



Quality Assurance Pocket Guide for Planer Operations

SOUTHERN PINE PRODUCTS
2" – 4" THICK

SPIB.ORG

MINIMUM DRESSED SIZES FOR COMMON SOUTHERN PINE PRODUCTS

Nominal Dimension	Thickness (in.)	Width (in.)
2 x 4	1.500	3.500
2 x 6		5.500
2 x 8		7.250
2 x 10		9.250
2 x 12		11.250
4 x 4	3.500	3.500
4 x 6		5.500

2021 SPIB Standard Grading Rules for Southern Pine Lumber

“... If lumber is dressed to a size below minimum American Lumber Standard requirements or below the minimum sizes set forth in these grading rules, the grade mark must show size...”

National Grading Rule for Dimension Lumber

“Hit or Miss provisions shall not be used to permit surfacing below specified minimum sizes”

Note: To avoid possible incorrect readings caused by changes in moisture content (shrinkage), SPIB inspectors use calipers to check finished size on fresh material.

Defect	Limits	Common Root Causes and Measurement
<p data-bbox="136 139 299 161">Machine Offset</p> 	<p data-bbox="425 175 492 289">No. 1 and No. 2 Prime:</p> <p data-bbox="429 318 488 339">1/16"</p>	<p data-bbox="530 161 1198 218">Common Root Causes: Movement in the side heads while in the cut</p> <p data-bbox="530 247 1160 304">Measurement: Departure from a straight line on one edge must not exceed the limit</p>
<p data-bbox="148 361 287 382">Machine Bite</p> 	<p data-bbox="425 432 492 546">MSR, No. 2, and No. 3:</p> <p data-bbox="429 575 488 596">1/8"</p>	<p data-bbox="530 347 1198 404">Common Root Causes: Movement while being cut in the top or bottom heads</p> <p data-bbox="530 432 1118 461">Measurement: Depth of bite must not exceed the limit</p>
<p data-bbox="41 582 91 604">Skip</p> 	<p data-bbox="429 575 488 596">1/8"</p>	<p data-bbox="530 504 1198 589">Common Root Causes: Undersized rough lumber, over dry rough lumber, planer setup/uneven cut (e.g., too much off one edge or face)</p> <p data-bbox="530 618 996 646">Measurement: Amount scant of target size</p>



Torn grain due to tearing of fiber by knives or saws



Fuzzy dressing due to high moisture or dull knives



Improper **eased edge** adjustment



Machine burn due to piece sticking in planer



Wavy dressing due to loose holding devices, poor cutting circle, dull knives, and other causes



Knife gap due to damaged planer knife or knives

For more details on defect measurement, see additional SPIB materials or your SPIB inspector