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**Specification for Handicraft Items
(Woodware Other Than Ebonyware)**

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Bureau of Ceylon Standards

Specification for Handicraft Items (Woodware Other Than Ebonyware)

S. L. S. . 243 : 1973

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~~REPLACES S.S. 243/73~~

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BUREAU OF CEYLON STANDARDS

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Ceylon Standards are subject to periodical revision in order to accommodate the progress made by industry. Suggestions for improvement will be recorded and brought to the notice of the Committees to which the revisions are entrusted.

This Standard does not purport to include all the necessary provisions of a contract.

BUREAU OF CEYLON STANDARDS

53, Dharmapala Mawatha,

Colombo - 3.

SRI LANKA STANDARD SPECIFICATION FOR HANDICRAFTS (WOODWARE OTHER THAN EBONYWARE)

FOREWORD

This Sri Lanka Standard Specification has been prepared by the Drafting Committee on Handicrafts. It was approved by the Civil Engineering Divisional Committee of the Bureau of Ceylon Standards and was authorised for adoption and publication by the Council of the Bureau on 10th December, 1973.

The moisture content of seasoned wood changes from season to season depending chiefly upon the fluctuations in atmospheric humidity, though here again the nature of the species and the cross section area of the piece as well as the surface treatment applied to it play an important part. It is essential that timber used for the manufacture of handicrafts should have attained a moisture content as near as possible to the value that will be attained in equilibrium with the average atmospheric conditions in service.

This specification differs from the specification for handicrafts (ebonyware), in that, this is applicable to items made using timber other than ebony. The seasoning schedule for these handicraft items are given in C. S. 159 : Ceylon Standard Code of Practice for Seasoning of Timber.

1. SCOPE

This Ceylon Standard Specification covers the type of timber, the seasoning procedure and finish for handicraft items made out of timber other than ebony. It does not cover the mode of manufacture. This specification does not include pigmented woodware.

2. TERMINOLOGY

For the purpose of this standard the following definitions shall apply:

2. 1 **Air seasoning** – Seasoning done in open air, usually protected from sun and rain.
2. 2 **Bonding** – The process of uniting two or more pieces of wood or veneers by means of an adhesive. This process is characterised by continuity of the union over the whole area in contact. The adhesive shall be waterproof and non-toxic.
2. 3 **Conditioning** – The process designed to suit the moisture content of timbers to the conditions and purposes for which it is to be used.
2. 4 **Equilibrium Moisture Content** – The moisture content which is attained by wood when placed in a constant condition of temperature and humidity.
2. 5 **Wood Wool** – Curling wood shavings used as packing material.
2. 6 **Kiln seasoning** – The process of artificial drying of timber in a kiln under controlled conditions of temperature, air movement and humidity to a pre-determined moisture content.
2. 7 **Knot** – A branch base or limb embedded in the tree or timber by natural growth.
2. 8 **Moisture content** – The weight of water present in wood expressed as a percentage of its oven dry weight.
2. 9 **Full-Gloss** – A term used about enamels, varnishes and paints meaning that they possess a high gloss finish when dry, as opposed to semi-gloss, egg-shell or matt finishes.
2. 10 **Semi-Gloss** – The term applied to a material which is designed to present a higher degree of gloss than a flat or egg shell sheen, but which has not the mirror-like appearance of a full gloss paint.
2. 11 **Egg-Shell Finish** – A term for a finish which is not completely flat, or matt, but which presents instead a slight sheen or lustre, similar to the sheen on an egg shell.
2. 12 **Flat (Matt)** – Possessing no sheen or lustre.

3. REQUIREMENTS

3. 1 **Timber** – Good quality timber free of sapwood conditioned according to clause 4 of this standard and without any cracks shall be used.
3. 2 **Dimensions** – Dimensions of items shall be given in millimetres.
 3. 2. 1 **Tolerance** – The tolerance on nominal dimensions specified shall be ± 5 per cent.
3. 3 **Finish** – Any type of finish can be used; provided it conforms to clause 5 of this standard. Toxic finishes shall not be permitted. No pigmented finish or dyed finish (e. g. boot polish) shall be permitted.

4. SEASONING METHODS

Seasoning methods are classified as follows:-

- (a) Air seasoning.
 - (b) Kiln seasoning.
4. 1 **Air seasoning** – The seasoning procedure shall conform to the method specified in C.S. 159 - Ceylon Standard Code of Practice for seasoning of timber.
 4. 2 **Kiln seasoning** –
 4. 2. 1 The seasoning procedure shall conform to the method specified in C. S. 159 - Ceylon Standard Code of Practice for Seasoning of Timber.
 4. 2 **Kiln Schedule** – The recommended schedules are given in C. S. 159 - Ceylon Standard Code of Practice for Seasoning of Timber. The Seasoning of timber is started at a comparatively lower temperature and higher humidity. These conditions are gradually altered as the timber dries, until towards the end of seasoning, when the temperature of the air inside the kiln is fairly high and the humidity is low.

The average moisture content of the wettest half of the total number of samples may be taken as a guide for making changes

in the kiln schedule in preference to one single sample which happens to be the wettest. This refers to the study of rate of drying of timber and changes in kiln schedule to be made during kiln drying of timber.

4. 3 Moisture content

4. 3. 1 Maximum permissible moisture content – The maximum permissible moisture content for these handicraft items shall be 15 per cent.

5. FINISH

5. 1 Requirements of an unfinished item

5. 1. 1 Colouring of sapwood using chemicals shall not be permitted.

5. 1. 2 Decayed sections shall not be permitted to be patched with other types of timber.

5. 1. 3 The item shall be free of cracks. Shellac or any other filler shall not be used for such fillings.

5. 1. 4 Pins, screws etc., used shall be properly embedded such that the points are not exposed. These pin/screw heads shall be covered with a filler.

5. 2 Graded finish – The finishes of handicraft items shall be graded as follows:–

- (a) Gloss.
- (b) Semi - Gloss.
- (c) Egg - shell.
- (d) Flat.

6. TESTS

6. 1 Determination of the type of timber (Drilling Test)

The type of timber used shall be determined by drilling at a suitable point of the base of that particular handicraft item.

6. 2 Determination of Moisture Content (Moisture Content Test).

6. 2. 1 Electrical Method – Electrical Moisture meters shall be used. When taking readings, the following rules shall apply.

- (a) Correction figures for the particular timber, pre-determined by oven-dry method, shall be used to calculate the correct reading.
 - (b) Handicraft items shall not be hot or surface wet or contain large moisture gradients due to painting, preservative treating or due to a wet core.
 - (c) Readings shall be taken at 3 different points, and the average reading taken for the item under test.
6. 2. 2 **Oven dry method** - Any dispute concerning the moisture content shall be decided by recourse to the oven drying method as described in C. S. 159 - Ceylon Standard Code of Practice for Seasoning of Timber.

7. SAMPLING AND INSPECTION

7. 1 Sampling

- 7. 1. 1 **Lot** - In any batch, all items of the same class, same dimensions and same type shall be grouped together to constitute a lot.

7. 2 Sample size and criterion for Conformity

- 7. 2. 1 The sample size shall be 2 percent for lots consisting of more than 250 items.
- 7. 2. 2 And for lots consisting of less than 250 items, the sample size shall be as agreed to between the purchaser and supplier.

8. PACKING AND MARKING

- 8. 1 **Packing** - Each handicraft item shall be packed in polythene bags/paper bags/cartons (not air sealed). These in turn are arranged in cardboard or wooden boxes with dry wood wool, dry wood shavings or paper cuttings in an orderly manner, such that no movement is possible.

- 8. 2 **Marking** - Each box shall be legibly and indelibly marked with the following:-

- (i) Description of goods.
- (ii) Name of manufacturer/exporter.
- (iii) Country of origin.

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The Sri Lanka Standards Institution is the owner of the registered certification mark shown below. Beneath the mark, the number of the Sri Lanka Standard relevant to the product is indicated. This mark may be used only by those who have obtained permits under the SLS certification marks scheme. The presence of this mark on or in relation to a product conveys the assurance that they have been produced to comply with the requirements of the relevant Sri Lanka Standard under a well designed system of quality control inspection and testing operated by the manufacturer and supervised by the SLSI which includes surveillance inspection of the factory, testing of both factory and market samples.

Further particulars of the terms and conditions of the permit may be obtained from the Sri Lanka Standards Institution, 17, Victoria Place, Elvitigala Mawatha, Colombo 08.



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The principal objects of the Institution as set out in the Act are to prepare standards and promote their adoption, to provide facilities for examination and testing of products, to operate a Certification Marks Scheme, to certify the quality of products meant for local consumption or exports and to promote standardization and quality control by educational, consultancy and research activity.

The Institution is financed by Government grants, and by the income from the sale of its publications and other services offered for Industry and Business Sector. Financial and administrative control is vested in a Council appointed in accordance with the provisions of the Act.

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All members of the Technical and Sectoral Committees render their services in an honorary capacity. In this process the Institution endeavours to ensure adequate representation of all view points.

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