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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 4822.1-1984

Replacing GB/T 4822-2015

**Sawn timber inspection
(English Translation)**

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Foreword

This document complies with the provisions of GB/T 1.1-2020 "Standardization Work Guidelines Part 1: Structure and Drafting Rules of Standardization Documents" Drafting:

This document replaces GB/T 4822-2015 "Sawn Timber Inspection": Compared with GB/T 4822-2015, except for structural adjustments and editorial changes in addition, the main technical changes are as follows:

- Changed terms and definitions (see Chapter 3, Chapter 3 of the:2015 edition);
- Deleted the volume calculation content in the general requirements for "dimensional inspection" (see 4.1:4 of the:2015 version);
- Changed the width inspection requirements for parallel whole-edge sawn timber (see 4.3:1,:2015 version of 4:3:1);
- Changed the sawn timber thickness inspection requirements (see 4.4:1,:2015 version of 4:4:1);
- Changed the set inspection requirements (see 5.2,:2015 version of 5:2);
- Change "blunt edge" to "missing edge", and add "sharp edge" inspection requirements (see 5.6,:2015 version of 5:6);
- Added inspection requirements for sawing defects, resin pockets, distortion, and diamond deformation (see 5.7, 5:9, 5:11, and 5:12);
- Added accuracy requirements for inspection tools (see 6.3);
- Added the "spraying" marking method of the grade mark (see 7.1), and changed the special sawn timber symbol in the sawn timber grade symbol (see Table 1,:2015 version of Table 1);
- Added volume calculation (see Chapter 8):

Please note that some content in this document may be subject to patents: The publisher of this document assumes no responsibility for identifying patents:

1 Scope

This document describes the dimensional inspection, material inspection, tools, grade markings and volume calculations for sawn lumber inspection:

This document is applicable to the inspection of sawn timber in the production and circulation fields:

2 Normative reference documents

The contents of the following documents constitute essential provisions of this document through normative references in the text: Among them, the dated quotations for undated referenced documents, only the version corresponding to that date applies to this document; for undated referenced documents, the latest version (including all amendments) applies to this document:

GB/T 449 sawn timber volume table GB/T 4823 Defects in sawn timber GB/T 11917
Material manufacturing process terminology GB/T 36202 Sawn timber inspection
terminology

3 Terms and definitions

The terms and definitions defined in GB/T 4823, GB/T 11917 and GB/T 36202 apply to this document:

4 Dimensional inspection

4.1

General requirements

4.1.1

Dimensional inspection of sawn timber refers to the inspection of the entire edge of sawn timber:

4.1.2

The size of sawn timber should be calculated and evaluated based on the size inspected at the time of transaction:

4.1.3

The upgrade and tolerance of sawn timber length, width and thickness shall be implemented in accordance with the sawn timber product standards:

4.2

Length measurement

4.2.1

The length measurement of sawn timber is to measure the shortest distance between the two end faces along the length direction:

4.2.2

The length of sawn timber is measured in meters, measured to cm, and any length less than 1cm is rounded off:

4.2.3

If the actual length of the sawn timber is less than the gauge length, but does not exceed the lower deviation of the length, it will still be calculated based on the gauge length; if it exceeds the lower deviation of the length, press Calculation of the first-level measuring ruler length:

4.3

Width inspection

4.3.1

The width measurement of parallel whole-edge sawn timber is to measure the narrowest part of any part without blunt edges within the length of the gauge ruler, leaving 15cm at both ends:

width:

4.3.2

The width inspection of trapezoidal whole-edge sawn timber is to measure the width of the sawn timber at half the length of the timber:

4.3.3

The width of sawn timber is measured in mm, and any less than 1mm is rounded off:

4.3.4

If the actual width of the sawn timber is less than the gauge width, but does not exceed the lower deviation of the width, it will still be calculated based on the gauge width; if it exceeds the lower deviation of the width, press