Weyerhaeuser Scaling Process

October 18, 2006

Traditional Hand Cutting

Bucking to Card Specifications

Either By Hand or Machine

LONGVIEW TIMBERLANDS
Bucking Instructions
SAFETY IS OUR #1 PRIORITY
March 2004

Type	Sort Code	Min. Top Dia.	Max. Lrg. Dia.	Surface Characteristics	Preferred Lengths (*Doug Fir has 12" of trim*)	Acceptable Lengths (*Doug Fir has 12" of trim*)
EXPORT SS,IS,JGC	2-25-55	12"+	39"	WELL SCATTERED KNOTS FROM 1" TO 2 ½"	40', 36', 26'	39', 34', 33',30'
SMALL EXPORT SLC	9	9"-11"	N/A	CLEAN SURFACE TO SCATTERED 1 ½" KNOTS	40',36', 26'	39', 34', 33', 30'
DOMESTIC				2 1/2" - 3" KNOTS		
GC	5	12"	N/A		40', 36'	12' + 2' MULTIPLES
QUAD	13	8"	N/A		40', 36'	12'+ 2' MULTIPLES
CHIP & SAW	16	5"-7"			N/A	12'+ 2' MULTIPLES
DOUG-FIR FIBER	8	4"		N/A	N/A	10' + TO 40' MAXIMUM LENGTH

SPECIAL INSTRUCTIONS FOR EXPORT:
- BUCK TREES TO MAXIMIZE EXPORT SORTS. 12" + DIAMETERS ARE TOP PRIORITY
- 12"+ If 60' of 12"+ THEN BUCK 2 LOGS 12+ MAXIMIZE 12"+ EXPORT LOGS
- MEASURE ALL LOGS IN THE TREE PRIOR TO BUCKING.
- DO NOT BUCK 28', 32', 38' LOG LENGTHS IN EXPORT SORTS.
- ELIMINATE EXCESSIVE SNOW BREAKS, SPIKE KNOTS AND OFFSETS.
- DEFECT: NO ROT, HOOKED BUTT, CAT FACE, MASSED PITCH, FORKS, DOUBLE HEARTS, FLARED BUTTS AND STUMP PULL IN EXPORT SORTS, BUCK UP TO 6' LONG BUTT OR SHORT LOG 12' + TO CLEAR DEFECT.
- SWEEP: LOG MUST RECOVER STRAIGHT 13 FT. SEGMENTS (4-METER RULE). TAPE MUST NOT LEAVE THE LOG ON SL/SC SORTS.

SPECIAL INSTRUCTIONS FOR DOMESTIC:
- BUTT ROT/PITCH ALLOWED TO 1/6TH THE BUTT DIAMETER. REMOVE HOOKED BUTTS, DOUBLE HEARTS, FORKS, AND SEVERE FLARES. MUST HAVE 8' OF SAWABLE WOOD ON EACH SIDE OF A SNOW BREAK. ONE SNOW BREAK ALLOWED PER LOG.

Red=Peeler Lengths

Green= Domestic Lengths

Loading the Fast Way

The Importance of the Information Flow

Information Driven by the Setting # G6434

Entering the Load Information

Training New Scalers

SunRise Reporting
Ticket Detail
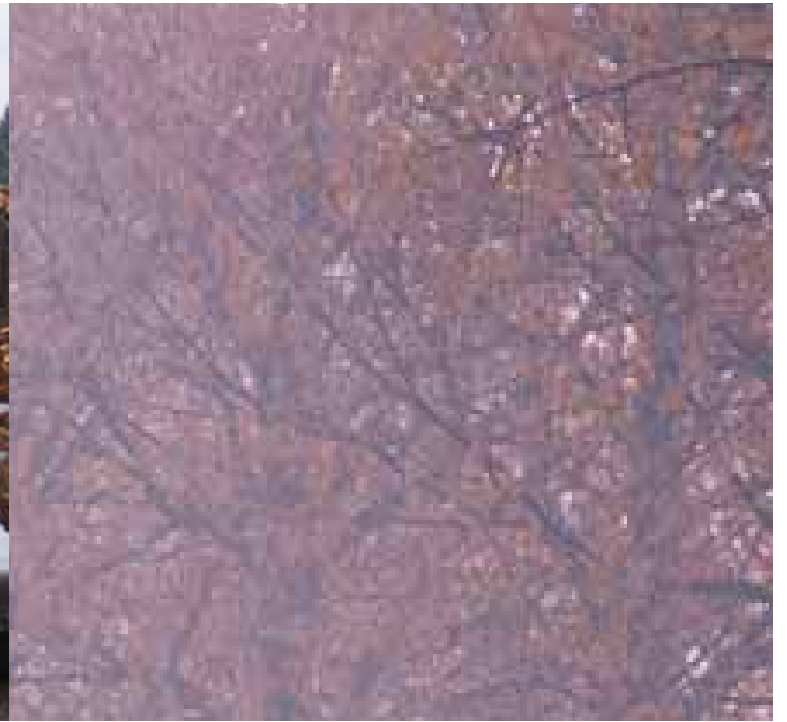
Management Zone : DA Bruce Davis - WA only

Ticket Summary

Setting	Equip	MZ	Load ID	Load Date	Destination ID	Name	Mix	Load Species	Tot	Good	Pct	Qual	Pct	Value Op	CF
L308000	113	DA	LV 2145046	08/25/04	5	NWHD-LV-Scal	H1	ALD	27	23	85	0	0	14.88	617
			LV 2145047	08/25/04	4	Gram	D1	WRC	29	29	100	0	0	0.00	1,235
			LV 2145049	08/25/04	4	Gram	D1	WRC	29	29	100	0	0	0.00	1,052
			LV 2145088	08/27/04	1	Longview	L1	DF	12	11	92	1	8	2.20	982
			LV 2145092	08/27/04	1	Longview	L1	DF	35	12	34	0	0	58.19	1,087
			LV 2145096	08/27/04	1	Longview	L1	DF	17	14	82	1	6	9.90	1,059
* Total for Setting L308000									149	118	79	2	1	85.17	6,032

Mis-Sort and Quality Calls / Log Detail

Setting	Load ID	Load Mix	Dest	Log Nbr	Len	Top	Butt	Species	Gd	Load Sort	Log Sort	Mis Sort	Deduct Len	Dia	Log CF	Qual Code	Value Op
L308000	LV 2145046	H1	5	1	18	7	0	ALD	79	24	L	**			8		1.92
				17	18	7	0	ALD	79	24	L	**			8		1.92
				19	16	7	0	ALD	79	24	L	**			7		1.68
				20	30	13	0	MAP	52	24	L	**			39		9.36
	LV 2145088	L1	1	1	36	18	22	DF	60	90	05		16		86	K	
				8	28	9	12	DF	70	90	13	**			20	EK	2.20
				11	40	19	24	DF	60	90	55				110	*L	
	LV 2145092	L1	1	1	40	9	13	DF	70	90	13	**	2		31	SB	3.41
				3	40	8	12	DF	70	90	13	**	1		26	EK	2.86
				4	40	8	12	DF	70	90	13	**			26	U	2.86
				7	30	9	12	DF	70	90	13	**			21	EK	2.31
				8	30	11	15	DF	70	90	13	**	4		32	SN	3.52
				10	32	9	13	DF	70	90	13	**	2		25	SB	2.75
				11	30	8	11	DF	70	90	13	**	1		18	SB	1.98
				12	26	8	11	DF	70	90	13	**			15	U	1.65
				13	32	8	12	DF	70	90	13	**	6		21	TR	2.31
				14	30	11	15	DF	70	90	13	**			32	EK	3.52
				15	26	8	11	DF	79	90	13	**	2		15	SB	1.65
				17	40	9	13	DF	70	90	13	**	2		31	S	3.41
				18	26	8	11	DF	70	90	13	**			15	U	1.65
				20	26	9	12	DF	70	90	13	**	1		18	S	1.98
				21	40	10	15	DF	70	90	13	**	3		39	SN	4.29
				22	26	9	12	DF	70	90	13	**	1		18	SB	1.98
				23	26	11	14	DF	70	90	13	**	1		26	EK	2.86
				24	26	8	11	DF	70	90	13	**	1		15	U	1.65
				25	36	8	12	DF	70	90	13	**	1		23	S	2.53
				28	30	8	11	DF	70	90	13	**	1		18	SB	1.98
				29	26	9	12	DF	70	90	13	**	1		18	S	1.98
				30	40	9	13	DF	70	90	13	**	2		31	S	3.41
				35	26	8	11	DF	70	90	13	**			15	U	1.65
	LV 2145096	L1	1	4	40	13	18	DF	60	90	05		1		59	SN	
				5	40	9	13	DF	70	90	13	**	3		31	SB	3.41
				6	40	14	19	DF	60	90	05		2		66	S	
				7	40	9	13	DF	70	90	20		4		31	*H	
				9	26	13	16	DF	60	90	05		1		34	S	
				11	26	12	15	DF	60	90	05		1		30	SN	
				13	36	9	13	DF	70	90	13	**	2		28	S	3.08
				14	40	9	13	DF	70	90	13	**	1		31	S	3.41

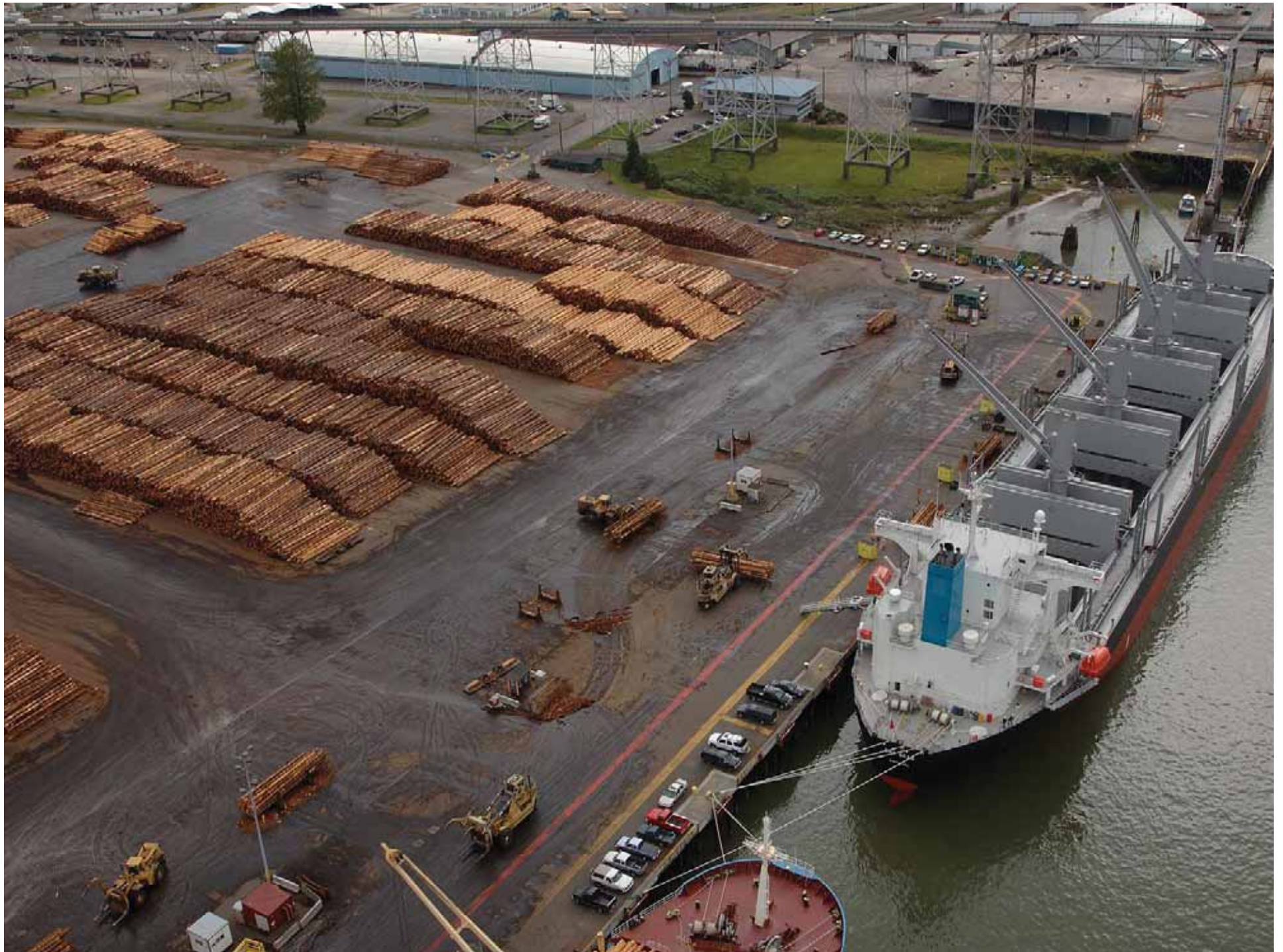Timely Feedback on Loads of Logs

Sorting and Tagging

Shovel Sorting

Staging for Ship Loading

Data Recording for Ship Loading

Weyerhaeuser Stacker

Longshore

Floating Inventory

Barge Delivery from Dallesport

Serve Domestic Log Market

Office Folks

In the race for quality there is NO finish line!!