

## Why use Marley?

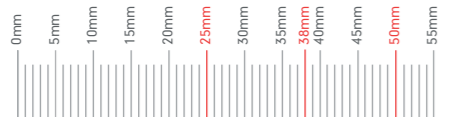
JB Red completely meets the BS 5534 and NHBC requirements for fully graded roofing battens and it is the only UK factory graded roof batten certified by the BBA (Certificate 19/5668). The battens are exceptionally strong, have full chain of custody certification and are CCPI verified.

We also offer the most comprehensive roof system on the market covered by a 15 year warranty.

If your batten measures less than 25mm, it is not a roofing batten

Find out more.

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info@marley.co.uk  
marley.co.uk



## Graded batten checklist

Item to Assess	Other roofing battens	JB Red
Dimension (full measure)	Check with supplier	✓
Length	Check with supplier	✓
Knots	Check with supplier	✓
Wane	Check with supplier	✓
Slope of grain	Check with supplier	✓
Distortion	Check with supplier	✓
Species	Check with supplier	✓
Fissures	Check with supplier	✓
Rate of growth	Check with supplier	✓
Cut from side boards	Check with supplier	✓
Decay and insect attack	Check with supplier	✓*
Treatment BS 8417	Check with supplier	✓*
Identification and marking	Check with supplier	✓
PEFC Certified	Check with supplier	PEFC Certified
Wood Protection Association Certified	Check with supplier	✓
Third Party Accreditation	Check with supplier	BBA Certified

\* to achieve a 60 year desired service life

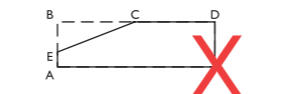
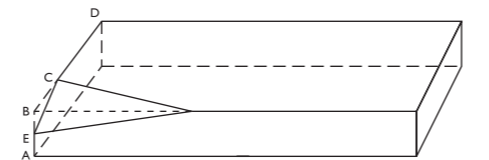
## Wane

Wane which is found along the whole length of the batten is permissible (in these instances it is recommended the roofer turns the batten over and fixes tile to the face). Wane is permitted on one arris and should not exceed one-third of the dimension of each of the faces on which it occurs.

B to C must not exceed 1/3 B to D,  
B to E must not exceed 1/3 B to A

For 25 x 38 B to C must be less than 12mm and B to E less than 8mm

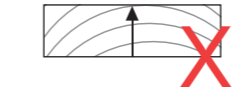
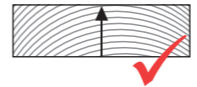
For 25 x 50 B to C must be less than 16mm and B to E less than 8mm



	Done
JB Red	✓
Non-JB	check

## Rate of growth

There should be an average of not less than four annual growth rings per 25mm measured at each end.

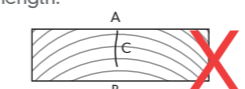
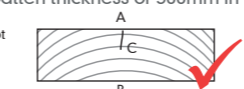


	Done
JB Red	✓
Non-JB	check

## Splits and fissures

End splits (through the piece) that occur before fixing should be trimmed off. End splits or splits at intermediate supports that occur due to nailing should not be greater than 150mm long. Fissures (not through the piece should not exceed half the batten thickness or 300mm in length.

The depth of fissure C cannot be more than 1/2 A to B.  
For 25 x 38 or 25 x 50 A to C must be less than 12.5mm



	Done
JB Red	✓*
Non-JB	check

\*End splits can subsequently occur and should be cut off after grading.

**Defects** should be cut out and any batten less than 1.2 metres long (or sufficient to span at least 3 supports) should be discarded.

**Dimension Tolerances** Battens should meet the following tolerances: Width +/- 3mm Thickness +3mm/-0mm when measured at reference moisture content of 20%\*

**Decay and Insect Attack** Battens and counter-battens should be free from rot and live insect attack.

**Sap Stain** Sap stain such as 'blue stain' is not deemed to be a structural defect and is therefore permitted.

**Resin Pockets** Resin pockets on either face of a batten are permitted provided that no resin pocket exceeds 70mm in length, or 6mm in width, or one third of the batten thickness. Resin pockets on either side of a batten are permitted provided that no resin pocket exceeds 70mm in length, or 6mm in width, or 12mm in depth.

\* Note: The dimensions of battens and counter-battens are based on measurement at 20% moisture content. As timber swells on wetting and shrinks on drying, dimensions measured at other moisture contents may be adjusted to the 20% values by allowing 1% change in cross-sectional dimensions for every 4% change in moisture content.



What to look for in graded battens



## Welcome

This pocket grading guide sets out the grading requirements for Roofing Battens to meet BS 5534. This guide is intended to help you check any batten where there may be a doubt over the grade. There is no tolerance for error within BS 5534 when supplying graded battens. Marley uses a modern high technology laser grading machine to ensure quality and consistency and always recommend that kiln dried sideboards should be used for manufacturing roofing battens. If there is any doubt over the grade, checks should be made with the supplier and any third party accreditation body.



Sideboards

## Why use JB Red?

Meets all the requirements of BS 5534

No further grading required reducing time and cost

Reduced risk of complaints

Consistent thickness and width

Unique red colour – easily identifiable with building control

Manufactured from slow grown kiln dried sideboards



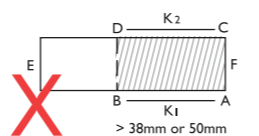
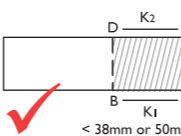
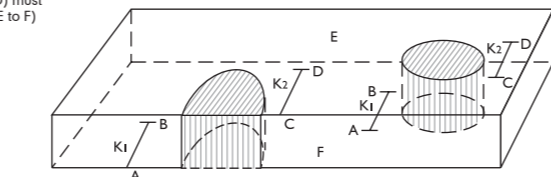
## Knot sizes

For knot sizes, the sum of dimensions K1 and K2 encompassing a knot should not exceed the actual width of the batten.

K1 (A to B) + K2 (C to D) must not exceed the width (E to F)

25 x 38 - K1 + K2 must be less than 38mm

25 x 50 - K1 + K2 must be less than 50mm



	Done
JB Red	✓
Non-JB	check

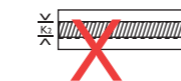
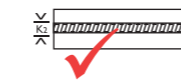
## Knot position

A knot appearing on both sides of the batten, which does not appear on the face, is not deemed to be a permissible defect, if the knot on either side is greater than 1/5 of the depth. A knot appearing on both sides of the batten and on the face is not deemed a permissible defect.

Note: Face is parallel to the slating or tiling. The width is the dimension of the face(s).

Not permissible if either K1 or K2 are more than 1/5 of the depth

25 x 38, 25 x 50 – Both K1 and K2 must be less than 5mm



	Done
JB Red	✓
Non-JB	check

## Distortion

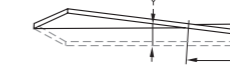
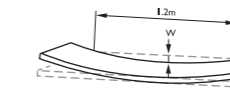
Battens need to be straight and there is now a tolerance on distortion. Battens cut from side boards are unlikely to distort. Bow, spring or twist should each not be greater than 5mm, measured over a length of 1.2m at a reference moisture content of 20%.

Measurements of Distortion:

Bow = W = max. 5mm

Spring = X = max. 5mm

Twist = Y = max. 5mm

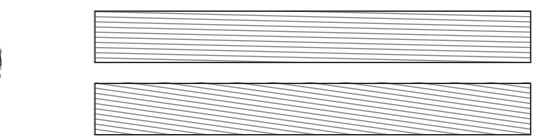
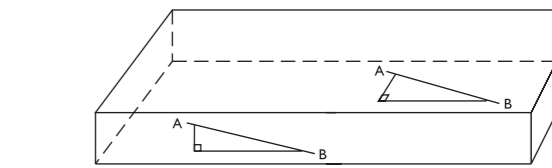


	Done
JB Red	✓
Non-JB	check

## Slope of grain

The deviation of the slope of grain from the longitudinal axis should not exceed 1 in 6 on either axis.

Note: A method and tool for measuring slope of grain is given in BS 4978 (Specification for visual strength grading of softwood)



	Done
JB Red	✓
Non-JB	check