock will produce. Not over 85% of the total footage shall be in bundles under 4'; and not more than 55% of the total footage shall be 1-1/4' bundles.*

### **#1 COMMON & BETTER HARD MAPLE**

*A combination of CLEAR, SELECT, and #1 COMMON developing from the production run. The lowest grade pieces admissible shall not be less than #1 COMMON.*

*Bundles shall be 1 1/4' and longer through 8' as the stock will produce. Not over 60% of the total footage shall be in bundles under 4'. Not more than 27% of the total footage shall be in 2' bundles, and not more than 15% of the footage shall be 1 1/4' bundles.*

## **NOFMA ASH GRADING RULES**

### **CLEAR ASH**

*The face shall be practically free of defects.*

*The following characters are admitted: small burls (less than 1/8" in diameter); fine pin worm holes with no discoloration (1 for every 3' in length); or in the absence of these, one (1) thin light brown streak (3" long to be allowed for every 6' of length or equivalent).*

*Brown heartwood is allowed as follows; 3/8" entire length or 1" for one-third the length of the strip.*

*Clear Ash is usually chosen for it's light color. Bundles to be 1 1/4' to 8'.*

### **SELECT ASH**

*The face shall contain mostly sapwood, unstained.*

*The following characters are admitted: narrow streaks not running entire length of the strip; pin worm holes (up to 3 every 3' in length); imperfection in milling (torn grain) which will sand out; one (1) small tight knot (1/4" in diameter) to every 3' in length; small pith fleck (less than 1/4" diameter); an intermittent brown machine burn across the face not exceeding 1/4" in width; and unlimited cambium miners.*

*Brown heartwood is allowed as follows: 3/8" entire length or 1" for one-third the length of the strip.*

*Will admit pieces with 1/2 tongue. Most defect are lost sight of after the floor is laid and finished, giving a good appearance.*

*Bundles to be 1 1/4' to 8'.*

### **#1 COMMON ASH**

*A floor with varying wood characteristics such as heavy streaks, stained sapwood, and sound knots typical of this grade. All defects must readily fill and be sound.*

*The following characters are admitted: broken knots up to 1/2" in diameter; pith flecks less than 3/16" in diameter; worm holes up to 3/16"; checks and end splits less than 1/16" wide and not extending through the piece; and sticker stain.*

*Minor imperfections in machining permitted; torn grain (not over one-fourth (1/4) of the surface, less than 1/26" in depth); one (1) dark machine burn across the face for every 3' of length, not exceeding 1/2" in width, 1/64" in depth.*

*Will admit pieces with 1/4 to 8'.*

### **#2 COMMON ASH**

*Defects of every character admitted, but should lay a serviceable floor.*

*The following defects are NOT allowed: soft rot; broken knots where the unsound portion extends through piece; Torn grain over 3/16" in depth; splits and open defects extending through the piece; shake and pith flecks that are soft if over 1/4" in diameter.*

*Knot holes and defects which will readily fill are admitted.*

*A limited number of pieces with no tongue and limited number of pieces that are thin (scant) in*

*thickness but will end match admitted. Bundles to be 1 -1/4' to 8'.*