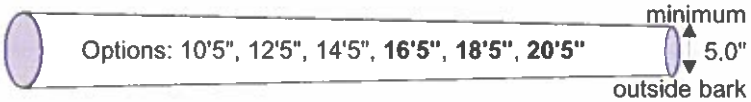
WEYERHAEUSER GRANDE PRAIRIE SAWLOG QUALITY SPECS

Intent: maximize sawlog recovery ensuring logs are safe to haul, unload, and stack

Lengths & diameters of Spruce & Pine & Balsam Fir



4.5" top acceptable to achieve a 20'5" sawlog

Absolute **minimum** sawlog length is 10' 3"
Absolute **maximum** sawlog length is 20' 7"
Target trim allowance is 5", plus or minus 2"
Mill killer length is 20' 11"
Logs longer than 20' 11" must be reprocessed

Industrial Salvage Operations: no 20'5" sawlogs (max. 16'5") or Balsam Fir sawlogs (sort Balsam Fir to pulp)

Maximize sawlog volumes within these specifications. Consider shorter saw & pulp lengths to achieve this.

Manufacturing:
All ends to be cut square (no need to recut square buncher face, use photoeye)
Do not make 20'5" sawlogs from heavy branched or loose-barked trees
20'5" sawlogs should be sorted separately to maximize weights on trucks
Cut broken tops as close to break as possible (random length sawlog)

Oversize:
Logs 20" and larger at the butt to be marked (O or X) and sorted separately from regular sawlogs with butts oriented all the same way
Butt diameter 20" to 24" - paint "O", butt diameter 24" and larger - paint "X"
Length options: 16'5", 18'5", 20'5"; no oversize shorter than 16'5" unless bucking for defect
Trees with butt diameters over 30" should not be cut. If cut, butt must be trimmed flush prior to processing (absolutely no step cuts)

Species:
Pine, White Spruce, Black Spruce, Balsam Fir
Balsam Fir sawlogs will be sorted and loaded separately (by bunk) from Spruce and Pine

Dead Wood:
Standing dead with tight bark (no sloughing and no beetle rot) can be sorted to sawlogs
Beetle rot and sloughing bark will be sorted to pulp
Dead balsam fir (with sloughing bark) will be sorted to the burn pile

Checking:
Open checking (frost cracks) are allowed (maximum one check per log)
If checking spirals, cannot be more than 1/4 of the log circumference

Mechanical Fiber Damage:
Minimize through attention to saw placement; no greater than 2" deep
Minimize butt shatter from bunchers (cut vs push) and processors (supported cuts)

Butt Rot:
Butt > 10" - maximum 50% of cross sectional area of butt (2/3 diameter)
Butt < 10" - maximum loonie-sized rot and must be fully contained by the shell of log
No rot or stain allowed in balsam fir sawlogs

Limbs:
Trim off flush with log stem

Root Flare, Butt Flare:
Maximum 2" per side, no need to get to zero flare

Forks:
Cut at fork (random length sawlog) and assess resulting three pieces separately

Crooks, Pistol Grips:
None allowed (sort to pulp, as a piece 8 feet long)

Catface:
Butt > 10" - damage must be no more than 1/2 diameter of log
Butt < 10" - damage must be no more than 2" deep

Sweep:
Butt > 10" - maximum 3.5" of sweep allowed
Butt 6 - 10" - maximum of 2" of sweep allowed
Butt < 6" - no sweep allowed
Manage sweep by making shorter sawlogs

Reducing mud and debris on the ends of sawlogs

Intent prevent mineral soil from contacting and adhering to ends of logs at each stage in the process

Decking and Processing
- logs to be decked on high ground whenever possible
- logs to be decked back from roads far enough to prevent mineral soil from splashing on logs
- decks are to be moved back prior to road work if there is risk of mineral soil contaminating logs
- do not push ends of logs into the ground
- ends of sawlogs must be cut square - no broken ends or step cuts
  - buncher cuts are allowed if they are smooth and square without step cuts

Loading
- avoid allowing either end of sawlog to contact the ground
- DO NOT align log ends by butting them up on the ground; use decked wood or side of loaded truck

Hauling
- do not haul in conditions that will cause mineral soil to contaminate the ends of sawlogs

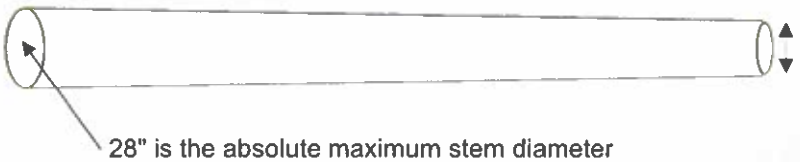
Unloading
- avoid allowing either end of sawlog to contact the ground
- logs to be decked on high ground whenever possible
- in staging yards, sawlog decks are to have brow logs under the tops of the sawlogs
  - use pulp or hardwood where possible
  - when reloading, salvage brow logs into sawlog loads only if undamaged and clean

Storage
- deck logs in areas that are not subject to road spray or splashing from passing traffic
- deck logs on well drained or higher ground whenever possible

WEYERHAEUSER GRANDE PRAIRIE PULPWOOD QUALITY SPECIFICATIONS

Intent: Maximize sawlog recovery with resulting pulpwood that is safe to load, haul, unload, and stack

Diameters:



28" is the absolute maximum stem diameter
Pieces 28" or greater on the butt must be sorted to sawlog, or left standing as tree retention

Lengths:

14' is optimum length, but minimize sawlog in pulp by going to 2.5 inch top
8' is the minimum length
14' 4" is the maximum length

When processing defect out of sawlogs
8' minimum length for pieces under 20" on the butt
14' minimum length for pieces 20" or greater on the butt

Decking: Pieces less than 14' to be centered in deck. Do not deck on top of debris pile.

Salvage: Broken pieces (minimum 8' long to a 2.5" top) must be salvaged as pulp.

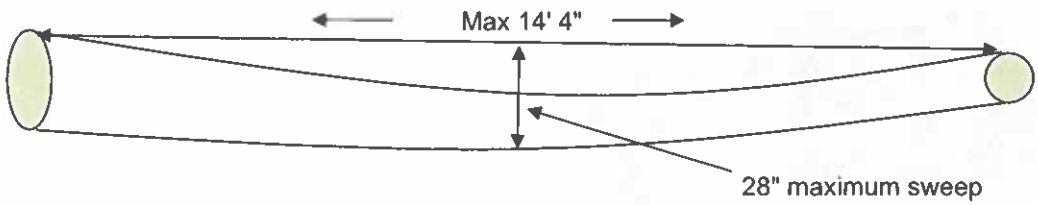
Species: Pine, White Spruce, Black Spruce, Balsam Fir, Tamarack

Dead Wood & Blowdown: Pieces with sloughing bark and beetle rot can go to pulp
Pieces with no bark should go to the burn pile

Limbs: Trim off flush with stem. During processing, ensure branches do not contaminate the deck

Crook and stem size: Pulpwood must be able to fit through a tube that is 28" in diameter

Sweep:



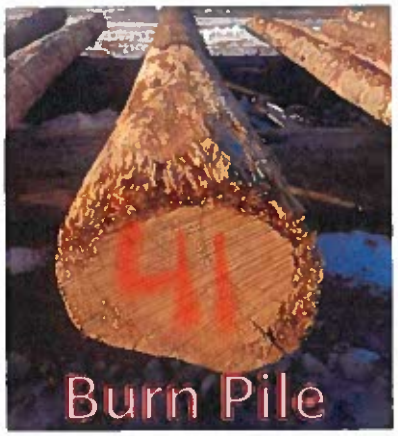
Forks:

May-23

Deadwood Guidance for Spruce and Pine (Dead balsam fir, with sloughing bark, will go to the burn pile)

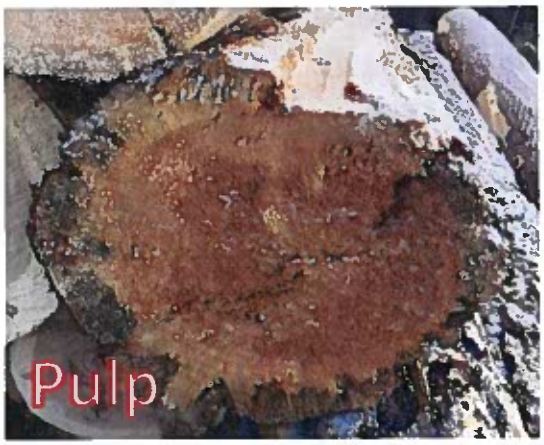
Does the dead log have beetle rot or is completely barkless → Yes → Burn Pile

No



Does the dead log have sloughing bark and beetle rot? → Yes → Pulp

No



Does the dead log have tight bark with minimal sloughing and no beetle rot? → Yes → Sawlogs

Open checking (frost cracks) are allowed as long as bark is tight
If checking spirals, cannot be more than 1/4 of the log circumference

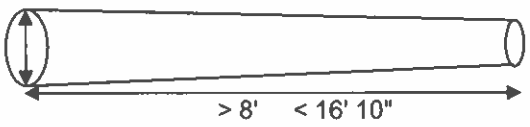
May-23

WEST FRASER HARDWOOD QUALITY SPECS

Lengths and diameters:

Diameters:

6 inch minimum butt diameter



4 inch minimum top diameter or to point of heavy branching

Oversize: > 26" at the butt; marked as oversize with a painted "O/S" on the butt

Lengths: The minimum length is 8 feet
To ensure safe log haul, minimize number of pieces < 12 feet in length
16' 6" is the optimum length
16' 10" is the absolute maximum length

Species: Aspen, Poplar or Birch

Dead Wood: Obviously rotten, significant checking or excessive bug holes will not be accepted
Recently dead but still sound wood is acceptable

Salvage: Broken pieces (minimum 8 feet long to a 4 inch top) must be salvaged
No broken ends, attached snipes or ends not squared

Limbs: Trim off flush with stem

Butt Flare: Maximum 2" on butts less than 20"
Maximum 4" on butts greater than 20"

Butt Rot: Maximum 50% basal area of butt. Buck off 2 foot increments until achieved

Forks: Buck out and assess all three pieces for merchantability

Crook: Maximum 100% offset on stems less than 16" at the crook
Maximum 50% offset on stems greater than 16" at the crook

Sweep: Maximum 10" in a 16' 6" section

Oversize Loading: Prefer all O/S loaded on one bunk. Otherwise, O/S will be loaded on the top of the front or rear bunks of the load.

May-24

WEYERHAEUSER GRANDE PRAIRIE LOADING SPECIFICATIONS

Split loads of either (a) sawlogs & pulp, or (b) spruce/pine sawlogs & balsam fir sawlogs in one load
will require two TM9 forms and two weigh in/out cycles

Sawlog butt orientation
All sawlog sorts must all be "butts one way", reversing only once per bunk if needed to achieve a level bunk

Sawlog size determination
See second page

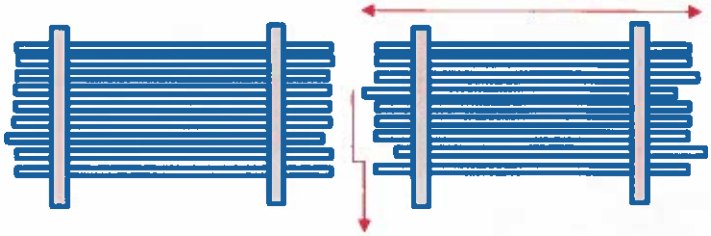
Oversize sawlogs (20" diameter and larger at the butt)
Logs 20" and larger at the butt to be painted (O or X) and sorted separately from regular sawlogs
Butt diameter 20" to 24" - paint "O"; butt diameter 24" and larger - paint "X"
All oversize logs (O and X) can be sorted and loaded together
All oversize logs must be loaded butts one way
Prefer pure bunks of O/S only - can reverse butts once per bunk to level out
Otherwise, O/S logs can be loaded on top of sawlog bunks (Fb O/S on top of Fb sawlogs)
Do not mix sawlogs and O/S throughout the bunk

Pulp butt orientation
Butts and tops can be mixed, loaded both ways to achieve level load
Note: winches placed on the inside of the bunks stakes are susceptible to damage from the crane and will no longer be paid for by the mill. Best placement is directly under the bunk.
Minimum bunk spacing is 10 feet to allow the crane room to unload

Balsam Fir and Tamarack Pulp
For pulp, all species can be mixed on each bunk
Pulp loads containing >30% fir and/or tamarack will be called "balsam load" approaching the scale

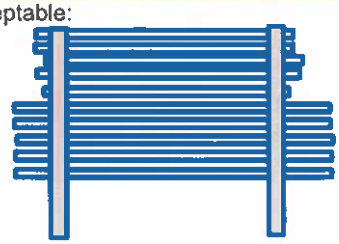
Sawlog and pulp stacking within a bunk
20' 5" sawlogs to be sorted and loaded separately in pure bunks
Each bunk must have the longest logs in the bunk all flush
Bunks must have a clean and clear separation
there will be no overlap of logs between bunks
Acceptable:

max 22 foot bunk length, front to back



clear separation between bunks

Loading short logs in sawlog and pulp bunks
Logs that are 4 or more feet shorter than the longest logs in the bunk must be loaded in the center of the bunk and preferably on top of the longer logs
Acceptable:



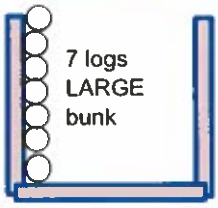
minimize short logs in bottom 2 feet of bunk

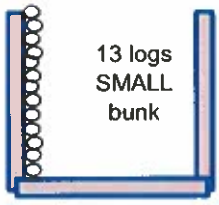
Process for off-spec loads
Wood yard operators may refuse to unload off-spec loads that are unsafe to unload.
Loads deemed unsuitable for unloading, piling, or feeding to the mill, may be downpiled for inspection.
In either case, contractor and WY rep will assess load and develop plan to unload safely and minimize future occurrences.

May-24

Process to determine sawlog size (large or small)

Each bunk will have its own size designation
It is the driver's responsibility to make and announce the size calls by bunk
Driver will count the number of logs up each front stake on the driver's side of the load
- 12 logs or fewer along the stake = large bunk
- more than 12 logs along the stake = small bunk





Driver will call size for each bunk.
For example:
"green sawlogs, 2 large & 1 small"
"dry sawlogs, 2 small & 1 oversize"
"green sawlogs, 2 large & 2 small"

Driver will call on approach to the mill and also when unwrapped.

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