



NOFMA STANDARDS OF MANUFACTURE  
For Solid Wood Flooring as established and revised June 10, 2001  
(Standards apply *only* at time of manufacture)

**Moisture Content-**

Flooring is manufactured at a 6% – 9% moisture content with a 5% allowance for pieces outside that range up to 12% moisture content.

**Configuration-**

**Side Match-** Flooring shall fit a NOFMA “GO, NO-GO” flooring gauge.

**End Match-** There is no standard for snugness of end match fit. Nofma has proprietary standards for the maximum and minimum dimensions of the end match tongue and groove. Also, the end match must not interfere with the side match when positioning and not encroach into the wear layer. End match squareness is considered a grade issue.

**Width-** 1 1/2", 2", and 2 1/4" strip flooring, shall fit a NOFMA flooring gauge.  
Plank flooring shall be within +/- .005" of stated size.

**Over-wood- Unfinished Flooring** NOFMA # 1 Common and Better- .020" maximum  
NOFMA # 2 Common .030" maximum

Factory Finished Flooring	NOFMA Prime-	.012" maximum
	NOFMA Standard-	.016" maximum
	NOFMA Tavern-	.020" maximum

## NOFMA STANDARDS OF MANUFACTURE For Solid Wood Flooring (continued)

Grade--

A 5% allowance in feet on the amount shipped (1000 feet, minimum shipment) is made for the occasional mistake in grading. *See-- NOFMA Official Flooring Grading Rules-- for Solid Flooring.* ([www.nofma.org](http://www.nofma.org))

End Match Squareness-- is tallied as a grading character. The following amounts are allowed and are not counted against the off grade percentage.

For 2 1/4", 2% of pieces at .031" un-square; or 5% of pieces at .016" un-square.

For 3" and wider, 2% of pieces at .01" un-square per inch of width; or 5% of pieces at .005" un-square per inch of width.

.063" maximum for un-square ends.

The manufacturer of *NOFMA certified solid flooring* is required to--

Mark all bundles/packages of standard flooring with the official NOFMA grade name and color (or species);

Place a number or logo identifying the manufacturer on the back of the product.

**NOFMA STANDARDS OF MANUFACTURE For Engineered Wood Flooring (continued)**

**Crook –**

Unfinished, Plank and Block, Bevel and Square Edge.	NOFMA Select & Better Engr.	NOFMA No.1 Common Engr.	NOFMA No. 2 Common Engr
Factory Finished, Bevel and Square Edge	NOFMA Prime	NOFMA Character	NOFMA Cabin
	Not to exceed .032" for any piece in Length		Not to exceed .062" for any piece in length

**Grade –**

A 5% allowance in feet on the amount shipped (1000 feet, minimum shipment) is made for the occasional mistake in grading. *See NOFMA Official Flooring Grading Rules for Engineered Flooring.* ([www.nofma.org](http://www.nofma.org))

**End alignment or Squareness –**

is tallied as a grading character. The following amounts are allowed and are not counted against the off grade percentage.

Unfinished, Plank and Block, Bevel and Square Edge.	NOFMA Select & Better Engr. .007"per inch of width	NOFMA No.1 Common Engr. .009" per inch of width	NOFMA No. 2 Common Engr .012" per inch of width
Factory Finished, Square Edge	NOFMA Prime .005"	NOFMA Character .007"	NOFMA Cabin .010"
Bevel Edge.	.007" per inch of width	.009" per inch of width	.012" per inch of width

The manufacturer of all *NOFMA certified engineered flooring* is required to–  
Identify the species of the face veneer on the packaging or product;  
Print a number or logo identifying the manufacturer on the back of the product.



## NOFMA Solid Flooring Inspection Standard

The standard is based on viewing NOFMA standard grade 2 1/4" T & G, blind nailed, strip flooring in a 12' x 12' room. Products of other dimensions and applications may require a modified standard.

Inspection should be from a standing position. An occasional noticeable condition or irregularity (3 or 4 conditions) may be apparent and the flooring considered acceptable. The following described conditions may occur as an occasional frequency and or the frequency described. Prominent features may require individual attention.

Overall appearance— Should present a random appearance consistent with the NOFMA specified grade.

Racking— Flooring should generally be distributed with random lengths consistent with the NOFMA specified grade, short pieces should not be clustered\*.

“H” Joints— may occur, but should be randomly distributed and not be prominent\*.

Flooring Ends— Should be abutted. (The allowance for un-square ends which produce end gaps is a grade issue and is addressed as such.) The occasional slightly un-buttend end is allowed. There should be more than 6" between ends along adjacent runs. An occasional close end is allowed\*.

A racking “Stair Step” – Should not have a uniform interval among ends for a majority of adjacent runs\*.

Closets and other hidden areas – should not be included in standard.

Handling Abuse – Only occasional marring may be present.

Open wood characters— should be filled except where specifically designated as not to be filled.

Face Nailing At Wall Lines— Starting run and no more than 9" from finishing wall line, is acceptable.

Flooring Reversals in the Field— Blind nailing is preferred; however, where face nailing is used it should not be obvious from the standing position and filled nail holes should approach the color of surrounding wood.

NOFMA solid flooring inspection standard (continued)

Flooring lines-- Runs of flooring should be generally straight (1/2" in 12').

Tapered strips-- A tapering of strips for nearly 1/2 the strip dimension which results from out of line runs along a 12' continuous wall is generally not acceptable. Out of square rooms can result in obvious tapers and should be addressed before installation.

Gaps-- Gaps which close seasonally are acceptable gaps. Occasional permanent gaps 1/64" to 3/64" are considered an acceptable condition.

Permanent Cupping-- Cupping of less than .01" is considered a minor condition and is generally noticed only with the aid of reflected glare. Cupping of .02" and greater is considered noticeable and may require some form of remedial repair.

Noises or movement-- An occasional noise or creak is considered a minor condition.

\* Exceptions-- NOFMA Shorts and NOFMA #2 Common Grades.