

Table 20–6. Coefficients for multiple regression models (Eq. (20–5)) for estimating time required to heat stickered ponderosa pine and Douglas-fir boards and timbers to a 133 °F (56 °C) center temperature in a 160 °F (71 °C) heating medium*

Application	Coefficients				
	$\ln a$	b	c	d	R^2
Ponderosa pine, 1- and 2-in. boards, WBD < 12 °F	5.04	1.55	0.257	0.627	0.978
Ponderosa pine, 4-, 6-, and 12-in. timbers, WBD < 12 °F	4.59	1.61	0.205	-0.521	0.967
Douglas-fir, 1- and 2-in. boards, WBD < 12 °F	8.04	1.63	0.265	-1.35	0.925
Douglas-fir, 4-, 6-, and 12-in. timbers, WBD < 12 °F	15.03	0.455	0.336	-2.70	0.984

* $T_c = (T_c - 32)/1.8$, °C = °F/1.8, 1 in. = 25.4 mm.

wet-bulb temperature in the heating chamber is greater than the target center temperature:

$$\ln T_{133} = \ln a + b (\ln t)^n + c \ln (\text{WBD}) + d \ln (T_i) \quad (20-5)$$

where

T_{133}	is	time for the center to reach 133 °F (56 °C) (min),
t		thickness of boards or cross-sectional dimension of timbers (in.),
WBD		wet-bulb depression (°F),
T_i		initial wood temperature (°F),
a, b, c, d		regression coefficients,
n		either 1 or 2.

Simpson and others (2003) developed a series of regression models to estimate heating times for ponderosa pine and Douglas-fir boards and timbers. The regression coefficients (a , b , c , and d) and coefficients of determination (R^2) are shown in Table 20–6. The models worked well when the wet-bulb depression was less than or equal to about 12 °F (6.7 °C) and the boards or timbers were stickered. The heating time estimates for a series of sizes, wet-bulb depressions, and initial temperature generated using these equations are presented in Tables 20–7 to 20–10. The estimates for ponderosa pine cover initial temperatures from 40 to 80 °F (4.4 to 26.7 °C) (in 10 °F (5.6 °C) increments). The estimates for Douglas-fir cover only initial temperature of 60 to 80 °F (15.6 to 26.7 °C) because of the seasonal timing of the experiments.

The estimated heating times in Tables 20–7 to 20–10 are average times and give a reasonable general estimate of the time required to heat the center of wood to 133 °F (56 °C). In any group of lumber and timbers, the average time does not ensure that all pieces will achieve the target temperature because some will require more than the average time. Therefore, the upper statistical confidence levels for the heating times need to be considered. Equations for calculating the upper confidence levels of heating times for ponderosa pine and Douglas-fir boards and timbers are provided

in Simpson and others (2003). In Tables 20–7 to 20–10, the heating time values of 95% upper confidence bounds are presented in parentheses.

American Lumber Standard Committee (ALSC) Enforcement Regulations

Heat treatment of wood is typically accomplished in a heat chamber. Heat chamber is defined as any enclosed equipment used to heat-treat lumber or wood packaging material and includes kiln, heat boxes, or any other appropriate apparatus. Depending on the treating schedules used, products from heat treatment processes are of two types:

1. Heat treated (HT)—lumber or used, previously assembled or repaired wood packaging that has been placed in a closed chamber with artificial heat added until the lumber or packaging achieves a minimum core temperature of 133 °F (56 °C) for a minimum of 30 min.
2. Kiln-dried heat-treated (KD HT)—lumber or used, previously assembled or repaired wood packaging that has been placed in a closed chamber with artificial heat added until the lumber or packaging achieves a minimum core temperature of 133 °F (56 °C) for a minimum of 30 min and that is dried to a maximum moisture content of 19% or less.

ALSC enforcement regulations require that a heat treatment facility should be inspected and verified by an accredited third-party agency for initial qualification. Agencies will verify the accuracy of temperature-measuring and recording devices in the heating chamber and require that thermocouples be located to accurately measure the temperature achieved in the heat chamber and that an appropriate number of thermocouples are utilized given the chamber configuration. A thermocouple verification study is needed for any kiln schedule operating in a heat chamber using (1) both dry and wet heat (steam) with wet-bulb temperature of less than 140 °F (60 °C) or (2) only dry heat of less than 160 °F (71 °C). In such a verification study, an appropriate number

Wood Handbook Chapter 20 Heat Sterilization Of Wood

Patrick Vollmar



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