



Designation: **D1990—16 D1990 – 19**

# Standard Practice for Establishing Allowable Properties for Visually-Graded Dimension Lumber from In-Grade Tests of Full-Size Specimens<sup>1</sup>

This standard is issued under the fixed designation D1990; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ε) indicates an editorial change since the last revision or reappraisal.

## INTRODUCTION

Visual stress-grades of lumber manufactured in North America have evolved from the procedures of Practice **D245**. Allowable stress and modulus of elasticity values were determined for these grades using the procedures of Practice **D245** and the appropriate clear wood values of Practice **D2555**. The clear wood values of Practice **D2555** were developed from tests of small clear specimens.

Development of allowable stress and modulus of elasticity values from tests of full-size structural lumber as commercially produced and marketed has become possible with the development of suitable test equipment that permits rapid rates of loading to test large numbers of pieces from commercial lumber production. These tests can be carried out at the production sites or in a laboratory.

### 1. Scope

1.1 This practice covers the principles and procedures for establishing allowable stress values for bending, tension parallel to grain, compression parallel to grain and modulus of elasticity values for structural design from “In-Grade” tests of full-size visually graded solid sawn dimension lumber. This practice also covers procedures for periodic monitoring, and additional procedures, if needed, for evaluation and possible reassessment of assigned design values. This practice is focused on, but is not limited to, grades which used the concepts incorporated in Practice **D245** and were developed and interpreted under American Softwood Lumber PS 20.

1.2 A basic assumption of the procedures used in this practice is that the samples selected and tested are representative of the entire global population being evaluated. This approach is consistent with the historical clear wood methodology of assigning an allowable property to visually-graded lumber which was representative of the entire growth range of a species or species group. Every effort shall be made to ensure the test sample is representative of population by grade and size (see **7.1.1** and **7.1.2**).

1.3 Due to the number of specimens involved and the number of mechanical properties to be evaluated, a methodology for evaluating the data and assigning allowable properties to both tested and untested grade/size cells is necessary. Sampling and analysis of tested cells are covered in Practice **D2915**. The mechanical test methods are covered in Test Methods **D198** and **D4761**. This practice covers the necessary procedures for assigning allowable stress and modulus of elasticity values to dimension lumber from In-Grade tests. The practice includes methods to permit assignment of allowable stress and modulus of elasticity values to untested sizes and grades, as well as some untested properties. The practice includes procedures for periodic monitoring of the species or species group to quantify potential changes in the product and verification of the assigned design values through, evaluation, and reassessment.

NOTE 1—In the implementation of the North American In-Grade test program, allowable stress values for compression perpendicular to grain and shear parallel to grain for structural design were calculated using the procedures of Practice **D245**.

1.4 This practice only covers dimension lumber.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

<sup>1</sup> This practice is under the jurisdiction of ASTM Committee **D07** on Wood and is the direct responsibility of Subcommittee **D07.02** on Lumber and Engineered Wood Products.

Current edition approved ~~May 1, 2016~~ Oct. 1, 2019. Published ~~June 2016~~ November 2019. Originally approved in 1991. Last previous edition approved in ~~2014~~ 2016 as ~~D1990—14~~ D1990—16. DOI: ~~10.1520/D1990-16~~ 10.1520/D1990-19.

1.6 This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.

## 2. Referenced Documents

### 2.1 ASTM Standards:<sup>2</sup>

**D9 Terminology Relating to Wood and Wood-Based Products**

**D198 Test Methods of Static Tests of Lumber in Structural Sizes**

**D245 Practice for Establishing Structural Grades and Related Allowable Properties for Visually Graded Lumber**

**D1165 Nomenclature of Commercial Hardwoods and Softwoods**

**D2555 Practice for Establishing Clear Wood Strength Values**

**D2915 Practice for Sampling and Data-Analysis for Structural Wood and Wood-Based Products**

**D4442 Test Methods for Direct Moisture Content Measurement of Wood and Wood-Based Materials**

**D4444 Test Method for Laboratory Standardization and Calibration of Hand-Held Moisture Meters**

**D4761 Test Methods for Mechanical Properties of Lumber and Wood-Based Structural Materials**

**E380 Practice for Use of the International System of Units (SI) (the Modernized Metric System) (Withdrawn 1997)<sup>3</sup>**

**IEEE/ASTM SI 10 Standard for Use of the International System of Units (SI): The Modern Metric System**

### 2.2 American Softwood Lumber Standard:

**National Institute of Standards and Technology Voluntary Product Standard PS 20-94<sup>4</sup>**

## 3. Terminology

### 3.1 Definitions:

3.1.1 For definitions of terms related to wood, refer to Terminology **D9**.

### 3.2 Definitions of Terms Specific to This Standard:

3.2.1 *characteristic size*—the standard dimensions of the piece at which the characteristic value is calculated (**Note 2**).

NOTE 2—In the North American In-Grade program, the characteristic size used was 1.5 in. (38 mm) thick by 7.25 in. (184 mm) wide by 144 in. (3.658 m) in length at 15 % moisture content.

3.2.2 *characteristic value*—the population mean, median or tolerance limit value estimated from the test data after it has been adjusted to standardized conditions of temperature, moisture content and characteristic size.

#### 3.2.2.1 Discussion—

The characteristic value is an intermediate value in the development of allowable stress and modulus of elasticity values. Typically for structural visual grades, standardized conditions are 73°F (23°C), and 15 % moisture content (**Note 3**). A nonparametric estimate of the characteristic value is the preferred estimate. If a distributional form is used to characterize the data at the standardized conditions, its appropriateness shall be demonstrated. (See Practice **D2915** for guidance on selection of distribution.)

NOTE 3—The described adjustment factors and allowable stress and modulus of elasticity value assignment procedures were developed based on test data of visual grades of major volume, commercially available North American softwood species groups. For other species (see Nomenclature **D1165**) and for other grading methods, it may be necessary to verify that the listed adjustments are applicable. The commercial species groups and grading criteria used in the development of these procedures were as described in the grading rules for Douglas Fir-Larch, Hem-Fir and Southern Pine from the United States, and Spruce-Pine-Fir, Douglas fir(N), and Hem-Fir(N) from Canada (**1, 2, 3, and 4**)<sup>5</sup>. The specific species groupings, together with botanical names are given in Nomenclature **D1165**.

3.2.3 *grade quality index (GQI)*—A numerical assessment of the characteristics found in the sample specimens which are considered to be related to strength and are limited as part of the grade description. The grade quality index is a scaling parameter which allows modeling of strength and modulus of elasticity with respect to grade (**Note 4**).

NOTE 4—In the North American In-Grade test program, lumber produced in accordance with visual stress grading rules (**1, 2, 3, 4, 5, and 6**) developed from the procedures of Practice **D245** was sampled. For each test specimen a strength ratio was calculated for the particular type of failure indicated by the failure code (see Test Methods **D4761**). Strength ratios were calculated according to the formulas given in the appendix of Practice **D245** for bending and compression parallel to grain test specimens. Strength ratios for lumber tested in tension and compression parallel to grain were calculated as for bending. The sample grade quality index for each sample was calculated as the nonparametric five percentile point estimate of the distribution of strength ratios. Specimens which failed in clear wood were excluded from the sample for determining the sample GQI.

3.2.4 *In-Grade*—samples collected from lumber grades as commercially produced.

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

<sup>3</sup> The last approved version of this historical standard is referenced on [www.astm.org](http://www.astm.org).

<sup>4</sup> Available from U.S. Government Printing Office Superintendent of Documents, 732 N. Capitol St., NW, Mail Stop: SDE, Washington, DC 20401, <http://www.access.gpo.gov>.

<sup>5</sup> The boldface numbers in parentheses refer to the references listed at the end of this practice.

### 3.2.4.1 *Discussion*—

Samples collected in this manner are intended to represent the full range of strength and modulus of elasticity values normally found within a grade.

3.2.5 *monitoring, n*—a periodic review of a subset of structural properties of a lumber cell to determine if a potential downward shift from the assigned values indicates a need for an evaluation or reassessment, or both, of allowable properties developed with this practice (Stage 1).

3.2.6 *evaluation, n*—The process of examining data, including that collected over the course of a monitoring program that has detected a shift in cell properties, to determine the likely cause for the detected shift in cell properties, developing the best response to the data, and establishing that the actions are sufficient (Stage 2).

### 3.2.6.1 *Discussion*—

The response to the evaluation can include altering the grade description, or the input resource, or changing the method of processing. Testing is conducted to confirm that the action taken corrected the affected properties.

3.2.7 *reassessment, n*—The recalculation of allowable properties derived by this practice because of a change in product properties (Stage 3).

3.2.8 *statistically significant downward shift, n*—A statistically significant downward change in the monitored size grade cell property in relation to a single cell from the matrix used to derive the current allowable property for which further action is required in this Practice.

### 3.2.8.1 *Discussion*—

The Wilcoxon nonparametric statistical test showing a change that is significant at the 0.05 level has been selected as the consensus statistical method for determining when further action is required in this Standard.

3.2.9 *action level*—The lower property boundary, representing a statistically significant downward shift, used in monitoring to define the property level at which additional confirmation testing during monitoring, or further action beyond monitoring is necessary.

3.2.10 *sampling matrix*—the collective designation used to describe all of the individual test cells. The sampling matrix is intended to characterize the property trends for a range of grades for a single size or a range of sizes for a single grade or a combination of both sizes and grades for a species or species group.

### 3.2.10.1 *Discussion*—

The sampling matrix is intended to characterize the property trends for a range of grades for a single size or a range of sizes for a single grade or a combination of both sizes and grades for a species or species group.

3.2.11 *test cell*—the combined test data for a single size/grade/species/property which is intended to characterize that sampling unit.

3.2.12 *thickness*—the lesser dimension perpendicular to the long axis of lumber.

3.2.13 *tolerance limit (TL)*—refers to the tolerance limit with 95 % content and 75 % confidence.

3.2.14 *width*—the greater dimension perpendicular to the long axis of lumber.

## 4. Significance and Use

4.1 The procedures described in this practice are intended to be used to establish allowable stress and modulus of elasticity values for solid sawn, visually graded dimension lumber from In-Grade type test data. These procedures apply to the tested and untested sizes and grades when an adequate data matrix of sizes and grades exists. In addition, the methodology for establishing allowable stress and modulus of elasticity values for combinations of species and species groups is covered. Allowable stress and modulus of elasticity values may also be developed for a single size or a single grade of lumber from test data.

4.2 Methods for establishing allowable stress and modulus of elasticity values for a single size/grade test cell are covered in Practice **D2915**. The appropriateness of these methods to establish allowable stress and modulus of elasticity values is directly dependent upon the quality and representativeness of the input test data.

4.3 A monitoring program shall be established to periodically review the continued applicability of allowable properties derived by this practice. A monitoring program will establish data sets that are either the same as, above, or below the data that was used to develop the current allowable properties. Upon detection of a statistically significant downward shift, evaluation of the data and

confirmation of remedial actions shall be undertaken. When evaluation is not undertaken or the results of the evaluation indicate an adjustment to allowable properties is appropriate, a reassessment shall be conducted to re-establish allowable properties.

**NOTE 5**—It is recognized that over time there is the potential for changes in the raw material or product mix. In response to this a monitoring program must be conducted to ensure design values derived by this practice are not invalidated by such changes. If the data collected with a monitoring provides evidence of an statistically significant downward shift in lumber properties an evaluation program in accordance with the procedures of this practice is needed to detect and confirm that responses to such changes are appropriate. Evaluation, if undertaken, provides a means for responding to the data and assessing if the actions taken are sufficient. Following the confirmation of a statistically significant downward shift, reassessment of values shall be conducted if evaluation is either not undertaken or does not adequately address the downward shift.

## 5. Documentation of Results, Adjustments, and Development of Allowable Properties

### 5.1 Reporting Test Data:

#### 5.1.1 Summarizing Statistics:

5.1.1.1 Provide a set of summarizing statistics that includes sample size, mean, median, standard deviation, confidence intervals, and nonparametric point estimates and tolerance limits. If parametric methods are used to characterize the data, provide a description of selection procedures and a tabulation of distribution parameters. Document any “best fit” judgments made in the selection of a distribution.

5.1.1.2 Provide a description of all statistical methods used with the summarizing statistics.

5.1.2 *Unadjusted Test Results*—To permit verification of property calculations by regulatory and third party reviewers, unadjusted individual specimen test results shall be maintained in suitable archival form. The archived records shall be retained as long as the derived property values are applicable. Archived records shall be retained by the user of this practice and an independent public institution.

**NOTE 6**—In the United States, the USDA Forest Products Laboratory, the American Lumber Standards Committee, and colleges and universities are considered suitable independent public institutions. It may be desirable for historical or other purposes to continue to archive the records after the derived values are no longer applicable. In such cases, the records should be maintained by a public institution.

5.1.3 *Significant Digits*—With example calculations, illustrate that adequate significant digits were maintained in intermediate calculations to avoid round-off errors. Table 3 and Section 4 of Practice **E380** provide guidance.

5.2 *Graphical Presentation*—Graphical presentations are recommended to illustrate typical data sets. If parametric methods are used, histograms or cumulative distribution functions shall be shown superimposed on the parametric functions. Class widths shall meet the requirements of Practice **D2915**, Table 7.

### 5.3 Preparation of Characteristic Values

#### 5.3.1 Adjustments to Test Data:

5.3.1.1 Document each of the adjustments to the test data.

5.3.1.2 If the adjustments to the test data follow procedures found in other ASTM standards or are documented in other sources, reference these sources in a manner permitting the reader to recreate the use of these sources in the same application. Indicate the limitations of application.

5.3.1.3 In the presentation, explain adjustments made to the data which cannot be referenced to acknowledged sources.

5.3.1.4 Provide examples of all adjustment procedures.

### 5.4 Development of Allowable Properties:

5.4.1 Explain each step of the development of allowable properties with reference to the appropriate paragraph of this practice.

5.4.2 *Grouping*—Summarize all grouping calculations in tabular form and examples presented to illustrate application of limiting criteria.

5.4.3 *Allowable Property Adjustments*—Illustrate each of the adjustments for allowable properties for at least one of the size/grade combinations presented. Present all adjustments in tabular form. Examples may be presented.

5.5 *Summary/Index*—Prepare a brief summary of the presentation that highlights each of the major steps. An index or table of contents shall accompany the document that references the content and the corresponding paragraphs of this practice.

## 6. Development of Stress Grades

6.1 Stress grades for lumber are designed to separate the raw material source into marketable groups of specific quality levels to which allowable stress and modulus of elasticity values can be assigned. Stress grading systems used with this practice shall be internally consistent and continuous (**Note 7**).

**NOTE 7**—To be considered internally consistent, a grading system should not be based on two or more methods of determining an allowable property. A continuous system should not skip levels of material strength. For example, the North American In-Grade test program sampled grades which were developed using the stress ratio system of Practice **D245** (see Refs **1**, **2**, **3**, and **4**).

## 7. Minimum Sampling Matrix

7.1 *General Considerations*—Development of allowable stress and modulus of elasticity values under this practice may be for either a single size (**7.3**) or a single grade (**7.2**) or a full matrix of sizes and grades (**7.4**). The required sampling matrix is

determined by the desired end result. The intent of a sample matrix is to provide sufficient data across the sizes or grades, or both, to permit interpolation between data points. Extrapolation beyond the sample matrix may be misleading and therefore is not recommended. Assignment of allowable stress values beyond the sample matrix is permitted when there is additional supporting information to indicate that the assigned values are conservative estimates.

**7.1.1 Population Representativeness**—The sampling plan shall be designed to represent the region to be sampled (see **Note 8**).

**NOTE 8**—Consideration should be given to potential sources of variability in the allocation of the random sample and the design of the sampling plan. The North American In-grade test program samples were considered representative because the design of the sampling plan required sampling proportional to production in at least 3 sub regions of the growing range for each of the species groups with substantial production; this resulted in a minimum cell size of 360 pieces. Smaller geographic regions equivalent to several U.S. states had representative samples with sample sizes of 200 or more. The use of large sample sizes is not sufficient by itself to assure that the sample is representative of the population. It is often necessary to sample sub-regions (or locations) to represent variability due to geography, production and growing conditions; in the North American In-Grade Program, this was typically a minimum of three sub-regions, but more for the major volume species groups. If this is not possible justification needs to be provided to demonstrate that an alternate sampling plan adequately represents these sources of variability.

**7.1.2 Grade Representativeness**—The sampling shall be collected in a random sampling design intended to represent the range of strength reducing characteristics allowed by the grade.

**7.2 Grade**—To adequately model grade performance, it is necessary to sample a minimum of two grades representative of the range of grade quality (**Note 4**). Grades sampled to model grade relationships shall be separated by no more than one intermediary grade and no more than one quarter of the total possible range (**Note 9**) in assumed bending GQI.

**NOTE 9**—For the grading system sampled in the North American In-Grade test program, the total possible range in strength ratio (GQI) is 0 to 100 %. The strength ratio concept is described in greater detail in Practice **D245**.

**7.3 Width**—In order to adequately develop the data for width, at least three widths per grade shall be tested, and the maximum difference in width between two adjacent widths shall be 4 in. (10 cm).

**7.4 Minimum Full Matrix**—A full matrix of grades and sizes shall contain a minimum of six test cells composed of at least two grades and three widths for each of the grades, meeting the restrictions of **7.2** and **7.3**, to be considered adequate for the development of a full matrix of values, including untested cells (**Note 10**).

**NOTE 10**—The sampling matrix judged to be acceptable for the North American In-Grade test program for the major species groups (**Note 2**) with large geographic range, consisted of six test cells with large samples (at least 360 pieces per cell). The test cells were nominal 2 by 4, 1.5 in. by 3.5 in. (38 mm by 89 mm); nominal 2 by 8, 1.5 in. by 7.25 in. (38 mm by 184 mm); and nominal 2 by 10, 1.5 in. by 9.25 in. (38 mm by 235 mm) dimension lumber of select structural grade (65 % minimum bending strength ratio) and No. 2 grade (45 % minimum bending strength ratio). Samples were selected for tests of four properties (modulus of elasticity, modulus of rupture, ultimate tensile stress parallel to grain, and ultimate compressive stress parallel to grain). For complete grade descriptions, see Refs. **1, 2, 3, or 4**). Samples were selected proportional to production from the entire geographic growth and production range of each species group.

## 8. Input Test Data and Adjustments to Input Test Data

**8.1** Methods for sampling and analysis of matrix input test data are found in Practice **D2915**. For testing, use Test Methods **D198** or Test Method **D4761**. Other standards may be employed if demonstrated to be applicable.

**8.2** Because the range of quality within any one specific grade may be large, it is necessary to assess the observed grade quality of the sampled material in relation to the assigned grade quality used to establish the matrix (**7.2**). The following procedures provide one way to make this assessment.

**8.2.1** The observed GQI determined from failure coded data can be used to assess whether the test cells are representative of the visual grade that is the target by comparing the 5th percentile point estimate (5th %tle PE) GQI of the test cells with the assigned GQI for the target grade (**Note 4**). The observed GQI shall be calculated for all pieces associated with knots, slope of grain, and distorted grain, or other strength reducing characteristics at point of failure. The calculation methodology shall be documented (see **X12.6**).

**8.2.2** When calculating strength ratios using the appendix of Practice **D245**, two strength ratios shall be calculated for combination knot failures: (1) using the total combined knot cross section in the equation for center of wide face knots, and (2) using the largest single edge knot from the cross-section in the equation for narrow face knots. The smaller of these two calculated strength ratios shall be permitted to be used in the calculation of fifth percentile point estimate of the distribution of strength ratios.

**8.2.3** Fifth percentile point estimates of the distribution of strength ratios shall be presented to decimal place, using the rounding procedures of Section 6.4 in Practice **E29**.

**8.2.4** To comply with the requirements of **7.2** and **8.2** both of the following conditions (**Note 11**) shall be met:

(1) The average of all individual cell GQIs in one grade shall not exceed the assigned grade GQI by more than 5 percentage points, and

(2) Each individual cell GQI shall not exceed the assigned grade GQI by more than 7 percentage points.

If both conditions are not met one of the options in **8.3** shall be followed.

**NOTE 11**—GQI evaluation and adjustment is an additional procedure overlaid on the representative sampling requirement to assure final strength property assignments account for the full range of grade characteristics permitted in each visual grade. The basis for these procedures were developed using distribution data of GQI measurements of the major North American species groups as part of the North American In-Grade Lumber Testing

program. A modification of the GQI scale or calculation methodology may be appropriate. The GQI for a sample is determined from defects associated with the failure of the pieces in the sample after test loading. The determination of a GQI value depends on the assessment and measurement of knot types, sizes, and their locations as well as the maximum slope of grain of the piece. Sample size, measurement variation, species variability, and methods of analysis can significantly impact the final GQI value (See X12).

### 8.3 Standardized Conditions:

#### 8.3.1 Grade Quality

8.3.1.1 If the average of all individual cell GQIs in one grade for a sample is no more than 5 percentage points above the grade GQI, and each individual cell GQI for a sample is no more than 7 percentage points above the grade GQI that sample shall be considered to support the intent of 7.2. Otherwise, it is permissible to re-sample or collect more samples to address non-compliance and re-evaluate the new or augmented sample for grade representativeness using GQI procedures (Note 11). Sampling used for augmentation or re-sampling shall follow the same sampling protocol applied to the original sample and be representative of population and grade as specified in 7.1.1 and 7.1.2. If the requirements of this clause are not met or if re-sampling is not possible, then the following are possible actions to address non-compliance:

(1) If the average of all cell GQIs in one grade does not exceed the grade GQI by more than 5 points, reduce the property value for all specimens in any cell whose GQI exceeds the grade GQI by more than 7 points using the formula in 8.3.1.2. If the average of all individual cell GQIs in the grade exceeds the grade GQI by more than 5 points, reduce the property value for all specimens in each cell that exceeds the grade GQI by more than 5 points using the formula in 8.3.1.2. Cells adjusted, using this procedure, are assumed to be compliant and no further grade quality adjustment is required for the grade in question.

(2) Adjust the grade definition to support a higher grade GQI so that it is within 5 points of the observed GQI.

NOTE 12—Failure of the sample to meet these criteria could be a result of several causes, some of which may be acceptable or correctable by using another method. It could be desirable to reassess the appropriateness of the GQI scale used. A proposal for replacement or augmentation of existing data should include adequate statistical analyses and information to determine if the new data substantiates retaining existing data, augments existing data, or replaces existing data.

8.3.1.2 Where structural property data of a cell is required to be modified to adjust to standardized conditions of assigned GQI, the data for all specimens in the cell shall be multiplied by the following factor (Note 13):

$$Factor = (assigned\ GQI + 5\% \text{ points}) / (observed\ GQI) \quad (1)$$

An alternative relationship shall be permitted to be used to modify the modulus of elasticity to standardized GQI conditions, provided this relationship is based on documented evidence. An example equation for the adjustment of modulus of elasticity can be found in X12.5.6.

NOTE 13—The GQI evaluation and adjustment is an additional procedure applied to the final strength property assignments to account for the maximum size of grade characteristics permitted in each visual grade. The adjustment factor is an override that can be applied without further sampling. It has been shown that application of GQI adjustment factors ranging from 0.95 to 0.89 can leave the final design values unchanged or can change the final design values by 1 rounding rule.

8.3.2 *Temperature*—Test samples at  $73 \pm 5^\circ\text{F}$  ( $23 \pm 3^\circ\text{C}$ ). When this is not possible, adjust individual test data to  $73^\circ\text{F}$  ( $23^\circ\text{C}$ ) by an adjustment model demonstrated to be appropriate.

#### 8.3.3 Moisture:

8.3.3.1 Where possible, test the samples at the moisture content (15 %) at which the characteristic value is to be determined. When this is not possible, adjust the data to 15 % moisture content by the adjustment procedures in Annex A1 or by procedures documented as adequate for the method adopted prior to developing the characteristic values.

8.3.3.2 Determination of specimen moisture content shall be made in accordance with Test Methods D4442 and D4444.

#### 8.4 Size:

8.4.1 Adjust specimen dimensions to 15 % moisture content using the adjustment procedure given in Appendix XI or other demonstrably appropriate adjustment model.

8.4.2 For the purposes of the equation in 8.4.3, the standard dressed size may be used in place of actual specimen dimensions when the moisture content adjusted specimen dimensions are within  $\pm 1/16$  in. (2 mm) in thickness and  $\pm 1/4$  in. (6 mm) in width of the standard dressed size.

8.4.3 The property values of all test data shall be adjusted to the characteristic size (for example, 1.5 by 7.25 by 144 in. [38 by 184 by 3658 mm] at 15 % MC) using the following equation (Note 14) or other appropriate size adjustment prior to developing the characteristic value:

$$F_2 = F_1 \left( \frac{W_1}{W_2} \right)^w \left( \frac{L_1}{L_2} \right)^l \left( \frac{T_1}{T_2} \right)^t \quad (2)$$

where:

- $F_1$  = property value at Volume 1, psi,
- $F_2$  = property value at Volume 2, psi,
- $W_1$  = width at  $F_1$ , in.,
- $W_2$  = width at  $F_2$ , in.,

- $L_1$  = length at  $F_1$ , in.,  
 $L_2$  = length at  $F_2$ , in.,  
 $T_1$  = thickness at  $F_1$ , in.,  
 $T_2$  = thickness at  $F_2$ , in.,  
 $w$  = 0.29 for modulus of rupture (MOR) and ultimate tensile stress parallel to grain (UTS); 0.13 for ultimate compressive stress parallel to grain (UCS); 0 for modulus of elasticity (MOE),  
 $l$  = 0.14 for modulus of rupture and UTS parallel to grain; 0 for UCS parallel to grain and modulus of elasticity, and  
 $t$  = 0 for modulus of rupture, UTS parallel to grain, UCS parallel to grain, and modulus of elasticity.

NOTE 14—The adjustments to mechanical properties for piece geometry given in 8.4.2 were developed from test data (adjusted to 15 % MC and 73°F) of visual grades of lumber (1, 2, 3, 4) using Test Methods D4761. The length adjustments given above are based on the actual test clear span between reactions or grips. The bending tests used third point loading with a constant span to depth ratio of 17 to 1. The tension tests were conducted with an 8 ft (2.4 m) clear span for 2 by 4 (Southern Pine was tested on a 12 ft (3.7 m) span) and a 12 ft (3.7 m) clear clear span for 2 by 6 ft and wider. The adjustment equation of 8.4.2 has not been verified for widths less than 3.5 in. (89 mm) nor greater than 9.25 in. (286 mm). Additional information regarding the basis for and recommended limitations to Eq 2 is given in Appendix X2.

## 9. Establishment of Characteristic Values

9.1 For strength values, the characteristic value (see 3.2.2) for each grade (GQI class) tested shall be the tolerance limit (see 3.2.13) from the data adjusted by the procedures in Section 8 to standardized conditions of temperature, moisture content and size.

9.2 When more than one width is tested, the characteristic value shall be developed using the combined data of all widths adjusted to standardized conditions modified as necessary by the test data check given in 9.3.

### 9.3 Test Cell Data Check:

9.3.1 The purpose of the test cell data check is to minimize the probability of developing nonconservative property estimates by comparing the model generated property values against the confidence interval for each cell in the test matrix. This test ensures that the individual matrix cell estimates generated with the volume adjustment procedures of 8.4.3 and the tolerance limit of the combined data do not lay above the upper limit of the confidence interval for the fifth percentile of any tested cell.

9.3.2 When species are grouped (Section 10), the test cell data check shall be performed after grouping using the combined data of the controlling species in each test cell. An example is given in Appendix X3.

9.3.3 All individual data values shall be converted to the characteristic size by the procedures of 8.4.3, and the tolerance limit shall be determined for the combined data set.

9.3.4 The calculated tolerance limit from 9.3.3 shall be used with the procedures of 8.4.3 to generate a size-adjusted estimate for each cell in the test matrix.

9.3.5 The size-adjusted estimate from 9.3.4 for each test cell shall be compared to the upper limit of the 75 % confidence interval on the nonparametric fifth percentile estimate for the test data in that cell. If the size-adjusted estimate from 9.3.4 for any cell does not exceed the confidence interval limit, the characteristic value shall be the tolerance limit as calculated in 9.3.3.

9.3.6 If the size-adjusted estimate from 9.3.4 does exceed the upper limit of the 75 % confidence interval from 9.3.5 for any cell, reduce the tolerance limit calculated in 9.3.3 until this condition does not exist. The reduced tolerance limit estimate shall be the characteristic value for that grade.

9.4 For modulus of elasticity, the characteristic values for each grade are the mean, median, and the lower tolerance limit (or other measure of dispersion).

9.4.1 When more than one width is tested, the characteristic value shall be based on the combined data of all widths adjusted by the procedures of Section 8 to the standardized conditions.

### 9.5 Estimates of Characteristic Values for Untested Properties:

9.5.1 These formulas were developed from large data bases of several North American commercial species groups, and are intended to produce conservative property estimates when only one property was tested. The derivation of these formulas is discussed in detail in Appendix X4.

#### 9.5.2 Estimates Based on Modulus of Rupture:

9.5.2.1 An estimate of the ultimate tensile stress characteristic value ( $T$ ), in psi, may be calculated from the modulus of rupture characteristic value ( $R$ ), in psi, with the following formula:

$$T = 0.45 \times R \quad (3)$$

9.5.2.2 An estimate of the ultimate compressive stress characteristic value ( $C$ ), in psi, may be calculated from the modulus of rupture characteristic value ( $R$ ), in psi, with the following formula:

$$\text{For } R \leq 7200 \text{ psi} \quad (4)$$

$$C = [1.55 - (0.32 \times R/1000) + (0.022 \times (R/1000)^2)] \times R$$

$$\text{For } R > 7200 \text{ psi}$$

$$C = 0.39 \times R$$

### 9.5.3 Estimates Based on Ultimate Tensile Stress:

9.5.3.1 An estimate of the modulus of rupture characteristic value ( $R$ ), in psi, may be calculated from the ultimate tensile stress characteristic value ( $T$ ), in psi, with the following formula:

$$R = 1.2 \times T \quad (5)$$

9.5.3.2 An estimate of the ultimate compressive stress characteristic value ( $C$ ), in psi, may be calculated from the ultimate tensile stress characteristic value ( $T$ ), in psi, with the following formula:

$$\text{For } T \leq 5400 \text{ psi} \quad (6)$$

$$C = [2.40 - (0.70 \times T/1000) + (0.065 \times (T/1000)^2)] \times T$$

$$\text{For } T > 5400 \text{ psi}$$

$$C = 0.52 \times T$$

9.5.4 When both bending and tension parallel to grain data are available, use the lower of the two estimates for the compression parallel to grain value.

9.5.5 Compression parallel to grain tests shall not be used to estimate either the modulus of rupture ( $R$ ) characteristic value or the ultimate tensile stress ( $T$ ) characteristic value.

## 10. Adjustments to Characteristic Values

10.1 *Grouping of Data to Form a New Species Grouping*—Frequently, because of species similarities or marketing convenience, it is desirable to combine two or more species into a single marketing group (**Note 15**). When this is done, it is necessary to determine the characteristic values for the combined group of species. There are no limitations as to how many or which species can be combined to form a new species grouping, but the group characteristic values shall be determined from the procedures of **10.2** for each median or mean property to be established, and the procedures of **10.3** for each tolerance limit property to be established. When a mean value is to be determined, the group shall be formed using the median values. Sections **10.2** and **10.3** cover procedures for establishing entirely new species groups, as well as adding a new species to an existing species grouping. All grouping is done after the data have been adjusted to standardized conditions of temperature, moisture content and characteristic size in accordance with **8.3** and **8.4** (see **Appendix X3** for example).

NOTE 15—For grouping by other appropriate technical criteria, see **Appendix X9**.

### 10.2 Grouping for Median Properties

#### 10.2.1 New Species Grouping:

10.2.1.1 To assign a median or mean characteristic value to a new grouping of species, begin by conducting a nonparametric analysis of variance (**Appendix X5**) to test for equality of median values of the separate species. This can be done for either a single grade or a matrix of grades. Where the goal is to assign values to a matrix of grades, this grouping procedure shall be conducted on each grade. Perform grouping tests on the data only after it has been adjusted to the characteristic size by the procedures in **8.4.3**.

10.2.1.2 If the test is not significant at the 0.01 level, the median or mean characteristic value for the group shall be the median or mean of the combined group data.

10.2.1.3 If the test is significant at the 0.01 level, determine the subgroup of species in the grouping which are indistinguishable from the species with the lowest median characteristic value using a Tukey multiple comparison test (**Appendix X4** and Ref (7)) on the medians at a 0.01 significance level. The median or mean characteristic value for the group shall be determined from the combined data of all the species in this subgroup.

#### 10.2.2 Adding New Species to Existing Group:

10.2.2.1 A new species may be added to an existing species grouping without modification of the group median or mean characteristic value if the median value of the new species is greater than or equal to the existing group median characteristic value.

10.2.2.2 If the requirements of **10.2.2.1** are not met, determine the combined group median or mean characteristic value in accordance with **10.2.1**. If the data will not permit the use of **10.2.1**, then the group median or mean characteristic value shall be the median or mean of the newly included species.

### 10.3 Grouping for Tolerance Limit Properties:

#### 10.3.1 New Species Grouping:

10.3.1.1 To assign a tolerance limit characteristic value to a new grouping, determine the tolerance limit value for the combined grouping (**Note 16**). Determine the number of pieces in each species group below the group tolerance limit value. Conduct a Chi Square test (**Appendix X7**) to determine if the percent of pieces below the group value is statistically significant for each species in the group.

NOTE 16—To determine a group tolerance limit value, each species to be included in the group should have a minimum sample size of at least 100 per property in order for the Chi Square test to be sufficiently sensitive (**8**).



10.3.1.2 If the test is not significant at the 0.01 level, the group characteristic value shall be determined from the grouped data of all the species in the new grouping.

10.3.1.3 If the test is significant at the 0.01 level, begin with a subgroup consisting of the two species with the highest percent of pieces below the group value. Use the Chi Square test to determine if the percent of pieces below the group value are comparable. Repeat this process, adding the species with the next highest percent of pieces below the group value to the previous group. Continue adding species until the test is significant at the 0.01 level. The group tolerance limit is determined from the combined data of the last subgroup of species for which the Chi Square test was not significant at the 0.01 level.

10.3.2 *Adding New Species to Existing Group:*

10.3.2.1 A new species may be included with an existing species grouping if the tolerance limit of the new species is equal to or greater than the current characteristic value for the group.

10.3.2.2 If the requirements of 10.3.2.1 are not met, determine the combined species group value in accordance with 10.3.1. If the data will not permit the use of 10.3.1, the group characteristic value shall be the tolerance limit value of the newly included species.

## 11. Establishing Grade Relationships for Stress and Modulus of Elasticity

11.1 The adjustment model for grade shall be based on relating the characteristic values determined in Section 9 modified for species grouping (Section 10), if appropriate, to the corresponding assumed minimum GQI values (see Appendix X8). The grade model constructed from the data may consist of either a linear relationship connecting the adjacent points or a mathematically fitted curve. The selected relationship shall be demonstrated to be appropriate (Note 17).

NOTE 17—The structural visual grade No. 1 (1, 2, 3, 4) has a highly restricted grade description. In the North American In-Grade test program, it was deemed appropriate for bending and tension to use only 85 % of the No. 1 value that linear interpolation between select structural and No. 2 permitted. For compression, 95 % of the permitted No. 1 value was used (see Appendix X8). Alternatively, the No. 1 values could have been set equal to the No. 2 values.

11.2 Estimate the characteristic values for untested grades from the model selected in 11.1. Use the assumed minimum GQI for the grade determined from the minimum grade requirements (see Appendix X8).

11.2.1 If the grade adjustment model is used to extrapolate beyond the sample matrix, provide additional supporting documentation to demonstrate that the procedure is conservative.

## 12. Establishing Allowable Properties

12.1 The characteristic values established in Section 9 and modified in Sections 10 and 11, and the estimated values for untested grades are based on short term tests adjusted to standardized conditions. These characteristic values shall be further modified for thickness, width, length, moisture content, load duration and safety. The adjustments in this section will convert the characteristic values to allowable stress and modulus of elasticity values for normal loading conditions. Normal loading conditions anticipate fully stressing a member to the full maximum design load for a duration of approximately ten years, either continuously or cumulatively.

12.2 *Adjustments for Width:*

12.2.1 For assignment of allowable properties, adjust the characteristic values for width using the adjustment procedures of 8.4.3 to the standard dressed width.

12.2.2 For assignment of allowable properties, the property values determined for 3.5 in. (89 mm) width (4 in. nominal) may be applied to narrower widths and to all widths used flatwise in bending of nominal 2 in. thick dimension lumber.

12.2.3 For assignment of allowable properties to widths greater than 11.5 in. (292 mm), 12 in. nominal, use 0.9 of the value at 11.5 in. (292 mm).

12.2.4 No adjustment for width is required for modulus of elasticity characteristic values.

12.3 *Adjustments for Thickness*—Allowable bending stresses derived from data on 1.5 in. (38 mm) thick (2 in. nominal) lumber may be multiplied by 1.10 for members greater than 3 in. (76 mm) in net thickness.

12.4 *Adjustment for Length*—For assignment of allowable properties the characteristic values may be adjusted to a representative end-use length using the procedures in 8.4.3. The basis for and recommended limits to application of formula 8.4.3 is in Appendix X2 (Note 18).

12.5 *Adjustment for Moisture Content:*

12.5.1 The allowable properties derived from the characteristic values at 15 % moisture content are applicable to all dimension lumber manufactured at 19 % or less moisture content when used in dry use conditions, where the moisture content of the wood is not expected to exceed 19 %.

12.5.2 For lumber used where end-use conditions are expected to produce moisture contents in the wood in excess of 19 %, multiply the allowable property values at 15 % moisture content by the factors in Table 1 (Note 18).

NOTE 18—The allowable properties derived from the characteristic values at 15 % moisture content and the adjustments in Table 1 account for the normal shrinking and swelling of lumber with changes in moisture content, as well as the changes in mechanical property values with moisture content. The basis of the adjustment factors in Table 1 are discussed in Appendix X10.

**TABLE 1 Modification of Allowable Property Values for Use When Moisture Content of the Wood Exceeds 19 %**

| Property        | Adjustment Factor |
|-----------------|-------------------|
| $F_b \leq 1150$ | 1.0               |
| $F_b > 1150$    | 0.85              |
| $F_t$           | 1.0               |
| $F_c \leq 750$  | 1.0               |
| $F_c > 750$     | 0.8               |
| MOE             | 0.9               |

12.5.3 The adjustment factors in **Table 1** assume the standard dressed size at the dry use moisture content. Lumber surfaced unseasoned shall take this into account when establishing characteristic values either by surfacing sufficiently oversize to account for these dimensional changes, or adjusting the allowable property values accordingly. The effects of changes in moisture content on dimensions is discussed further in **Appendix X1**, and adjustment factors in **Table 1** are discussed in **Appendix X10**.

12.6 Strength property values derived from **9.3** shall not exceed the corresponding test cell nonparametric fifth percentile point estimate (PE) by more than 100 psi or 5 % of the point estimate, whichever is less. The test data in that size/grade cell shall be appropriately adjusted in accordance with preceding paragraphs of Section **12**.

12.7 *Adjustment for Duration of Load and Safety*—Adjust the characteristic values determined in Sections **9** and **10** adjusted for grade, width, thickness, and length for safety and normal (10 year) loading by dividing the values by the factors in **Table 2**.

12.8 *Property Rounding*—Round the allowable properties in **12.7** in accordance with **Table 3** and the rounding rules of Practice **E380**. Maintain adequate significant digits in all intermediate calculations to avoid round-off errors.

12.9 *Adjustments for Multiple Member Use*—When three or more pieces of dimension lumber are used as joists, rafters, studs, or decking and are contiguous or are spaced not more than 24 in. on center in conventional frame construction and are joined by transverse floor, roof or other load distributing element, the allowable bending stress of such members may be increased by 15 %.

### 13. Periodic Corroboration of Assigned Design Values

13.1 The periodic corroboration of assigned allowable properties shall include one or more of the following three stages. (1) A monitoring program to periodically check for changes in product performance, (2) An evaluation program, upon detection of a statistically significant downward shift, to evaluate monitoring data and confirm effectiveness of remedial actions, and (3) a reassessment program to re-establish allowable properties.

### 14. Monitoring

14.1 The data from a monitoring program shall be used to determine if there is sound evidence to believe that there has been a change in the product performance sufficient to justify an evaluation as described in Section **15**, or a reassessment as described in Section **16**.

NOTE 19—The monitoring program is based on testing the hypothesis that there has been no change against an alternative that there has been a change.

14.2 The monitoring program shall include: (1) definition of objectives, (2) use of appropriate sampling procedures and sample size to accomplish those objectives, (3) selection and use of appropriate test methods, and (4) application of suitable data analysis procedures to collected data (see example in **Appendix X11**). Any significant deviation from the In-grade program sampling and testing methods shall be justified by comparative data analysis.

14.2.1 For lumber species or species groups with production over 1000 million board feet (MMbf) annually, this monitoring program shall at a minimum include the destructive testing of a representative size-grade cell at least once every five years.

NOTE 20—A new five year cycle begins on the date the national lumber authority having responsibility for the review and approval of lumber design values (for example, the American Lumber Standard Committee in the United States) approved the most recent periodic corroboration results. The destructive testing results for the next cycle of monitoring should be completed and submitted within five years to the national lumber authority having responsibility for the review and approval of lumber design values.

14.2.2 A monitoring program shall also look at results collected over time to determine if the data suggests any trends pointing toward a lack of conformance in the future.

**TABLE 2 Property Reduction Factors to Convert Adjusted Characteristic Values to Allowable Properties**

| Property  | Reduction Factor |
|---|------------------|
| Modulus of rupture (MOR)                              | 2.1              |
| Ultimate tensile stress (parallel to grain) (UTS)     | 2.1              |
| Ultimate compressive stress (parallel to grain) (UCS) | 1.9              |
| Modulus of elasticity (MOE)                           | 1.0              |

**TABLE 3 Rounding Rules for Allowable Properties Values**

|  |                          |
|--|--------------------------|
| Bending stress ( $F_b$ )                         | Nearest 50 psi for       |
| Tensile stress (parallel to grain) ( $F_t$ )     | allowable stress of 1000 |
| Compressive stress (parallel to grain) ( $F_c$ ) | psi or greater.          |
|  | Nearest 25 psi for all   |
|  | others.                  |
| Modulus of elasticity (MOE)                      | Nearest 100 000 psi      |

NOTE 21—It is recommended that a multi-stage approach utilizing a combination of destructive and non-destructive testing of lumber production be used (9). A monitoring program may involve multiple steps to minimize the sample size during routine periodic tests. It may also be appropriate and more efficient to confine the periodic sampling to a single representative size-grade cell that can be repeatedly sampled on an ongoing basis. As subsequent stages are triggered, the sample sizes and scope of testing can be expanded (for example, other size-grade cells or properties) as appropriate to confirm with a high degree of certainty whether an important change has occurred. For consistency of comparison, any monitoring should employ a sampling method that retains, where appropriate, the elements of sampling done under the In-grade testing program that established the allowable properties for the same species being checked (10, 11). The sample is to be representative of the specific lumber product. It is cautioned that statistically significant changes occasionally have no practical significance. Conduct statistical decisions first, followed by practical analysis as a second step.

14.2.3 A Wilcoxon test shall be used to determine whether to proceed to step 2 (an additional destructive sampling of a size-grade cell) of Stage 1. This action level is reached when a comparison of the cell property that was used to determine the current cell value is significantly different from the monitored cell value at an  $\alpha$  level of 0.05.

14.3 If the action level for a downward shift in Stage 1, Step 1 is not reached, the original periodic testing shall be re-initiated. If the action level for a downward shift in Stage 1, Step 1 is reached then either a Stage 1, Step 2 is undertaken or an evaluation of the current allowable properties is started.

## 15. Evaluation

15.1 An evaluation program shall be initiated when a statistically significant downward shift in a monitored cell has been confirmed. Alternatively, a reassessment in accordance with Section 16 shall be initiated.

15.2 The data developed over the course of the monitoring program shall be thoroughly reviewed to (1) determine the likely cause for the detected shift in allowable properties, and (2) develop the best response to the detected shift. The development of the response shall be documented and discuss implications for the other size-grade cells and properties.

15.3 Acceptable responses include altering the description of the visual grade, changing the method of processing, or restricting the resource that can be processed.

15.4 The evaluation shall include testing to confirm that the response brings the derived values within an acceptable range of the published properties for all affected size-grades and properties.

15.5 Where the evaluation requires an adjustment to some or all allowable properties, the procedures of Section 16 shall be followed.

## 16. Reassessment

16.1 A reassessment of values derived from this practice shall be conducted if there is cause to believe that there has been a significant change in the raw material resource or product mix detected by the monitoring which has been unresolved by evaluation. This reassessment shall be conducted using the sampling matrix upon which the original characteristic values are based except as provided in X11.1.4, in conjunction with an awareness of changing production conditions.

16.1.1 Conduct significance tests on the test data to determine if the differences detected between the original and the reassessed data are significant.

16.1.2 If significant differences in matrix data are detected, repeat characteristic values, grouping, and allowable property derivation to determine whether changes in design properties result.

16.2 Reassessment of values derived from this practice shall include the following steps: (1) definition of objectives, (2) use of appropriate sampling procedures and sample size, (3) selection and use of appropriate test methods, and (4) application of suitable data analysis procedures (see Appendix X11).

(Mandatory Information)

**A1. MOISTURE ADJUSTMENT PROCEDURE FOR DEVELOPMENT OF CHARACTERISTIC VALUES FOR MECHANICAL PROPERTIES OF LUMBER**

A1.1 For development of characteristic values in this standard, adjust properties of all test data for moisture content to 15 % MC. It is recommended that the test specimens be conditioned as close to 15 % MC as possible, as the adjustments for moisture content decrease in accuracy with increasing change in moisture content. Adjustments of more than five percentage points of moisture content should be avoided. For this standard, adjustment equations are assumed valid for moisture content values between 10 and 23 % (assumed green value).

**TABLE A1.1 Constants for Use in Eq A1.2**

| Coefficients | MOR  | UTS  | UCS  |
|--------------|------|------|------|
| $B_1$        | 2415 | 3150 | 1400 |
| $B_2$        | 40   | 80   | 34   |

**TABLE A1.2 Constants for Use in Eq A1.5**

| Coefficients | MOE    |
|--------------|--------|
| $B_1$        | 1.857  |
| $B_2$        | 0.0237 |

A1.2 For modulus of rupture, MOR, ultimate tensile strength parallel to the grain, UTS, and ultimate compression strength parallel to the grain, UCS, adjustments shall be calculated from Eq A1.1 and Eq A1.2.

For

|                 |   |             |        |
|-----------------|---|-------------|--------|
| MOR ≤ 2415 psi: | } | $S_2 = S_1$ | (A1.1) |
| UTS ≤ 3150 psi: |   |             |        |
| UCS ≤ 1400 psi: |   |             |        |

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For

|                 |   |  |        |
|-----------------|---|--|--------|
| MOR > 2415 psi: | } | $S_2 = S_1 + \left\{ \frac{(S_1 - B_1)}{(B_2 - M_1)} \right\} (M_1 - M_2)$ | (A1.2) |
| UTS > 3150 psi: |   |  |        |
| UCS > 1400 psi: |   |  |        |

where:

- $S_1$  = property at Moisture Content 1, psi,
- $S_2$  = property at Moisture Content 2, psi,
- $M_1$  = Moisture Content 1, %,
- $M_2$  = Moisture Content 2, %, and
- $B_1, B_2$  = constants from Table A1.1.

A1.2.1 For species with substantially different properties than those used to create the models for adjusting strength properties for changes in moisture content, it may be advisable to “scale” property adjustments relative to those found in the Douglas-fir and Southern pine moisture studies from which the models were created. With this scaling, which is referred to as normalization, the properties of weaker species are first scaled up before entering the moisture adjustment procedure, then adjusted by the moisture adjustment procedure, followed by scaling down after adjustment by the same factor used initially. Scaling is done by adjusting the property going into the moisture adjustment procedures using the equation below:

$$S_1^* = [(S_1 - C)(A/B)] + C \tag{A1.3}$$

After  $S_1^*$  is adjusted to  $S_2^*$  using the moisture adjustment procedure,  $S_2$  is rescaled as follows:

$$S_2 = [(S_2^* - C)(B/A)] + C \tag{A1.4}$$