

Summary of Changes to take effect Nov 1, 2009

We have made some changes to the log quality specifications for 2009 to better reflect what PVOSB requires to run efficiently. The changes are summarized below and you will find more detail in the contents of this document.

Length tolerance has been increased from 2" to 4". This increase will make it easier for contractors to hit the required lengths.

Runaway lengths ($\geq 20'10''$) will be assessed a flat fine of \$300 per occurrence. This reflects the impact that runaway lengths have on the mill. Lengths $> 20'10''$ jam in the log magazines or ponds and often require the line to be shut down to remove the jam.

Loads that do not meet Loading Specifications (section 2 of the log quality specifications) will be subject to a flat fine of \$250 per occurrence. These loads require extra time to unload and can result in damage to equipment.

A minimum average quality score of 90% is required by pay period. Average quality of $<90\%$ less will be subject to fines as per the Penalty Assessment Schedule.

PLEASE FAMILIARIZE YOURSELF WITH THIS DOCUMENT AND BEGIN PROCESSING TO THESE SPECIFICATIONS AS SOON AS POSSIBLE.

Thank you for your anticipated cooperation. If you have any questions please contact the Canfor representative responsible for the block you are on.

Schedule 1 – OSB Log Specifications

Peace Valley OSB requires all log loads to meet the following quality and dimensional specifications. Log quality optimizes recovery, reduces waste, and minimizes production costs. Logs delivered to Peace Valley OSB that do not meet these specifications for quality and dimension are subject to payment deduction under Peace Valley OSB’s Log Quality Assessment System. All log loads arriving at the Peace Valley OSB scales are subject to quality assessment.

Log specifications are subject to review and revision; ensure you are using current version (Dated lower right page corner).

1. Log Lengths and Sorting Specifications

Sort	Species	Target Top Diameter (outside bark)	Description	Target Length ¹	Length Tolerance	Minimum Length ²
1 Aspen (Preferred Production)	Aspen, Birch	10 cm (4 inches)	Aspen and Birch only. (Max 10% Cottonwood content permitted) (by piece count)	6 Meters (19'8") to 4.7 Meters (15'6") (6 Meter is preferred Length)	+ / - 10 cm (4 inches)	4.6 Meters (15'2")
2 Cottonwood (Preferred Production)	Cottonwood (Black Poplar, Bam)	10.0 cm (4 inches)	100% Cottonwood (Max 10% Aspen content permitted)	6 Meters (19'8") to 4.7 Meters (15'6") (6 Meter is preferred Length)	+ / - 10 cm (4 inches)	4.6 Meters (15'2")
3 Shorts	Cottonwood, Aspen, Birch	10 cm (4 inches)	Aspen, Birch, Cottonwood	4.0 Meters (13'1") to 3.5 Meters (11'6")	+ / - 10 cm (4 inches)	3.5 Meters (11'6")

¹ All logs are measured from the top of the undercut.

² Sort One and Two logs must be maximized. [Sort Three logs must be kept to a minimum and must not be manufactured unless necessary to avoid excessive waste.](#)

To assist in making processing or bucking decisions, the following log configurations are listed in order of priority of manufacturing for the mill's requirements. When making OSB log processing decisions, keep in mind that this is the order of preference.

1. Sort 1 or 2 logs, full 6 meters,
2. Sort 1 or 2 logs, 4.6 to 6.0 meters,
3. Sort 3 logs.

2. Loading Specifications

Logs arriving at Peace Valley OSB must be loaded no higher than the outside trailer stakes and must be secured and marked as per WorkSafeBC and Ministry of Forests regulations.

Sorts may not be mixed within a single trailer bunk;

1. Sort 1 (Aspen) and Sort 2 (Cottonwood) may be loaded on a single truckload but must be in separate bunks.
2. Sort 1 (Aspen) and Sort 3 (Shorts) may be loaded on a single truckload, but must be in separate bunks.
3. Sort 2 (Cottonwood) and Sort 3 (Shorts) may be loaded on a single truckload, but must be in separate bunks.
4. The EXCEPTION to the rule: One cleanup load of mixed aspen and cottonwood long logs (Sorts 1 and 2) is permitted per road section per block. The load slip must clearly identify this as a cleanup load.

Each Load Description Slip must clearly state what sort(s) the truck is carrying.

Log bunks must be square (ie all butts in a tier must be squared to each other).

Non-spec loads will be subject to a flat fine of up to \$250.00

3. Acceptable and Unacceptable Log Defects

DEFECT	Description	Tolerance	Solution
Burls, limbs, stubs, branches	Maximum length or variance of any protrusion from the bole of the log is...	7.5cm (3 inches)	Trim all protrusions flush with bole of log.
Top Rot	Top Rot is...	acceptable if less than 50% of top diameter measured inside bark.	If top rot is greater than 50% of top diameter inside bark, buck back to allowable rot tolerance and acceptable measure.
Butt, Spot or Pocket Rot	Maximum tolerance of rot is	50% by diameter	Note: Rotten branch stubs are an indication of severe rot.
	Exception to <i>50% by diameter</i> rule is that no log may contain a hole greater than 10cm (4 inches) in diameter		Buck back until hole is less than 10cm (4 inches) and log meets acceptable measure.
Conks	Conks are an indicator of rot and are....	unacceptable	Buck out conks until log conforms to Rot rule (above).

DEFECT	Description	Tolerance	Solution
Rotten Cat faces and Scars	Any cat face or scar with rot present in the defect is....	acceptable if rot is less than 50% by diameter	Buck back to allowable rot tolerance and acceptable measure.
Butt flare	Maximum butt flare offset is...	1/3 of the butt diameter of log	Trim flare to acceptable measure.
Sweep and Crook	Maximum permissible sweep or crook deflection is....	100% of the log diameter as measured at the point of maximum deflection. (i.e. if log diameter at center of crook is 20cm, max allowable deviation is 20cm)	Manufacture log so that sweep or crook is 100% or less deviation and log meets acceptable length.
Forks	Forks and school marms are..	unacceptable	The smaller portion of the fork must be bucked off leaving the larger leg attached, provided the attached leg meets the minimum CROOK tolerance. The cut must be made at a bevel to the bole of the tree, otherwise it will be tallied as a fork.
Pistol Butt	Pistol butt is...	unacceptable if it deflects more than 100% of the butt diameter	Buck back to meet tolerance and acceptable measure
Cull logs	Cull logs are those with greater than 50% rot by volume and are.....	unacceptable	Note: rotten branch stubs are an indication of severe rot.
Dead/dry logs	Dead dry logs are	acceptable if NO rot is present and the log has a minimum top diameter of 25cm (10 inches)	Reject log if rot present or top diameter is too small.

DEFECT	Description	Tolerance	Solution
Debris	Rocks, limbs, plastic, stumps, metal, tops or any material in a load other than correctly manufactured logs is...	unacceptable	
Shatter, broken or unmanufactured tops	Shatter, rat tails, shattered or broken tops are...	unacceptable	Manufacture tops to specified diameter, meeting acceptable measure.
Split	A wide or open split is...	acceptable provided it does not run more than 1/3 up the length of the log.	Manufacture to meet tolerance.
	Note: mechanically damaged logs meeting minimum utilization standards must be delivered to the mill and may not be left in the debris pile.		
Burnt or charred wood	Burnt or charred wood is...	Unacceptable unless previously authorized by PVOSB supervision.	Buck back to eliminate char, or reject log.
Snipe or falling hinge	Any snipe or falling hinge is...	unacceptable	Trim off snipe or hinge.

DEFECT	Description	Tolerance	Solution
Stepped/Slanted Butt	Maximum off-square allowance is...	10 cm (4 inches)	Do not buck off; improve falling or bunching technique.
Off length	Off length logs are ...	unacceptable	Only logs processed to the sort ranges specified in Section 1 (above) are permissible. All other lengths will be penalized. Any log less than 3.5 meters or longer than 6 meters are off length. Logs between 4.0 and 4.7 meters are off length. Runaway lengths (20'10") will incur a flat fine of \$300.00 per occurrence.
Slabs	Separate or dangling slabs are...	unacceptable	Trim from log and reject.

Note: mechanically damaged logs meeting minimum utilization standards must be delivered to the mill and may not be left in the debris pile. Quality penalties will be applied if log does not meet minimum quality tolerances.

LOG QUALITY ASSESSMENT

Overview

The log quality assessment system ensures that Peace Valley OSB receives properly manufactured and loaded logs that will optimise recovery and produce the quality of strand required for consistent high grade Oriented Strand Board production. The Log Quality Assessment System grades the quality of logs by ranking defects in accordance to their effect on strand production, mill recovery, and utilization standards.

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There are two parts to the Quality Assessment System; Percent Quality and Flat Penalty Assessment. The system assigns points to each defect in a selected sample load, and a quality percent is calculated. Percentage scores are based on an average over a pay period and Percent Quality penalties are applied at threshold levels as discussed in the *Penalty Schedule*.

Overlength logs may be penalized as a flat fine against each piece.

Sampling Procedures

Sampling frequencies will be based on volume delivered from each Contractor. Randomly generated quality samples, and Ministry Of Forests scale samples will be used to represent volume delivered in a pay period. Loads that contain obvious mis-manufactured logs may also be used for sampling.

Calculation of Percent Quality

Points are assessed for each defect. If a log has more than one defect, the highest-ranking defect will be tallied. The following page outlines the defects and points used to calculate the Percentage score. The count of each defect multiplied by the value of the defect will result in a points score. To calculate the percent score:

$$100 - ((100 \times \text{Total Points}) / (9.74 \times \text{Pieces}))$$

- 1) Total the number of points assessed in the load, multiply by 100.
- 2) Multiply the pieces in the load by 9.74 (average sheet points).
- 3) Divide the number from step 1 by the number from step 2.
- 4) 100 minus the result from step 3 equals **Quality Percent Score**.

DEFECT	PTS. PER DEFECT	COUNT	COMMENTS
TOP ROT >50% DIAMETER	5		
CONK/BUTT ROT >50% DIA.	10		
HOLES >4"	20		
EXCESSIVE SWEEP/CROOK	10		
PISTOL BUTT	10		
STEPS/HINGES/SNIPES	10		
EXCESSIVE FLARE >1/3 DIA	10		
SPLITS >1/3 LOG LENGTH	10		
BROKE ENDS/SHATTER/SLABS	5		
SMALL TOPS	5		
LIMBS/BURLS/SPIKES	5		
FORKS/MARMS	10		
DEBRIS	5		
EMBEDDED GRAVEL	20		
CULL LOGS	15		
LENGTHS TOO SHORT	5		
LENGTHS TOO LONG	20		
MISSORTED LENGTHS	5		
SPECIES SORT	5		
TOTAL SHEET POINTS	185		

Penalty Assessment Schedule- Peace Valley OSB

The total number of points and pieces assessed in a pay period is used to calculate the average pay period score. Penalties are applied to all Tonnes hauled in a pay period according to the schedule:

Average Pay Period Quality Score	Per Tonne Penalty Deduction
90% to 100%	No Deduction
80% to 90%	\$0.15 per tonne
75% to 79.5%	\$0.25 per tonne
Less than 75%	\$0.50 per tonne

Overlength logs (20'10") will be assessed a flat penalty of \$300.00 per log. The points for and piece count of flat penalty assessments do not count toward a pay period average percent score.

Truckloads of logs that do not meet the **Loading Specifications** may be assessed a flat fine up to \$250.00.

Consistent quality scores below 75% may result in a refusal to accept further deliveries until quality issues are addressed.

A report for all loads assessed will be printed and available for pick up at the scalehouse. A pay period summary for Log Quality will be included with Contractor Pay Statements.