



Crosslam CLT	Non-visible	Visible (once sanded)	Visible (double sanded)
The maximum length	12000 mm	12000 mm	12000 mm
The minimum length	4000 mm	4000 mm	4000 mm
The maximum width (pay attention to machining allowance)	3200 mm	3200 mm	3200 mm
The minimum width	2500 mm	2500 mm	2500 mm
Tolerances			
Thickness	+/-1 mm	+/-1 mm	+/-1 mm
Width	+/-3 mm	+/-3 mm	+/-3 mm
Length	+/-3 mm	+/-3 mm	+/-3 mm
Machining tolerances	+/-3 mm	+/-3 mm	+/-3 mm
Attention: In some cases, over 130 mm thick boards must be turned on the CNC work bench. In these cases, the machining tolerance is +/- 6 mm.			
Timber			
Wood	Spruce / Pine	Spruce / Pine	Spruce / Pine
The basic quality of the lamellas in terms of strength	C24	C24	C24
Visual quality requirements for timber	No requirements	Pohjoismainen sahatavara (Nordic sawn timber) - sorting instructions, quality classification table according to quality B	Pohjoismainen sahatavara (Nordic sawn timber) - sorting instructions, quality classification table according to quality B
Surface quality			
Surface	Planed	Sanded	Double sanded
Moisture content	max. 15 %	max. 11±2 %	max. 11±2 %
Surface quality	No requirements	Occasional small faults permitted	Occasional small faults permitted
Sanding quality	No requirements	Sanding roughness p40 or p60	Sanding roughness p100
Finishing of sanding on construction site	No requirements	Glue from surface has been removed by sanding. The visible surface is to be sanded on site	Finishing sanding is recommended to be carried out on site
Hit & miss in planing	Permitted	Occasionally permitted	Not permitted
Replacing surface defects	Permitted	Permitted	Permitted
Fingerjoints on the surface layer	Permitted	Permitted	Permitted
Openings between parallel lamellas			
- every second joint	max. 2 mm		
- 10 % of joints	max. 5 mm	max. 2 mm	max. 2 mm
Attention: Edges are not bonded. When the air humidity varies the surface of the board is opening of its lamella joints, especially due to the dry indoor air. The random cracking of the lamella is also possible and does not affect the bearing capacity of the element.			
Machining			
Circular saw	Permitted	Permitted	Permitted
Spiral milling cutter	Permitted	Permitted	Permitted
Wheel milling cutter	Permitted	Permitted	Permitted
Splinters of edges			
	Permitted	For crosswise machining permitted	For crosswise machining permitted