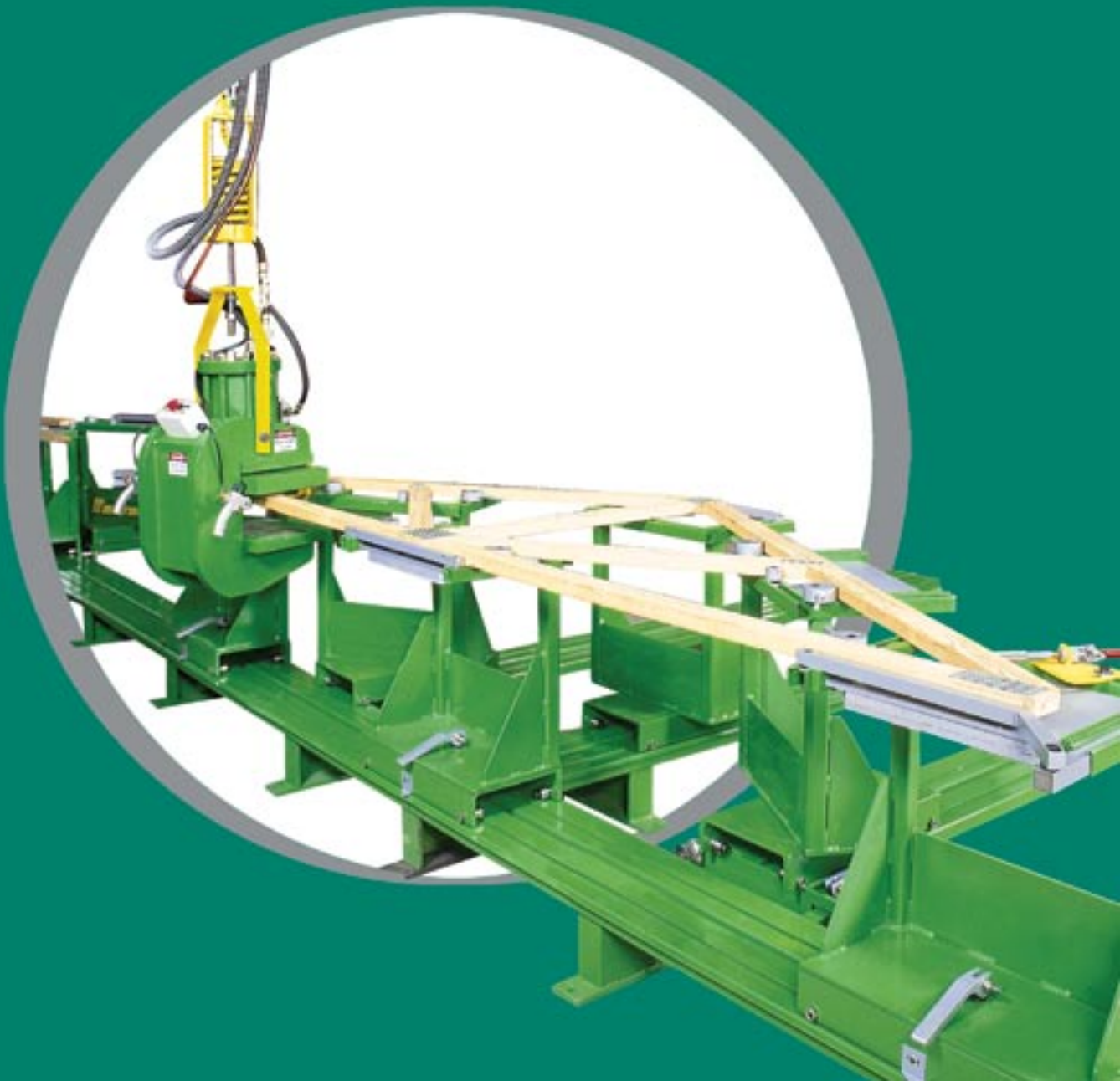


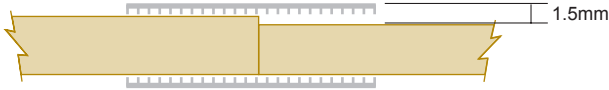


Manufacturing Specification

for Nailplated Roof Trusses



TIMBER SIZE



All timber must be at least the size specified on the cutting sheets.

Any undersize must not exceed the specified undersize.

The maximum difference in timber thickness between any two adjacent timber members at a joint must not exceed 1.5mm.

TIMBER GRADE



All timber must be at least the grade specified on the cutting sheets.

The timber must be graded in accordance with the relevant Australian Standard.

TIMBER MOISTURE CONTENT

For seasoned timber the moisture content shall not exceed 15% in the timber used in the manufacture of nailplated timber trusses.

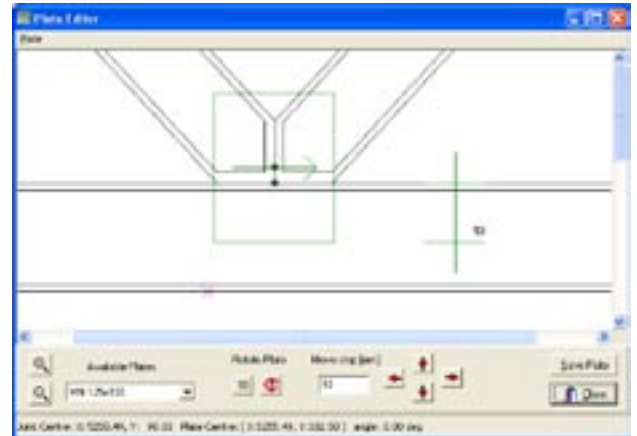
For engineered timber products please refer to the manufacturer's specification.

TIMBER DEFECTS

In addition to the grading rules from the relevant Australian Standards, timber with the following defects, used in the manufacture of nailplated timber trusses, shall comply with the following:-

- Sloping grain shall be avoided in trusses manufactured from either seasoned (dry) or unseasoned (green) hardwood. This is of particular concern around highly loaded joints especially in the top chord at heel joints.
- Brittleheart in hardwood timber shall not be used.
- Pith in softwood shall be avoided under or immediately adjacent to the nailplate.
- Loose knots shall be avoided under or immediately adjacent to the nailplate.
- Untreated "Lyctus" susceptible sapwood under the nailplate is not allowed.
- Timber with spring should always be cut and/or positioned so that the spring is opposite to the deflection under dead load.

NAILPLATE SIZES

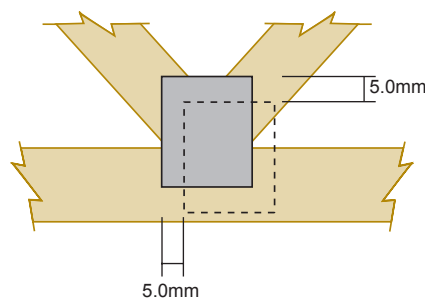


All nailplates must be at least the size (width and/or length) specified on the cutting sheet.

NAILPLATE TYPE

Nailplates must be the type specified on the cutting sheet. The only exception is the substitution of MNH for MN provided the nailplate is at least the same size (width/length).

NAILPLATE LOCATION



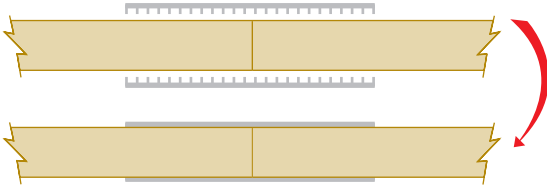
Nailplates must be located within 5mm of the dimensions specified on the cutting sheets.



NAILPLATE GEOMETRY

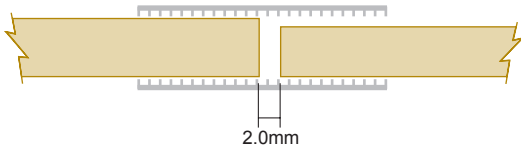
Nailplates must be positioned at the angle specified on the cutting sheets.

NAILPLATE PRESSING



Nailplates should be pressed fully into the timber. The maximum tolerance is 1.5mm. This tolerance is measured as the sum of the average gap per plate per joint. For example if one plate has an average gap of 1.5mm and the other side is fully pressed then this joint satisfies the tolerance. However if each plate has an average gap of 1.0mm then this joint exceeds the allowable tolerance and is not permitted.

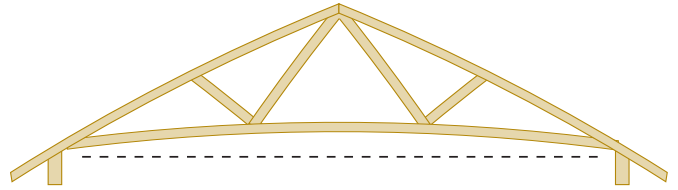
JOINTS



All timber at a joint should be cut and positioned with little or no gaps between timber members. The tolerances are as follows:-

- The maximum gap between any timber members at a joint is 2.0mm and
- The sum of these gaps for a single truss shall not exceed 6.0mm.
- Please note the above rules do not apply to trusses fabricated using "Turbo-Webs".

CAMBER



The manufactured camber should be in accordance with the cutting sheet.

The maximum tolerance should be 3.0mm

EQUIPMENT & HANDLING



The equipment utilised in the fabrication of timber roof trusses shall be used so as not to cause any damage to the structural integrity of either the timber or nail plates.

Handling of the timber from initial storage through to truss installation shall be performed in a manner that does not damage or overstress the timber and/or the pressed nail plates.



MULTINAIL AUSTRALIA PTY. LTD.
ABN 79 003 999 586

HEAD OFFICE

100 Cameron Street
Wauchope NSW 2446 Australia
T. + 61 (0)2 6585 3400
F. + 61 (0)2 6585 3697
E. sales@multinail.com.au
W. www.multinail.com



Multinail's Head Office and Manufacturing Facility at Wauchope is certified as complying with Australian Standard ISO9001 for the production of Nailplate, Bracing and Ancillary Components.

BRISBANE OFFICE

15 Mary Street
Kingston QLD 4114 Australia
T. + 61 (0)7 3808 3220
F. + 61 (0)7 3208 2841

CAIRNS OFFICE

23 Karwin Street
Bayview Heights QLD 4868 Australia
T. + 61 (0)7 4054 2062
F. + 61 (0)7 4054 7741

SYDNEY OFFICE

15/10 Victoria Avenue
Castle Hill NSW 2154 Australia
T. + 61 (0)2 9865 7011
F. + 61 (0)2 9865 7010

MELBOURNE OFFICE

6/16 Melverton Drive
Hallam VIC 3803 Australia
T. + 61 (0)3 9796 3127
F. + 61 (0)3 9796 3374

MULTINAIL MACHINERY PTY. LTD.
ABN 52 060 402 860

NEW SOUTH WALES

100 Cameron Street
Wauchope NSW 2446 Australia
T. + 61 (0)2 6585 3400
F. + 61 (0)2 6586 1268

QUEENSLAND

51-61 Musgrave Road
Coopers Plains QLD 4108 Australia
T. + 61 (0)7 3336 1777
F. + 61 (0)7 3275 3419

MULTINAIL ASIA SDN. BHD.

KUALA LUMPUR OFFICE

No. 1, Jalan TPP6/13
Pinwang Industrial Park
47100 Puchong
Selangor Malaysia
T. + 60 (0)3 8061 6800
F. + 61 (0)3 8061 6801
E. asia@multinail.com.au

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