

WPC Residential Treated Wood Standard

Material	1" Boards	5/4 Decking 2x4, 2x6			2x8, 2x10, 2x12			4x4 / 6x6		
Species	*** All		Hem-Fir, LPP, Jack pine	Red, Southern, Ponderosa Pine	Hem-Fir, LPP, Jack pine	SPF	*Red, Southern, Ponderosa Pine	Hem-Fir, LPP, Jack pine	SPF	
Material Requirements										
MC %	All <30			All <30			All <30			
Incising	No			Yes – 5mm			Yes – 8mm			
Process Requirements										
Initial Vacuum (minimum) @ 23 in. Hg		30 min			30 min			30 min		
**Pressure 150 +	min	15 min	30 min	15 min	15 min		30 min	60 min		
	max	30 min	60 min		90 min		90 min	120 min		
Minimum Solution Concentration (%)	ACQ	1.4	1.8		1.8		1.8			
	CA	0.6	0.8		0.8		0.8			
		-OR-	-OR-		- OR -		-OR-	- OR -		
Gauge Retention (PCF)	ACQ	0.1	0.125		0.135	0.154	0.145		0.154	
	CA	0.045	0.056		0.061	0.069	0.065		0.069	

Notes:
 >Minimum times are mandatory. Once the minimum time has been achieved pressure cycle can be discontinued provided net gauge retention is achieved. If gauge retention is not achieved maximum times are mandatory.
 >Minimum solution temperature is 15° C.
 * S-Dry Red Pine – Min pressure – 15 min. Max pressure – 60 min. Minimum solution concentration ACQ - 1.4, CA - 0.6
 ** Pressure periods are based on time at 150 psi +.
 *** All species = Red, Southern, Ponderosa Pine and SPF.

