

# Cross-Laminated Timber



# The following certificates demonstrate the outstanding quality of our products:



# Cross-laminated timber non-visual grade

<b>Type of wood</b>	spruce, fir addition of other types of wood permissible
<b>Standard and strength</b>	C24 according to EN 338
<b>Gluing</b>	finger joints: melamine/urea resin surface: polyurethane adhesive narrow side: hot-melt adhesive
<b>Dimensions</b>	Width: 1250 mm Height: 60–280 mm Length: 2700–14000 mm
<b>Surface and tolerance dimensions</b>	all sides non-visual grade planed on 4 sides with chamfer ± 1 mm in width and height ± 3 mm length tolerance
<b>Wood moisture</b>	12 % ± 2 %

Features	Permissibility
<b>Glued joint</b>	open joint up to 4 mm permissible
<b>Fracture in wood</b>	not permissible
<b>Rough areas</b>	occasionally permissible
<b>Discoloration, red stripes</b>	permissible
<b>Nail-proof brown stripes</b>	permissible
<b>Resin pockets</b>	permissible
<b>Bark inclusions</b>	permissible
<b>Chunking</b>	occasionally permissible
<b>Sound knots</b>	permissible

Features	Permissibility
<b>Loose knots</b>	permissible
<b>Tiny knots</b>	permissible
<b>Solid dead knots</b>	permissible
<b>Heartwood</b>	permissible
<b>Insect attack</b>	individual small wormholes up to 2 mm permissible
<b>Waney edge</b>	occasionally permissible
<b>Rot areas</b>	not permissible
<b>Checks</b>	permissible
<b>Packaging and storage</b>	Packaged in PE film

# Cross-laminated timber industrial visual grade

<b>Type of wood</b>	spruce, fir addition of other types of wood permissible industrial visible side only spruce, fir
<b>Standard and strength</b>	C24 according to EN 338
<b>Gluing</b>	finger joints: melamine/urea resin surface: polyurethane adhesive narrow side: hot-melt adhesive/white glue
<b>Dimensions</b>	Width: 1250 mm Height: 60–280 mm Length: 2700–14000 mm
<b>Surface and tolerance dimensions</b>	one side industrial visual grade, other sides non-visual grade planed on 4 sides with chamfer industrial visual side sanded on request ± 1 mm in width and height ± 3 mm length tolerance
<b>Wood moisture</b>	12 % ± 2 %

Features	Permissibility
<b>Glued joint</b>	open joint up to 4 mm permissible
<b>Fracture in wood</b>	not permissible
<b>Rough areas</b>	occasionally permissible
<b>Discoloration, red stripes</b>	up to 10% of the surface permissible
<b>Nail-proof brown stripes</b>	permissible
<b>Resin pockets</b>	up to 10 x 90 mm permissible
<b>Bark inclusions</b>	occasionally permissible
<b>Chunking</b>	minor chunking permissible in small numbers
<b>Sound knots</b>	permissible

Features	Permissibility
<b>Loose knots</b>	permissible up to 30 mm
<b>Tiny knots</b>	permissible
<b>Solid dead knots</b>	permissible up to 30 mm
<b>Heartwood</b>	permissible
<b>Insect attack</b>	not permissible
<b>Waney edge</b>	occasionally permissible
<b>Rot areas</b>	not permissible
<b>Checks</b>	occasionally permissible
<b>Packaging and storage</b>	Packaged in PE film

# Cross-laminated timber visual grade\*

<b>Type of wood</b>	spruce, fir addition of other types of wood permissible visible side only spruce
<b>Standard and strength</b>	C24 according to EN 338
<b>Gluing</b>	finger joints: melamine/urea resin surface: polyurethane adhesive narrow side: hot-melt adhesive/white glue
<b>Dimensions</b>	Width: 1250 mm Height: 60–280 mm Length: 2700–14000 mm
<b>Surface and tolerance dimensions</b>	one side visual grade, other sides non-visual grade planed on 4 sides with chamfer visual side sanded on request ± 1 mm in width and height ± 3 mm length tolerance
<b>Wood moisture</b>	12 % ± 2 %

\* on request

Features	Permissibility
<b>Glued joint</b>	open joint up to 2 mm permissible
<b>Fracture in wood</b>	not permissible
<b>Rough areas</b>	not permissible
<b>Discoloration, red stripes</b>	slight discoloration of up to 5% of the surface permissible
<b>Nail-proof brown stripes</b>	not permissible
<b>Resin pockets</b>	up to 5 x 50 mm permissible
<b>Bark inclusions</b>	occasionally permissible
<b>Chunking</b>	minor chunking permissible in small numbers
<b>Sound knots</b>	permissible

Features	Permissibility
<b>Loose knots</b>	not permissible
<b>Tiny knots</b>	permissible
<b>Solid dead knots</b>	occasionally permissible
<b>Heartwood</b>	occasionally permissible
<b>Insect attack</b>	not permissible
<b>Waney edge</b>	not permissible
<b>Rot areas</b>	not permissible
<b>Checks</b>	occasionally permissible
<b>Packaging and storage</b>	Packaged in PE film



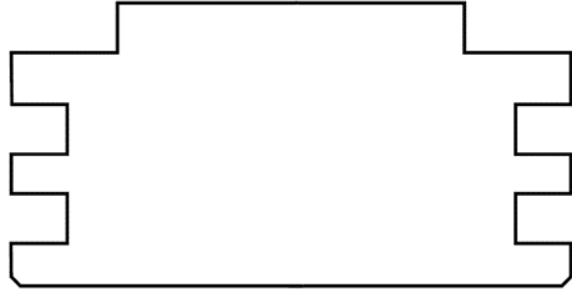
# Mechanical properties

Strength classes		C24
Elasticity modulus	$E_{//\text{mean}}$	on request
	$E_{\perp\text{mean}}$	
Shear modulus	$G_{\text{mean}}$	
Bending strength	$\sigma_{0.05}$	
Tensile strength	$\sigma_{t//0.05}$	
	$\sigma_{t\perp0.05}$	
Compressive strength	$\sigma_{c//0.05}$	
	$\sigma_{c\perp0.05}$	

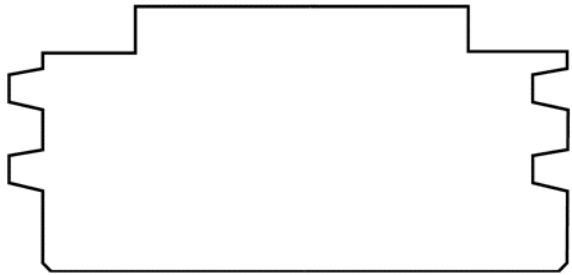
# Product composition

Thickness [mm]	Layers							
	Number	S1	S2	S3	S4	S5	S6	S7
60	3	20	20	20				
80	3	20	40	20				
100	3	30	40	30				
120	3	40	40	40				
100	5	20	20	20	20	20		
120	5	20	30	20	30	20		
140	5	40	20	20	20	40		
160	5	40	20	40	20	40		
200	5	40	40	40	40	40		
220	7	40	20	40	20	40	20	40
280	7	40	40	40	40	40	40	40

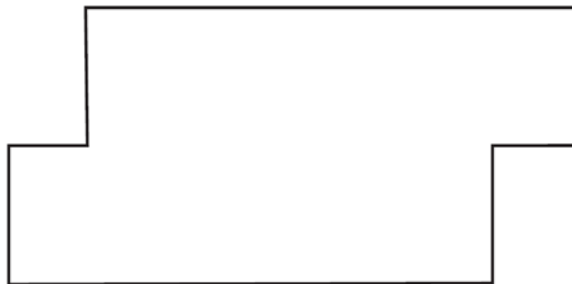
# Cross-laminated timber groove profiles\*



<b>Double groove and rebate</b>	
height	140-280 mm (in steps of 20 mm)
groove depth	20 mm
groove height	20 mm
rebate depth	50 mm
rebate height	20 mm



<b>Double tongue and groove with rebate</b>	
height	120-280 mm (in steps of 20 mm)
groove depth	15 mm
groove height	-
rebate depth	50 mm
rebate height	20 mm



<b>Shiplap edge</b>	
height	60-280 mm (in steps of 20 mm)
groove depth	-
groove height	-
rebate depth	50 mm
rebate height	50 % of the total height

\*diagram

Other profiles on request.

# Joinery

<b>Machine Equipment</b>	Hundegger K2-Industry	
<b>Labeling</b>	Individual label	
<b>Optional Component Inscription</b>	Project name	Ink jet and marking system
	Component number	
	Markings	
<b>File Format</b>	.BVX, .BVN	

# Imprint

**Mosser Leimholz Gesellschaft m. b. H.**

**Company headquarters & postal address:**

Fohlenhof 2  
A-3263 Randegg  
+43 7487 62 71-0  
office@mosser.at

**Register court:** District Court of St. Pölten

**Commercial register number:** FN93662p

**Sales tax ID number:** ATU20146606

**Chamber affiliation:** Member of the Austrian Wood Industries Association

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