

207-829-6901 | info@nelma.org

# Northeastern Lumber Manufacturers Association



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INSPECTION PROGRAM



## Inspection Program: Wood Packaging Materials

NELMA is pleased to offer certification inspection services to facilities that produce wood packaging materials (WPM) such as boxes, crates, skids, pallets, etc. destined for use in exporting goods to the numerous countries that have implemented the International Standard for Wood Packaging.

### Inspection Program

- ▶ Lumber and Timbers
- ▶ Pressure Treated Products
- ▶ Wood Packaging Materials
- ▶ Home

The International Standard for Phytosanitary Measures (ISPM) – Guidelines for Regulating Wood Packaging Material in International Trade, Publication Number 15” is the official name of the international standard for wood packaging, otherwise known as ISPM 15. The standard was developed as a means to greatly reduce the phytosanitary concerns related to growing global trade and the significant spread of pests through wood packaging materials (WPM). Numerous examples exist around the world of environmental and economic harm associated with the introduction of a non-native invasive species to a country, traced back to non-heat treated or non-fumigated WPMs. In the U.S. alone, the introduction of the [Asian Longhorned Beetle](#), the [Emerald Ash Borer](#), and likely the [Dutch Elm Disease](#) can be traced back to shipments received that contained these forest destructive pests.

ISPM 15 was adopted by more than 150 countries at the International Plant Protection Convention (IPPC) in March 2002, with each country allowed to choose their own date for actual implementation of the standard. The IPPC ISPM 15 standard prescribes two types of treatments for wood packaging materials, (a) heat treatment, and (b) fumigation with methyl bromide. These treatments must be applied to all solid wood components of the wood packaging materials, both hardwood and softwood species of wood.

**Meeting the requirements of ISPM 15 is a two-step process.** There are several different scenarios, dependent upon the operation type. Here's a basic example for facilities that manufacture finished wood packaging items (pallets, skids, boxes, crates, etc.), either for sale or for their own use in exporting goods:

Step 1: Purchase and use heat treated lumber or components, with each piece required to be stamped with an "HT" mark and an [ALSC-accredited agency logo](#). This signifies that the material was heated to a minimum of 56 degrees C (133 degrees F) for 30 minutes at the core of each piece. Typically only one "HT" mark will be ink-stamped on each piece.

Step 2: Once the facility is certified by an ALSC-accredited agency, such as NELMA, the "HT"-stamped lumber may be cut for use in manufacturing the finished wood packaging item without regard to an "HT" mark on each cut piece. The finished pallet, skid, crate, or box would be marked on a minimum of two opposite sides by the certified facility's "IPPC" stamp that includes the International IPPC logo, the facility's unique number, and the certifying agency's logo. This signifies to the custom agents in export countries that the wood packaging meets IPPC's ISPM 15 Standard and is part of the US's verification program.

Additional verification programs are available from NELMA for facilities that heat treat via a hot box, oven, or conventional dry kiln, then IPPC-stamp the finished wood packaging item (pallet, skid, crate, box, etc.), or for manufacturing operations that produce only wood packaging components from "HT" stamped lumber for sale to other facilities that produce the finished item.

For complete details of the NELMA's certification program for the various types of operations, please see the ***NELMA Certification Program and Compliance Process for Heat Treatment (HT) and Wood Packaging Materials (WPM)***, which may be viewed and downloaded by [clicking here](#).

Please note that "manufactured" composite wood products such as plywood, particleboard, oriented strand board, and veneer are exempt from this standard due to the heat utilized in their manufacturing process. Also note that preservatively-treated wood does not meet the standard, unless the wood was heat-treated and stamped HT prior to preservative treatment.

Also note that fumigation certification is not provided by NELMA at this time.

To view/download a copy of the ISPM 15 standard, please visit the IPPC website, <http://www.ippc.int/>.

Click [here](#) to view NELMA's most recent IPPC ISPM 15 Country Implementation Table.

Please contact us by phone at 207-829-6901 or email us at [info@nelma.org](mailto:info@nelma.org) for additional questions that you may have about the program or to inquire about our fee schedule. To apply for HT and/or WPM inspection services from NELMA, you may download an [application form](#), complete the requested information, and return via fax (207-829-4293) or email ([info@nelma.org](mailto:info@nelma.org))



# **The NELMA Certification Program And Compliance Process:**

## **Heat Treatment (HT) and Wood Packaging Materials (WPM)**

**Northeastern Lumber Manufacturers Association**  
P.O. Box 87A Cumberland Center, ME 04021  
Phone: 207.829.6901 Fax: 207.829.4293  
Email: [info@nelma.org](mailto:info@nelma.org)

Table of Contents	
Topic	Page
About NELMA	1
The International Standard for Wood Packaging - IPPC ISPM 15	1
Facility Certification Process	2
WPM Stamps and Proper Use	2
Stamping Frequency Exceptions	4
Forms, Files, and Documentation	4
HT Lumber Purchasing Requirements	4
Procedures to Repair Wood Packaging for Reuse	5
General Inspection Procedures	5
Inspection Discrepancies and Agency Action	5
Dunnage	6
Additional Information	7

## About NELMA

Established in 1933, the Northeastern Lumber Manufacturers Association (NELMA) is headquartered in Cumberland Center, Maine. The Association is accredited by the American Lumber Standard Committee (ALSC) as a lumber rules writing agency and as an agency to provide inspection services for lumber, timbers, treated wood products, and wood packaging materials (WPM). NELMA has certified members located throughout the Northeast, Great Lakes and Midwest Regions of the U.S.

## The International Standard for Wood Packaging

“The International Standard for Phytosanitary Measures (ISPM) – Guidelines for Regulating Wood Packaging Material in International Trade, Publication Number 15” is the official name of the international standard for wood packaging, otherwise known as ISPM 15. The standard was developed as a means to greatly reduce the phytosanitary concerns related to growing global trade and the significant spread of pests through wood packaging materials. Numerous examples exist in the U.S. and around the world of environmental and economic harm associated with the introduction of a non-native invasive species to a country, traced back to untreated WPM items. This measure was adopted by more

than 150 countries at the International Plant Protection Convention (IPPC) in March 2002, with each country allowed to choose their own date for actual implementation of the standard.

*To ensure that NELMA's HT and WPM customers are kept informed of the latest changes, an updated country list is emailed to each facility when implementation changes take place. Members may also access the list online at [www.nelma.org](http://www.nelma.org).*

Prior to its official adoption of ISPM 15 in March 2002, the European Union (EU) implemented a portion of the draft version of ISPM 15 standard in October 2001, requiring phytosanitary measures to be taken on softwood lumber used in wood packaging originating in the U.S., Canada, China, and Japan. This implementation announcement by the EU created the immediate need in the U.S. for a WPM heat treatment overview verification system for wood packaging materials. The current inspection program system in place today is a result of the efforts between the USDA's Animal and Plant Health Inspection Service (APHIS) and the ALSC to develop such an accreditation program.

The IPPC ISPM 15 standard prescribes two types of treatments for wood packaging materials, **(a)** heat treatment, and **(b)** fumigation with methyl bromide. These treatments must be applied to all solid wood components of the wood packaging materials, both hardwood and softwood species of wood. For heat treatment, ISPM 15 requires wood packaging materials to reach a **minimum** of 56 degrees C (133 degrees F) for 30 minutes at the core of the material, and verified through a recognized accredited and certified program. Note: NELMA's temperature requirements may be higher than the minimum, dependent upon heat chamber capabilities.

Items such as plywood, particleboard, oriented strand board, and veneer are exempt from the standard due to the heat utilized in their manufacturing process. Preservatively-treated wood does not meet the standard, unless heat-treated prior to processing.

Fumigation certification is not provided by NELMA at this time.

*Contact NELMA for a copy of the ISPM 15 Standard or view/download the document online at [www.ippc.int](http://www.ippc.int)*

## Facility Certification Process

The process of facility certification will commence upon receipt of a completed application and signed agreement from a heat treatment or wood packaging facility. The Association will schedule the initial inspector's visit with management and other designated personnel of the facility within 21 days upon application for program services.

There are **three** types of certifications available from NELMA regarding the Wood Packaging Materials program, **(a)** a Heat Treatment Facility, **(b)** a Wood Packaging Materials Facility, and **(c)** a Re-Manufacturer of Heat Treated Materials. Each type of certification is described as follows:

**A Heat Treatment Facility.** This is a facility that has a chamber or kiln designed to **(a)** heat treat solid wood materials to be used in the construction of wood packaging for export, such as lumber, timbers, or components, and/or **(b)** to heat treat finished wood packaging such as pallets, skids, and crates.

To ensure compliance with the heat treatment regulations and to obtain certification from NELMA, the heat treatment facility must "prove" that the heat treatment chamber can meet the time and temperature requirements of the regulation. While heat treatment schedules can be developed based upon experience over time, thermocouples placed in strategic points within the chamber during the heat treatment process and tied directly to a recording device is necessary to ensure the heat treatment requirements are being met or exceeded. Multiple thermocouples tied directly to an approved recording device are required by NELMA. These must be used within each charge of lumber, components, or wood packaging being heat treated.

Upon review of the operation and following discussions with the facility management and personnel regarding the rules and regulations, the NELMA Inspector will determine eligibility of the facility for certification. If certified, each heat treatment chamber or kiln to be used for heat treatment purposes will be registered with the appropriate identification information by a NELMA Inspector during the initial inspection.

**A Wood Packaging Facility.** This is a facility that produces finished pallets, skids, boxes, crates, or custom packaging either for sale or for their own company's use in exporting goods.

Upon review of the operation and following discussions with the facility management and personnel regarding the rules and regulations during the initial inspection, the NELMA Inspector will determine eligibility of the facility for certification.

*Please note that a Heat Treatment Facility may also be certified as a Wood Packaging Facility if they conduct both types of business.*

**A Re-Manufacturer of Heat Treated Materials.** This is a facility that purchases heat treated (HT-stamped) lumber and re-manufacturers the material into components or specialty-sized items for use as wood packaging for export. Upon review of the operation and following discussions with the facility management and personnel regarding the rules and regulations during the initial inspection, the NELMA Inspector will determine eligibility of the facility for certification.

*Please note that a Wood Packaging Facility may also be certified as a Re-Manufacturer of Heat Treated Materials.*

Companies with multiple production facilities that heat treat and/or manufacture wood packaging materials must have each site certified. Each location will maintain its individual records and be listed by NELMA as a separate facility for inspection purposes. Inspection fees will also be due to NELMA for services provided at each company facility.

## WPM Stamps and Proper Use

Upon certification by NELMA, the appropriate permanent-ink stamp(s) may be ordered for use by the facility. The stamp(s) are purchased from NELMA but remain the property of the Association under the signed licensing agreement. The official stamp(s) when applied properly to the wood packaging materials will signify compliance with the international phytosanitary regulations as prescribed under the IPPC ISPM 15 standard.

See **Table 1** for specific information on the **two** primary types of stamps that are available for use within the program (also see “Dunnage” stamp information on page 7). The use of each stamp is dependent upon a facility’s operation and certification as follows:

**At Heat Treatment Facilities.** For lumber and components that have been heat treated at the facility, the **Heat Treatment Stamp shall be applied at least once to each piece.** (\*See important “Stamping Frequency Exception Note” on Page 4)

When finished wood packaging materials (WPM), such as pallets, skids, and crates, are heat treated at the facility, the **IPPC Stamp shall be applied to a minimum of two sides of the WPM.**

**At Wood Packaging Material Facilities.** For finished wood packaging materials (WPM) such as pallets, skids, and crates manufactured from certified heat treated (HT) and stamped lumber and components, the **IPPC Stamp shall be applied to a minimum of two opposite sides of the WPM.**

Individual loose pieces to be included within the finished wood packaging materials, such as blocking, bracing, and other miscellaneous components **shall also be** manufactured from HT-stamped material. However, these items **may not** be stamped with the IPPC Stamp. In addition, no additional solid wood packaging items should



ever be added to the finished WPM once it’s removed from the certified facility unless the customer is also a certified facility.

**At Re-Manufacturers of Heat Treated Materials.** For components or specialty-sized items re-manufactured from certified HT-stamped lumber, the **Heat Treatment Stamp shall be applied at least once to each piece.** (\*See important “Stamping Frequency Exception Note” on Page 4)

In addition to permanent-ink stamps, a facility may also “brand” an exact replica of an official stamp onto their certified wood packaging materials. The facility must consult with NELMA prior to mock-up and production of the brand and final approval must be obtained from the Association before it may be utilized on WPM.

**Proper Stamp Usage Information:**

- NELMA-issued stamps become the responsibility of the wood packing facility and are licensed for use by NELMA. Stamps are not to be altered in any way without the express permission of NELMA.
- Stamps shall only be used at the specific wood packing facility location to whom they were officially issued and are not to leave the premises under any condition without express approval from NELMA.

Table 1	
Heat Treatment Stamp	IPPC Stamp
	
<p><b>For Use ONLY on Lumber and Components</b></p>	<p><b>For Use ONLY on Finished Wood Packaging</b></p>
<p>The required information within this stamp is <b>(a)</b> method of treatment (HT=Heat Treatment), <b>(b)</b> unique number assigned to the facility by the agency (000 in this example), and <b>(c)</b> the registered logo of the certified inspection agency (NELMA “sawblade” logo or “NELMA®”).</p>	<p>The required information within this stamp is <b>(a)</b> international symbol for wood packaging (IPPC logo), <b>(b)</b> country of origin of WPM manufacturer (US), <b>(c)</b> unique number assigned to the facility by the agency (000 in this example), <b>(d)</b> method of treatment (HT=Heat Treatment), and <b>(e)</b> the registered logo of the certified inspection agency (NELMA “sawblade” logo or “NELMA®”).</p>

- The importance of legible stamps cannot be over emphasized and will be checked during the inspection visits to the facility. Proper ink quality and quantity, careful application, and periodic cleaning are the keys to readable stamps. Stamps issued by NeLMA, using agency-approved ink, can be easily cleaned with warm water, mild soap and a soft brush.
- Stamps showing signs of wear should be replaced promptly! New stamps may be ordered only through NeLMA by calling 207-829-6901.

## Stamping Frequency Exception

The ALSC Enforcement Regulations provide for an exception to the HT stamping of each and every piece of certified material that has undergone a heat treatment cycle or has been re-manufactured from HT-stamped material. When the size of the pieces are **(a)** 30 inches or less in length, **or (b)** 1/2 inch nominal or less in thickness, **or (c)** 2 inches nominal or less in width, the HT stamp shall be applied by stamping not less than 25% of the pieces in the unit. The units that are partially stamped shall also be stenciled with the same information as appears on the HT stamp of the facility.

## Forms, Files, and Documentation

Each facility shall maintain a systematic method of keeping records and “in-house” quality control procedures for the process approved by NeLMA. Once certified, the NeLMA inspector will provide detailed instructions on the required documentation that must be maintained at the facility to ensure compliance with all rules and regulations. The inspector will educate designated facility personnel on the use of appropriate forms and file set-up that will streamline the verification process. Current NeLMA forms and information to be maintained in a file and up-to-date include the following:

**Heat Treatment Time/Temperature Recording Sheets** – A file will be maintained for each registered kiln, and contain all printouts and recording sheets/charts from each Heat Treatment charge, to include size, quantity, and

inventory identifiers. This form will be utilized by Heat Treatment Facilities.

**HT-Lumber Purchases Form**. This form records the purchases of certified HT-stamped lumber and components by the facility, to include date of delivery, lumber/component sizes, and quantity. A copy of the invoice and/or bill of lading for each purchase must be included within this file to document the transaction. This form will be utilized by Wood Packaging Facilities.

**HT-Lumber Usage Form**. This form records the actual usage of certified HT-stamped lumber in the manufacturing of wood packaging materials by the facility, to include size, quantity, and specific WPM identification information (job number, order number, etc.) A NeLMA Inspector will assign the use of this form at facilities where necessary.

**Re-Manufactured Lumber Form**. This form records specific data on components manufactured from certified HT-stamped lumber, to include original grade stamp information (name of inspection agency and mill number), size and quantity of lumber, and the resulting size and quantity of components re-stamped with the facility’s HT stamp. This form will be utilized by Re-Manufacturers of Heat-Treated Facilities.

*Contact NeLMA for a copy of these forms.*

## HT Lumber Purchasing Requirements

Facilities that purchase their lumber for use in a Wood Packaging Materials Facility or a Re-Manufacturer of Heat Treated Materials must be certain that the material is invoiced and received at the facility as heat treated lumber. As a minimum, each piece **MUST BE** legibly stamped at least once with an “HT” mark, **AND** with a mill number **AND** the logo or name of an ALSC-accredited agency. For material in question, check with NeLMA immediately.

*Contact NeLMA for a copy of ALSC-accredited agencies and their logos or view/download the list online at [www.alsc.org](http://www.alsc.org)*

## Procedures to Repair Wood Packaging for Reuse

The repair or replacement of damaged components within an existing pallet, skid, crate, box, or other wood packaging item for reuse is acceptable. However, the regulations require that the **entire** wood packaging item undergo heat treatment or fumigation to become ISPM 15 compliant. The repaired and retreated item must be stamped with the IPPC mark of the repair facility and any old IPPC marks obliterated.

## General Inspection Procedures

A **minimum of twelve** inspections per calendar year are conducted by a NELMA Inspector at each certified facility, as required by the ALSC Enforcement Regulations.

With the exception of the initial certification visit, these will be unannounced inspections. The inspection process will include the following:

### At Heat Treatment Facilities:

- ✓ A review of all heat treatment records and inventory documentation.
- ✓ A review of the recording devices and location of the thermocouples within the heat treatment chamber.
- ✓ Verification of the proper use of the facility's stamp(s) including legibility.
- ✓ An inspection of the facility's inventory.
- ✓ On a periodic basis, NELMA will verify a heat treatment chamber's recording devices with their own equipment placed within the chamber. This test provides verification to a heat treating facility that their equipment is in working order or requires maintenance.

### At Wood Packaging Material Facilities:

- ✓ Verification of the facility's purchasing records to ensure that certified HT-stamped lumber has been specified and purchased, in addition to an examination of the usage records.

- ✓ An examination of the facility's lumber inventory to locate available HT-stamped lumber and match existing quantity with anticipated amount based on data recorded on forms.
- ✓ An inspection of the facility's inventory to examine usage of the stamp on wood packaging including legibility and location on a **minimum of two** opposite sides.

### At Re-Manufacturers of Heat Treated Lumber:

- ✓ Verification of the facility's purchasing records to ensure that certified HT-stamped lumber has been specified and purchased.
- ✓ An examination of the facility's re-manufactured lumber form and comparison with existing inventory at the facility
- ✓ An inspection of the facility's inventory to examine usage of stamp(s) including legibility.

NELMA-certified wood packaging facilities will also receive inspection visits on a periodic basis by personnel of the ALSC, as noted in the NELMA "agreement". These inspections will also be unannounced and are conducted to ensure that NELMA, as an accredited agency of ALSC, is performing the required inspection procedures prescribed by ALSC for heat treating and wood packaging facilities.

*Contact NELMA for a copy of ALSC Wood Packaging Materials Enforcement Regulations or view/download the document online at [www.alsc.org](http://www.alsc.org)*

## Inspection Discrepancies and Agency Action

### Inspection Discrepancies

The inspector's findings during each visit will be discussed with the designated personnel and a copy of the report will be made available to the facility. All discrepancies must be considered serious in nature and immediate correction must be taken by the facility to maintain certification. Examples of discrepancies include the following:

**Illegible Stamps** – The appropriate stamp required for WPM items must be legible and clearly visible. Materials that contain illegible stamps will be held at the facility until immediate corrective measures are completed and verified by the NELMA Inspector.

**Improper Use of Stamp** – As noted above, the rules for WPM stamp usage is quite clear and definitive.

Stamping WPM items with the wrong stamp or not stamping the items in the **correct** location and number of times are examples of serious discrepancies. These items will be held at the facility until immediate corrective measures are completed and verified by the NELMA Inspector.

**Purchases/Usage Forms Not Maintained:** This is a serious discrepancy that impairs the inspector's ability to verify compliance by the WPM facility. See "Agency Action" section below for further information.

**Incomplete Heat Treatment Records:** This is a serious discrepancy that impairs the inspector's ability to verify compliance of the Heat Treatment process. See "Agency Action" section below for further information.

### Agency Actions

Consecutive inspection reports that indicate serious discrepancies at a certified facility will result in either a warning or suspension of service. Discovery of blatant misuse of the NELMA stamps will result in immediate suspension of service. **In addition, non-payment of fees to NELMA for inspection services rendered by the agency is also cause for suspension of service.** These conditions will result in the inability by the facility to obtain supervisory services from any ALSC-accredited agency for **(a)** 60 days in the case of a warning notice, and **(b)** a period of 180 days in the case of suspension of service. NELMA may reinstate inspection services only after the facility demonstrates the ability and willingness to maintain the requirements of NELMA's Heat Treatment and Wood Packaging Materials Certification Program.

## Dunnage

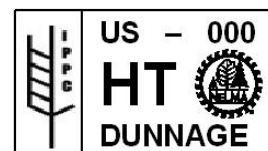
To official definition of dunnage as listed in IPPC ISPM 15 is:

***Dunnage - wood packaging materials used to secure or support a commodity, but which does not remain associated with the commodity***".

In other words, dunnage is the solid lumber material, typically individual pieces, used in the loading of a container, ship, or airplane for transit, but these items do not continue on with the shipment beyond the port of entry. There are **exceptions** where certain dunnage pieces that remain in the shipping container to the final destination may be stamped with the DUNNAGE mark (contact NELMA with your questions regarding the proper usage of the stamp).

ISPM 15 states that ideally, dunnage should be heat-treated or fumigated, then stamped with the IPPC stamp. However, if not heat-treated or fumigated, the ISPM 15 regulations state that as a minimum, the dunnage should be made from bark-free wood that is free from pests and signs of live pests. As a result of these ISPM 15 recommendations for dunnage, each country will determine which measure is acceptable.

Several countries including Australia, New Zealand, and South Africa require materials used specifically as dunnage to be stamped with the IPPC stamp (not just an HT stamp) on each piece. As a result, USDA APHIS and ALSC have approved the following IPPC-logo heat treatment stamp specific for dunnage:



This stamp has the same required ISPM 15 components as the existing IPPC stamp but with the word "DUNNAGE", or "DUN" in some cases, added to reflect its specific use in export shipments.

The stamp should be acceptable for shipments to all countries that have implemented the IPPC ISPM 15 standard.

Examples of what types of facilities may require the dunnage stamp:

- (1) At a certified **wood packaging facility or heat treatment facility** that may wish to stamp heat-treated lumber for dunnage for sale to a shipper/freight forwarder. The lumber MUST BE stamped the full length of each piece at a minimum of every 2 feet with the IPPC DUNNAGE stamp. This ensures that when it is cut to size by the shipper, at least one stamp facsimile will be present on each piece of dunnage.
- (2) At a certified **freight forwarder or wood packaging facility** that loads shipping containers at their site and dunnage material is needed to secure or separate the cargo. In this example, certified heat treated lumber stamped HT may be cut to desired sizes for use as dunnage and each piece then stamped once with the IPPC DUNNAGE stamp.
- (3) **At a certified seaport / airport facility.** Certified heat treated lumber stamped HT may be purchased and cut to desired sizes on site, and then each piece stamped once with the IPPC DUNNAGE stamp.

As with the current WPM and HT inspection programs under NELMA, tracking forms and documents will be required for verification on the use of the IPPC DUNNAGE stamp.

Please note that blocking and bracing of goods inside a certified IPPC-stamped box or crate would NOT be considered dunnage, as these wood packaging materials typically go with the shipment beyond the port of entry.

Please contact us with your questions or stamp needs regarding this new requirement or any additional circumstances not covered within this alert.

## Additional Information

Further details regarding The NELMA Heat Treatment (HT) and Wood Packaging Materials (WPM) Certification Program along with an application for inspection services may be obtained by contacting us at any time by:

**Phone: (207) 829-6901**

**Fax: (207) 829-4293**

**Email: [info@nelma.org](mailto:info@nelma.org)**

Information is also available on our website, **[www.nelma.org](http://www.nelma.org)**, under the "Inspection Program" tab. This includes access to the latest list of countries that have implemented the ISPM 15 standard and their specific requirements.

## Notes

Revised 2/06



# American Lumber Standard Committee, Incorporated

S.R. Ingram, Chairman  
R.K. Caron, Vice Chairman  
T.F. Brodie, Treasurer  
T.D. Searles, President

P.O. Box 210  
Germantown, Maryland 20875-0210  
Telephone: 301.972.1700  
Fax: 301.540.8004  
E-Mail: [alsc@alsc.org](mailto:alsc@alsc.org)

April 2006

(this list supercedes all previous lists)

The following rules have been certified as conforming to the American Softwood Lumber Standard, PS20, by the Board of Review of the American Lumber Standard Committee:

1. **Standard Grading Rules for Northeastern Lumber**; published by the Northeastern Lumber Manufacturers Association (NeLMA), 272 Tuttle Road, P.O. Box 87A, Cumberland Center, ME 04021; phone 207.829.6901; fax 207.829.4293
2. **Standard Grading Rules**; published by the Northern Softwood Lumber Bureau (NSLB), 272 Tuttle Road, P.O. Box 87A, Cumberland Center, ME 04021; phone 207.829.6901; fax 207.829.4293
3. **Standard Specifications for Grades of California Redwood Lumber**; published by the Redwood Inspection Service (RIS), 405 Enfrente Drive, Suite 200, Novato, CA 94949; phone 415.382.0662; fax 415.382.8531
4. **Standard Grading Rules for Southern Pine Lumber**; published by the Southern Pine Inspection Bureau (SPIB), 4709 Scenic Highway, Pensacola, FL 32504; phone 850.434.2611; fax 850.433.5594
5. **Standard Grading Rules for West Coast Lumber**; published by the West Coast Lumber Inspection Bureau (WCLIB), Box 23145, Portland, OR 97281-3145; phone 503.639.0651; fax 503.684.8928
6. **Western Lumber Grading Rules**; published by the Western Wood Products Association (WWPA), 522 SW Fifth Avenue, Portland, OR 97204-2122; phone 503.224.3930; fax 503.224.3934
7. **Standard Grading Rules for Canadian Lumber**; published by the National Lumber Grades Authority (NLGA), 406-First Capital Place, 960 Quayside Drive, New Westminster, BC V3M 6G2; phone 604.524.2393; fax 604.524.2893

## Agencies Accredited by the Board of Review of the American Lumber Standard Committee, Incorporated and Typical Grade Stamps.

### TYPICAL GRADE STAMP

MILL 000  
CONTINENTAL STAND  
INSPECTION AGENCY & BTR  
DOUG FIR S-GRN

### AGENCY NAMES & ADDRESSES

**Continental Inspection Agency, LLC (CI)**  
P.O. Box 785  
Lodi, CA 95241

209.367.3840

916.718.5217

fax: 209.367.3840

e-mail: [drdodgerman@sbcglobal.net](mailto:drdodgerman@sbcglobal.net)

1. Approval as an inspection agency including mill supervisory services under:
  - a. WWPA rules
  - b. WCLIB rules
  - c. RIS rules
  - d. NGR portion of the NLGA rules
2. Approved to provide heat treatment audit services under all rules.

S-DRY 001  
FINISH  
EASTERN WHITE PINE



### **Northeastern Lumber Manufacturers Association (NeLMA)**

272 Tuttle Road, P.O. Box 87A  
Cumberland Center, ME 04021

207.829.6901

fax: 207.829.4293

e-mail: [info@nelma.org](mailto:info@nelma.org)

S-DRY 001  
STAND  
EASTERN WHITE PINE **NELMA®**

1. NeLMA is a rules writing agency.
2. Approval of rules they publish and as an inspection agency including mill supervisory services under:
  - a. NeLMA rules
  - b. NSLB rules
  - c. NGR, Posts and Timbers, and Beams and Stringers portions of WCLIB rules
  - d. NGR, Selects and Common Boards, 4/4 Shop, Heavy Shop, Posts and Timbers, and Beams and Stringers under the WWPA rules
  - e. NGR portion of the SPIB rules
  - f. NGR portion of the NLGA rules
3. Approved to supervise glued and machine graded lumber.
4. Approved to provide heat treatment audit services under all rules.



**Northern Softwood Lumber Bureau (NSLB)**

272 Tuttle Road, P.O. Box 87A  
Cumberland Center, ME 04021

207.829.6901  
fax: 207.829.4293  
e-mail: info@nelma.org

1. NSLB is a rules writing agency
2. Approval of rules they publish and as an inspection agency including mill supervisory service under:
  - a. NSLB rules
  - b. NGR portion of WCLIB rules
  - c. NGR portion of the WWPA rules
  - d. NLGA rules
3. Approved to supervise glued and machine graded lumber.
4. Approved to provide heat treatment audit services under all rules.



**Pacific Lumber Inspection Bureau (PLIB)**

33442 First Way South  
Suite 300  
Federal Way, WA 98003

253.835.3344  
fax: 253.835.3371  
e-mail: info@plib.org

1. Approval as an inspection agency including mill supervisory service under:
  - a. WCLIB rules
  - b. WWPA rules
  - c. RIS rules
  - d. NLGA rules
2. Approved to supervise glued and machine graded lumber.
3. Approved to provide heat treatment audit services under all rules.



**Redwood Inspection Service (RIS)**

405 Enfrente Drive, Suite 200  
Novato, CA 94949

415.382.0662  
fax: 415.382.8531  
e-mail: info@calredwood.org

1. RIS is a rules writing agency.
2. Approval of rules they publish and as an inspection agency including mill supervisory service under:
  - a. RIS rules
  - b. WCLIB rules
  - c. WWPA rules
3. Approval to supervise machine graded lumber.
4. Approved to provide heat treatment audit services under all rules.



**Renewable Resource Associates, Inc. (RRA)**

860 Johnson Ferry Road  
Suite 140-194  
Atlanta, GA 30342

678.528.3734 or 770.330.9416  
fax: 678.528.8082  
e-mail: lon@rainc.net

1. Approval as an inspection agency including mill supervisory service under:
  - a. SPIB rules
  - b. NGR, Posts and Timbers, and Beams and Stringers portions of the NLGA rules
  - c. NGR, Selects and Finish, Boards, Posts and Timbers, and Beams and Stringers portions of the WWPA rules
  - d. NGR, Posts and Timbers, and Beams and Stringers portions of the WCLIB rules
  - e. NGR, Selects and Finish, Boards, Posts and Timbers, and Beams and Stringers portions of the NeLMA rules
  - f. NGR, Selects and Finish, Boards, Mouldings, Posts and Timbers, and Beams and Stringers portions of the NSLB rules
2. Approved to supervise glued and machine graded lumber.
3. Approved to provide heat treatment audit services under all rules.



**Southern Pine Inspection Bureau (SPIB)**

4709 Scenic Highway  
Pensacola, FL 32504

850.434.2611  
fax: 850.433.5594  
e-mail: spib@spib.org

1. SPIB is a rules writing agency
2. Approval of rules they publish and as an inspection agency including mill supervisory service under:
  - a. SPIB rules
  - b. Southern Pine graded under WWPA Moulding Stock and Shop Lumber rules
  - c. NGR, Posts and Timbers, and Beams and Stringers portions of NeLMA rules
  - d. NGR, Posts and Timbers, and Beams and Stringers portions of NSLB rules
  - e. NGR, Posts and Timbers, and Beams and Stringers portions of WCLIB rules
  - f. NGR, Western Patio Decking, Posts and Timbers, and Beams and Stringers portions of WWPA rules
  - g. NGR, Posts and Timbers, and Beams and Stringers portions of NLGA rules
3. Approved to supervise glued and machine graded lumber.
4. Approved to provide heat treatment audit services under all rules.

**SIWP® 000**  
**NO.2 S-DRY SYP**

**Stafford Inspection and Consulting, LLC (SIWP)**  
14418 Roxane Drive  
Orlando, FL 32832

407.380.7914  
fax: 407.380.8914  
e-mail: info@staffordinspection.com

1. Approval as an inspection agency including mill supervisory service under:
  - a. NGR, and Stress Rated Boards portions of SPIB rules
2. Approved to provide heat treatment audit services under all rules.

AUDITED BY  
**TP® NO.2 S-DRY**  
**000 SYP**

**Timber Products Inspection (TP)**  
P.O. Box 919  
Conyers, GA 30012

770.922.8000  
fax: 770.922.1290  
e-mail: dconner@tpinspection.com

1. Approval as an inspection agency including mill supervisory service under:
  - a. SPIB rules
  - b. RIS rules
  - c. WCLIB rules
  - d. WWPA rules
  - e. NGR, Posts and Timbers, and Beams and Stringers, and Section 6-Eastern White Pine Board Grades portions of the NeLMA rules
  - f. NGR, paragraph 112-Selects, and paragraph 113-Commons portions of the NLGA rules
  - g. NGR portion of the NSLB rules
2. Approved to supervise glued and machine graded lumber.
3. Approved to provide heat treatment audit services under all rules.

AUDITED BY  
**TP® NO.1 S-DRY**  
**000 D.FIR-L**

MILL 10  
 **NO. 2**  
DOUG FIR S-DRY

**West Coast Lumber Inspection Bureau (WCLIB)**  
Box 23145  
Portland, OR 97281-3145

503.639.0651  
fax: 503.684.8928  
e-mail: info@wclib.org  
e-mail: bshelley@wclib.org

1. WCLIB is a rules writing agency.
2. Approval of rules they publish and as an inspection agency including mill supervisory service under:
  - a. WCLIB rules
  - b. RIS rules
  - c. WWPA rules
  - d. NLGA rules
  - e. NGR, Scaffold Plank, Radius Edge Decking, Finish and Boards portions of the SPIB rules
3. Approved to supervise glued and machine graded lumber.
4. Approved to provide heat treatment audit services under all rules.

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 **2** **S-DRY**  


**Western Wood Products Association (WWPA)**  
522 SW Fifth Avenue, Suite 500  
Portland, OR 97204-2122

503.224.3930  
fax: 503.224.3934  
e-mail: info@wwpa.org

1. WWPA is a rules writing agency.
2. Approval of rules they publish and as an inspection agency including mill service under:
  - a. WWPA rules
  - b. WCLIB rules
  - c. NLGA rules
  - d. RIS rules
  - e. NGR and Scaffold Plank portions of the SPIB rules
  - f. Section 6.2-Eastern White Pine Common Board Grades of the NeLMA rules
3. Approved to supervise glued and machine graded lumber.
4. Approved to provide heat treatment audit services under all rules.



**National Lumber Grades Authority (NLGA)**  
 #302 - 960 Quayside Drive  
 New Westminster, BC V3M 6G2

604.524.2393  
 fax: 604.524.2893  
 e-mail: info@nlga.org

The NLGA is the rules writing agency for Canada. The following Canadian agencies have been accredited by the Board of Review of the American Lumber Standard Committee as inspection agencies including mill supervisory service as indicated below.

**A.F.P.A.® 00**  
**S-P-F NLGA 1**  
**KD-HT**

**Alberta Forest Products Association (AFPA)**  
 10709 Jasper Ave., # 500  
 Edmonton, AB T5J 3N3

780.452.2841  
 fax: 780.455.0505  
 e-mail: info@albertaforestproducts.ca

1. Approved as an inspection agency including mill supervisory service under:
  - a. NLGA rules
2. Approved to supervise glued and machine graded lumber.
3. Approved to provide heat treatment audit services under all rules.

**CL® A**  
**S-P-F**  
**100**  
**No. 2**  
**S-GRN.**

**CL® A 100**  
**SPRUCE-PINE-FIR**  
**NO. 1 S-DRY**

**Canadian Lumbermen's Association (CLA)**  
 2319 St. Laurent Blvd., Unit 500/Suite 500  
 Ottawa, ON K1G 4J8

613.233.6205  
 fax: 613.233.1929  
 e-mail: info@cla-ca.ca

1. Approved as an inspection agency including mill supervisory service under:
  - a. NLGA rules
  - b. NGR and Section 6-Eastern White Pine Board Grades portions of NeLMA rules
2. Approved to supervise glued and machine graded lumber.
3. Approved to provide heat treatment audit services under all rules.

**COFI**  
**100**  
**No 1**  
**S-DRY**  
**NLGA**  
**HEM-FIR(N)**

**CMSA.**  
**100**  
**No 1**  
**KD-HT**  
**NLGA**  
**S-P-F**

**Canadian Mill Services Association (CMSA)**  
 #200, 601-6th Street  
 New Westminster, BC V3L 3C1

604.523.1288  
 fax: 604.523.1289  
 e-mail: hatachi@canserve.org

1. Approved as an inspection agency including mill supervisory service under:
  - a. NLGA rules
  - b. NGR portion of WWPA rules for Douglas fir, larch, and SPF(S)
2. Approved to supervise glued and machine graded lumber.
3. Approved to provide heat treatment audit services under all rules.

**CSI**  
**000**  
**No 1**  
**S-DRY**  
**HEM-FIR(N)**

**Canadian Softwood Inspection Agency, Inc. (CSI)**  
 1047 - 250A Street  
 Aldergrove, BC V4W 2S8

604.857.2112  
 fax: 604.857.2177  
 e-mail: canadiansoftwood@telus.net

1. Approved as an inspection agency including mill supervisory service under:
  - a. NLGA rules
  - b. NGR portion of WWPA rules
  - c. NGR portion of WCLIB rules
2. Approved to supervise glued and machine graded lumber.
3. Approved to provide heat treatment audit services under all rules.

CFPA® 00  
S-P-F S-DRY  
CONST

**Central Forest Products Association (CFPA)**

Box 1169  
Hudson Bay, SK S0E 0Y0

306.865.2595  
fax: 306.865.2621  
e-mail: cfpa@sasktel.net

1. Approved as an inspection agency including mill supervisory service under:
  - a. NLGA rules
  - b. NGR portion of NeLMA rules
2. Approved to supervise glued and machine graded lumber.
3. Approved to provide heat treatment audit services under all rules.

QFA® S-P-F  
100 S-DRY  
No 1

**Council of Forest Industries (COFI)**

Suite 1501, 700 West Pender St.  
Pender Place I Business Building  
Vancouver, BC V6C 1G8

604.684.0211  
fax: 604.687.4930  
e-mail: info@cofi.org

Southern Region  
360-1855 Kirschner Rd.  
Kelowna, BC V1Y 4N7

250.860.9663  
fax: 250.860.0009  
e-mail: crooks@cofi.org  
desrosier@cofi.org

ILMA® S-DRY 1  
00 S-P-F

Northern Region  
400-1488 Fourth Ave.  
Prince George, BC V2L 4Y2

250.564.5136  
fax: 250.860.0009  
e-mail: routledge@nfpbc.ca

1. Approved as an inspection agency including mill supervisory service under:
  - a. NLGA rules
  - b. NGR portion of WWPA rules
2. Approved to supervise glued and machine graded lumber.
3. Approved to provide heat treatment audit services under all rules.

0  No. 2  
S-GRN  
D-FIR(N)  
NLGA

**Macdonald Inspection (MI)**

842 Eland Drive  
Campbell River, BC V9W 6Y8

250.923.3250  
fax: 250.923.3258  
e-mail: macinsp@island.net

1. Approved as an inspection agency including mill supervisory service under:
  - a. NLGA rules
  - b. NGR, Posts and Timbers, and Beams and Stringers portions of the WWPA rules
  - c. NGR, Posts and Timbers, and Beams and Stringers portions of the WCLIB rules
2. Approved to supervise glued and machine graded lumber.
3. Approved to provide heat treatment audit services under all rules.

M L® B	SPF No.1 KD-HT MILL 99
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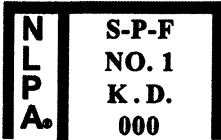
**Maritime Lumber Bureau (MLB)**

P.O. Box 459  
Amherst, NS B4H 4A1

902.667.3889  
fax: 902.667.0401  
e-mail: mlb@ns.sympatico.ca

1. Approved as an inspection agency including mill supervisory service under:
  - a. NLGA rules
  - b. NGR and Section 6-Eastern White Pine Board Grades portions of the NeLMA rules
2. Approved to supervise glued lumber.
3. Approved to provide heat treatment audit services under all rules.

**NFLD.LUMBER**



**Newfoundland and Labrador Lumber Producers Association (NLPA)**

P.O. Box 8  
Glovertown, NF A0G 2L0

709.533.2206  
fax: 709.533.2611  
e-mail: nllpa@nf.sympatico.ca

1. Approved as an inspection agency including mill supervisory service under:
  - a. NLGA rules
2. Approved to provide heat treatment audit services under all rules.

**O.L.M.A.® 01-1  
CONST. S-DRY  
SPRUCE · PINE · FIR**

**Ontario Lumber Manufacturers Association (OLMA)**

65 Queen Street West, Suite 210  
Toronto, ON M5H 2M5

416.367.9717  
fax: 416.367.3415  
e-mail: info@olma.ca

1. Approved as an inspection agency including mill supervisory service under:
  - a. NLGA rules
  - b. NGR and Section 6-Eastern White Pine Board Grades portions of the NeLMA rules
2. Approved to supervise glued and machine graded lumber.
3. Approved to provide heat treatment audit services under all rules.



**NLGA RULE  
No 1  
S-DRY  
S-P-F**

**Pacific Lumber Inspection Bureau (PLIB)**

British Columbia Division  
P.O. Box 19118  
Fourth Avenue Postal Outlet  
Vancouver, BC V6K 4R8

BC tel/fax: 604.732.1782  
US tel: 253.835.3344  
e-mail: info@plib.org

1. Approval as an inspection agency including mill supervisory service under:
  - a. NLGA rules
  - b. WCLIB rules
  - c. WWPA rules
  - d. RIS rules
2. Approved to supervise glued and machine graded lumber.
3. Approved to provide heat treatment audit services under all rules.



**S-P-F  
1  
000 S-DRY**

**Quebec Forest Industry Council (QFIC)**

1175 Lavigerie Avenue, Suite 200  
Ste-Foy, QB G1V 4P1

418.657.7916  
fax: 418.657.3365  
e-mail: neil.pelletier@cifq.qc.ca

1. Approved as an inspection agency including mill supervisory service under:
  - a. NLGA rules
  - b. NGR and paragraph 6.2 Commons portions of the NeLMA rules
2. Approved to supervise glued and machine graded lumber.
3. Approved to provide heat treatment audit services under all rules.

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**The following agencies are accredited to provide heat treatment service only. Typical stamps are shown.**

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HT**



**Carolina Inspection Services, Inc. (CIS)**

P.O. Box 389  
Marshville, NC 28103-1154

866.753.5738  
704.624.1996  
fax: 704.624.1946  
e-mail: deaton@carolinainspection.com

1. Approval as an inspection agency including mill supervisory service under:
  - a. Heat Treatment portion only of the NeLMA, NSLB, RIS, SPIB, WCLIB, WWPA, and NLGA rules



**Conway & Robison, LLC (C&R)**

P.O. Box 1508  
Sharpsburg, GA 30277

678.642.4036  
e-mail: jason@cr-inspect.com

1. Approval as an inspection agency including mill supervisory service under:
  - a. Heat Treatment portion only of the NeLMA, NSLB, RIS, SPIB, WCLIB, WWPA, and NLGA rules

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**Lee Inspection & Consulting Services, Inc. (LIWP)**

2207 California Plaza, #3B  
Bossier City, LA 71171

800.508.6232  
fax: 800.508.5531  
e-mail: dkstokes@dixie-net.com

HT



1. Approval as an inspection agency including mill supervisory service under:
  - a. Heat Treatment portion only of the NeLMA, NSLB, RIS, SPIB, WCLIB, WWPA, and NLGA rules

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HT



**Microforestry Resources, Inc. (MR)**

3128 Lost Desert Dr., SW  
Albuquerque, NM 87121

505.228.2581  
e-mail: audit@microforestry.com

1. Approval as an inspection agency including mill supervisory service under:
  - a. Heat Treatment portion only of the NeLMA, NSLB, RIS, SPIB, WCLIB, WWPA, and NLGA rules

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HT



HT



**Missouri Forest Products Association (MFPA)**

611 East Capitol Avenue, Suite One  
Jefferson City, MO 65101

573.634.3252  
fax: 573.636.2591  
e-mail: moforest@moforest.org

1. Approval as an inspection agency including mill supervisory service under:
  - a. Heat Treatment portion only of the NeLMA, NSLB, RIS, SPIB, WCLIB, WWPA, and NLGA rules

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HT MFPA

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HT

**National Hardwood Lumber Association (NHLA)**

P.O. Box 34518  
Memphis, TN 38184-0518

901.377.1818  
fax: 901.382.6419  
e-mail: info@natlhardwood.org

1. Approval as an inspection agency including mill supervisory service under:
  - a. Heat Treatment portion only of the NeLMA, NSLB, RIS, SPIB, WCLIB, WWPA, and NLGA rules

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HT



**Package Research Laboratory (PRL)**

41 Pine Street  
Rockaway, NJ 07866

973.627.4405  
fax: 973.627.4407  
e-mail: ddixon@package-testing.com

1. Approval as an inspection agency including mill supervisory service under:
  - a. Heat Treatment portion only of the NeLMA, NSLB, RIS, SPIB, WCLIB, WWPA, and NLGA rules

## INTERPRETING GRADE STAMPS

With few exceptions (see note), all approved grade stamps include the following five elements:

### Visually Graded Lumber<sup>1</sup>:

(a) <b>TRADEMARK®</b>	(c) <b>Grade Designation</b>
(b) <b>Mill Identification</b>	(d) (e) <b>Species Seasoning</b>

- a. *Trademark* – indicates identity of agency quality supervision
  - b. *Mill Identification* – product manufacturer name, brand or assigned mill number
  - c. *Grade Designation* – grade name (number or abbreviation)
  - d. *Species Identification* – name or abbreviation of individual species or species combination
  - e. *Condition of Seasoning*<sup>a</sup> – moisture content classification at time of surfacing
    1. *S-Dry* – 19% maximum moisture content
    2. *MC15* – 15% maximum moisture content
    3. *KD* – kiln dried to moisture content indicated in grading rules
    4. *S-Gm* – over 19% moisture content (unseasoned)
- <sup>a</sup> – *HT* – designation for Heat Treated - while not a seasoning designation, the abbreviation HT may be found in conjunction with the above seasoning abbreviations (see notes below). The HT definition can be found in the grading rules.

### Machine Graded Lumber<sup>1</sup>:

Grade stamps on machine graded lumber include the five elements listed above for visually graded lumber. Grade designations for the two types of machine graded lumber, machine stress rated (MSR) lumber and machine evaluated lumber (MEL), are distinctive from those used for visually graded lumber grades.

#### Machine Stress Rated Lumber (MSR) Stamp:

(b) <b>Mill Identification</b>	(d) (e) <b>Species Seasoning</b>
(a) <b>TRADEMARK®</b>	(c) <b>#### Fb - #.#E</b>
<b>Machine Rated</b>	

- MSR grade designations are composed of the assigned extreme fiber in bending (Fb or f) in psi and the assigned modulus of elasticity (E) in millions of pounds per square inch. Examples include 1650f-1.5E; 2100f-1.8E; and 2400f-2.0E.
- The phrase "Machine Rated" or "MSR" is also required on machine stress rated lumber stamps.

#### Machine Evaluated Lumber (MEL) Stamp:

(a) <b>TRADEMARK®</b>	(b) <b>Mill Identification</b>
(d) <b>Species</b>	(e) <b>Seasoning</b>
(c) <b>M – xx</b>	
<b>#### Fb</b>	<b>#.# E</b>
<b>#### Ft</b>	

- MEL grade designations use the format, M-xx; where xx indicates a one or two digit number. Examples include M-12; M-15; and M-19.
- In addition, the assigned extreme fiber in bending (Fb or f) in psi, the assigned modulus of elasticity (E) in millions of pounds per square inch, and the assigned tension parallel to grain (Ft) in psi are required elements on machine evaluated lumber stamps.

### Glued Lumber<sup>1</sup>:

(a) <b>TRADEMARK®</b>	(b) <b>Mill Identification</b>
(d) <b>Species</b>	(e) <b>Seasoning</b>
(c) <b>Grade Identification</b> <b>(Type Glue/Appropriate Use)</b>	

Grade stamps on glued lumber include all the information indicated for visually graded lumber. In addition, the grade stamp includes a designation or abbreviation indicating the type of glue joint and appropriate use. Examples include "Stud Use Only", "Vertical Use Only", "Certified End Joint", and "Certified Exterior Joints".

<sup>1</sup> Grade Stamp Layout – The placement of the required elements within a grade stamp may vary, depending on the preferences of the specific supervising agency. The sample grade stamp facsimiles that accompany the agency listing herein provide a good example of the typical placement of elements preferred by that particular agency. Contact the agency, whose trademark appears on the lumber, for specific information related to the agency's grade stamping policies.

Note: Grade stamps for timbers are not required to include the condition of seasoning.

An approved grade stamp may include only a) trademark, b) mill identification, c) HT designation.

Grade stamps are permitted to include information that is not required, so long as the additional information is not confusing, misleading or deceptive. Contact the agency, whose trademark appears on the lumber, for specific information related to the agency's grade stamping policy.

### American Lumber Standard Committee, Incorporated

P.O. Box 210 Germantown, MD 20875-0210

301.972.1700 fax 301.540.8004 e-mail: [alsc@alsc.org](mailto:alsc@alsc.org) url: [www.alsc.org](http://www.alsc.org)