




Introducing Cross Laminated Timber (CLT)

New Opportunities for Timber Construction

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Questions related to specific materials, methods, and services will be addressed at the conclusion of this presentation.



Course Description

Cross laminated timber (CLT) is an engineered wood building system designed to complement light- and heavy-timber framing options. Because of its high strength and dimensional stability, it can be used as an alternative to concrete, masonry and steel in many building types. This presentation will introduce CLT with a series of project examples that demonstrate its use and associated benefits in a range of applications. Information on manufacturing, specification and code-related considerations will also be discussed.

> Learning Objectives

1. Review completed CLT projects that demonstrate a range of applications and system configurations.
2. Discover how CLT can be used under current and future building codes and standards.
3. Discuss benefits of using CLT in place of concrete and steel, including structural versatility, prefabrication, lighter carbon footprint and reduced labor costs.
4. Discuss the fire characteristics of CLT, including the benefits of charring, current seismic approaches that can be used for CLT buildings, and how the acoustic and moisture performance of CLT assemblies can inform the design of a project.

Outline

- What is CLT?
 - Mass Timber
 - The Appeal
 - History
 - Availability
- Using CLT
 - Project Examples
 - Best applications
 - Cost effective design
 - Building Codes and Standards

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New Class of Wood Products



Mass Timber Structures

- Incorporating timber plate elements
- Including large timber elements such as solid sawn, NLT, LVL, LSL, glulam, and CLT
- A structural system resisting both vertical and lateral loads

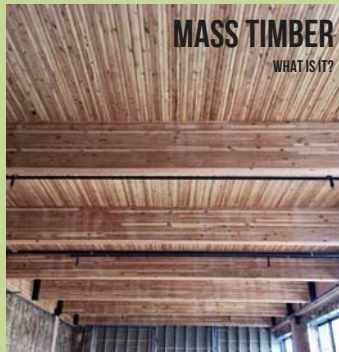
The new heavy timber movement is motivated by....

- Demand for lower impact structures
- Manufacturing Technology
- Material Technology
- Advances in Pre-fabrication
- Sophisticated Suppliers

BUILDING FRAME SYSTEMS



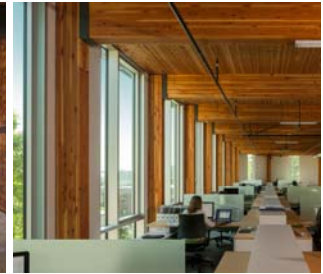
MASS TIMBER IS A CATEGORY OF FRAMING STYLES OFTEN USING SMALL WOOD MEMBERS FORMED INTO LARGE PANELIZED SOLID WOOD CONSTRUCTION INCLUDING CLT, NLT OR GLULAM PANELS FOR FLOOR, ROOF AND WALL FRAMING



MASS TIMBER
WHAT IS IT?



HEAVY TIMBER
Federal Center South, Seattle, WA
Photo: Benjamin Benschneider



MASS TIMBER
Bullitt Center, Seattle, WA
Photo: John Stamets

Glue Laminated Timber (Glulam)
Beams & columns



Cross-Laminated Timber (CLT)
Solid sawn laminations



Cross-Laminated Timber (CLT)
SCL laminations



Photo: Freres Lumber



Photo: StructureCraft



Photo: Lend Lease



Photo: LEVER Architecture

Dowel-Laminated Timber (DLT)



Photo: StructureCraft

Nail-Laminated Timber (NLT)



Photo: Think Wood

Glue-Laminated Timber (GLT)
Plank orientation



Photo: StructureCraft



Photo: StructureCraft



Photo: Ema Peter



Photo: Marasciello Architects + Epp

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Photo: JCL Co.



Photo: William Hoehn



Photo: LEVER Architecture



Photo: David Groulx and Greg
Organic Architecture



Photo: K&N Architects

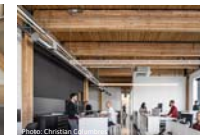
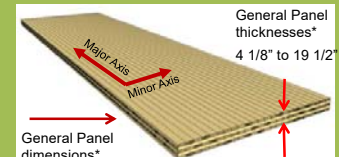


Photo: Christian G. G. Architects

MASS TIMBER PRODUCTS

CROSS-LAMINATED TIMBER (CLT)

With solid sawn laminations



General Panel
thicknesses*

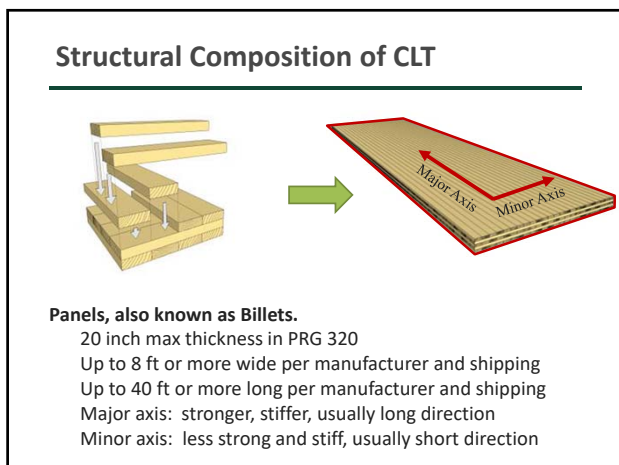
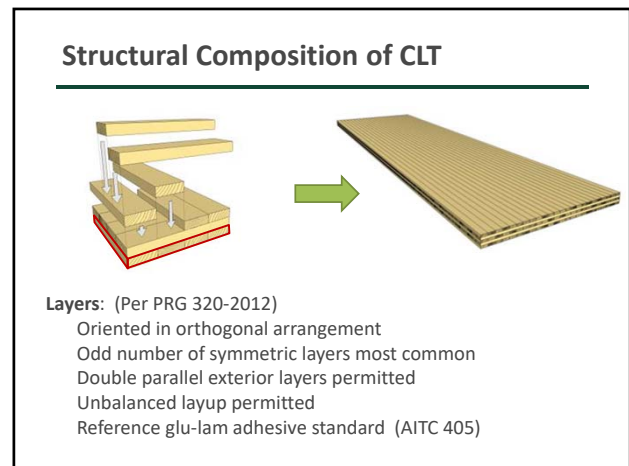
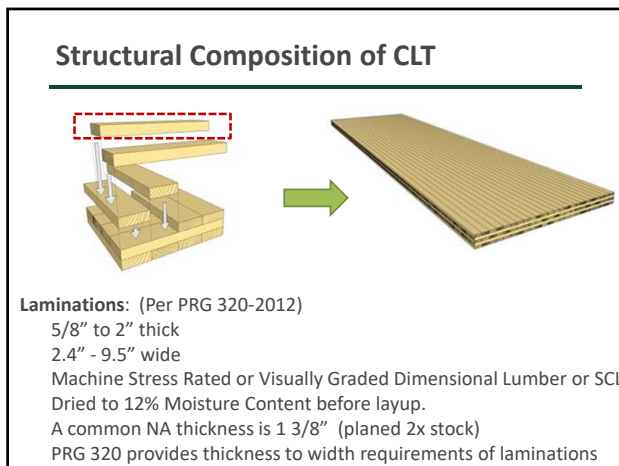
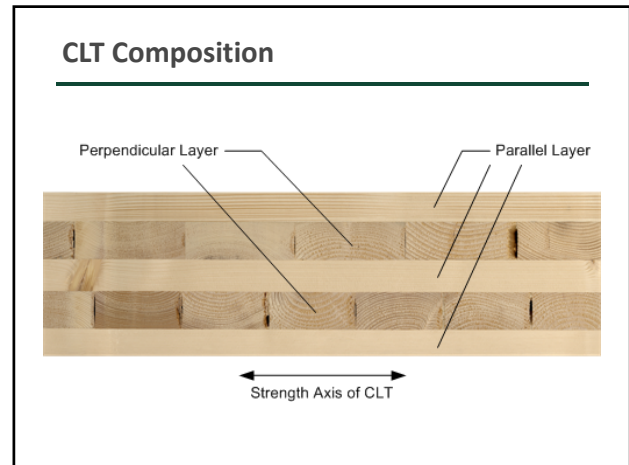
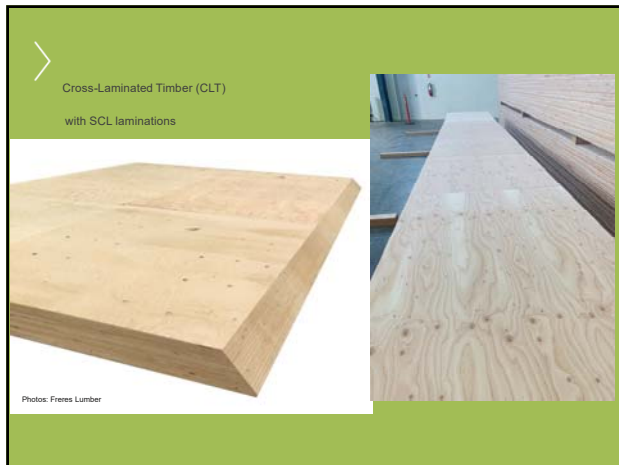
4 1/8" to 19 1/2"

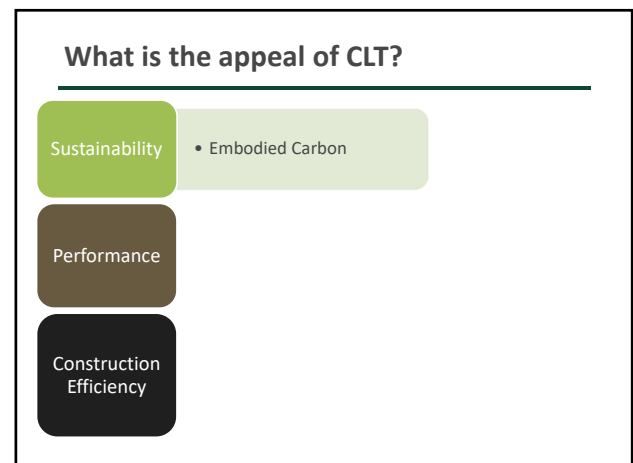
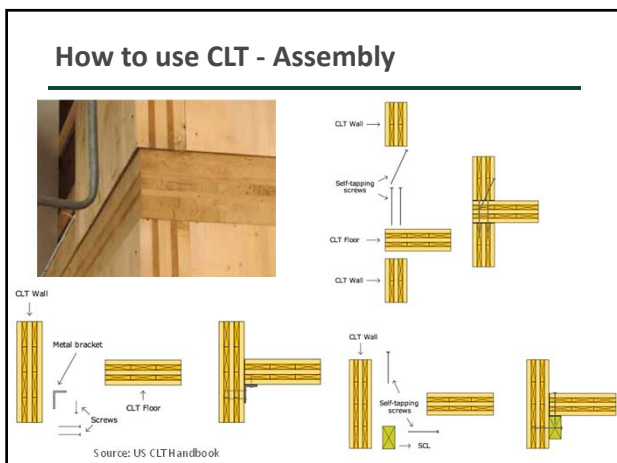
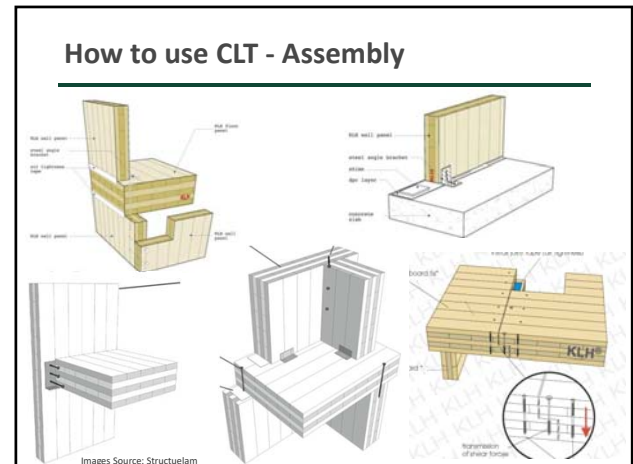
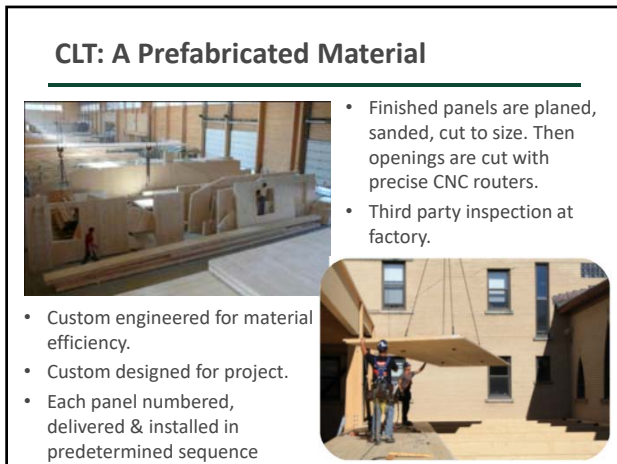
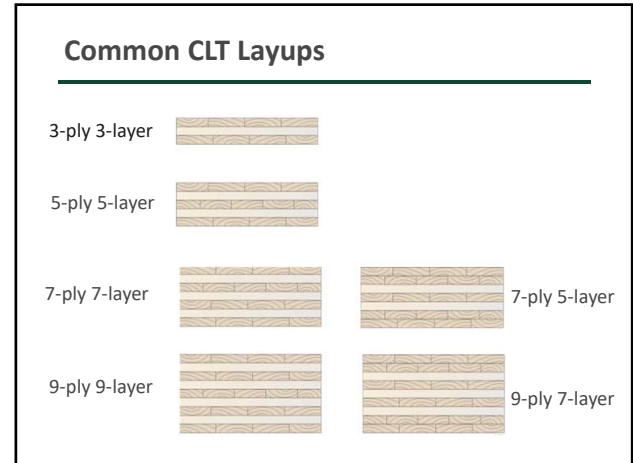
General Panel
dimensions*

4 to 12 ft wide

14 to 64 ft long

*Consult with manufacturers for
available panel sizes





> Reduced Embodied Carbon

Volume of wood used	950 m ³
Carbon sequestered and stored (CO ₂ e)	760 metric tons
Avoided greenhouse gases (CO ₂ e)	320 metric tons
Total potential carbon benefit (CO ₂ e)	1,080 metric tons

Carbon savings from the choice of wood in this one building are equivalent to:



1,615 passenger vehicles off the road for a year



Enough energy to operate a home for 803 years



Stadhaus, London, UK
Architect: Waugh Thistleton Architects
Photo credit: Waugh Thistleton Architects

What is the appeal of CLT?

Sustainability

- Reduced Embodied Carbon
- Minimal waste production

Performance

Construction Efficiency

> Minimal Waste



Why are designers drawn to CLT?

Sustainability

- Reduced Embodied Carbon
- Minimal waste production
- Highly Energy Efficient

Performance

Construction Efficiency

> Energy Efficient

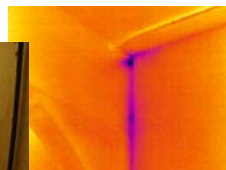


Table 2
Thermal resistance of typical softwood at various thicknesses and 12% moisture content

Thickness	1 in. (25 mm)	4 in. (100 mm)	6 in. (150 mm)	8 in. (200 mm)
R-value (h-ft ² ·°F·Btu ⁻¹)	1.25	5.00	7.50	10.00
RSI (m ² ·K·W ⁻¹)	0.22	0.88	1.30	1.80

CLT has an R-value of approximately 1.25 per inch of thickness.

Source: US CLT Handbook

What is the appeal of CLT?

Sustainability

- Reduced Embodied Carbon
- Minimal waste production
- Highly Energy Efficient

Performance

- Disaster Resilient

Construction Efficiency

> Disaster Resilient Seismic R Under Alternate Means



What is the appeal of CLT?

Sustainability

- Reduced Embodied Carbon
- Minimal waste production
- Energy Efficient

Performance

- Disaster Resilient
- Fire Resistant

Construction Efficiency

> Fire Test Results

- ASTM E119 Fire Endurance Test
- 5-Ply CLT (6-7/8" thick)
- 5/8" Type X GWB each side
- 2 hour target
- Actual 3 hours 6 minutes
- 2015 NDS Chapter 16 includes char rates for CLT to achieve up to 2 hour fire rating



What is the appeal of CLT?

Sustainability

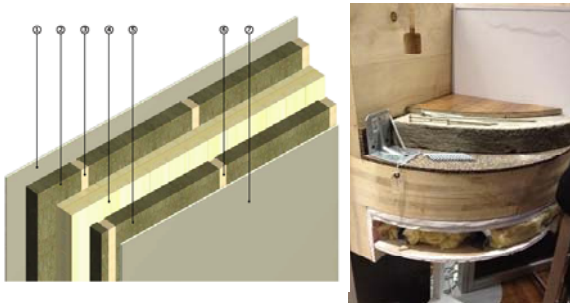
- Reduced Embodied Carbon
- Minimal waste production
- Highly Energy Efficient

Performance

- Disaster Resilient
- Good Fire Resistance
- High performing Acoustics

Construction Efficiency

> High Performing Acoustics



Why are designers drawn to CLT?

Sustainability

- Reduced Embodied Carbon
- Minimal waste production
- Highly Energy Efficient

Performance

- Disaster Resilient
- Good Fire Resistance
- High performing Acoustics
- Structural Flexibility

Construction Efficiency

Structural Flexibility



Photo Credit: APA

What is the appeal of CLT?

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- Highly Energy Efficient

Performance

- Disaster Resilient
- Good Fire Resistance
- High performing Acoustics
- Structural Flexibility

Construction Efficiency

- ~75% lighter than concrete

> 75% Lighter Weight Than Concrete



What is the appeal of CLT?

Sustainability

- Reduced Embodied Carbon
- Minimal waste production
- Highly Energy Efficient

Performance

- Disaster Resilient
- Good Fire Resistance
- High performing Acoustics
- Structural Flexibility

Construction Efficiency

- ~75% lighter than concrete
- Reduced construction time

> Reduced Construction Time



Murray Grove, London UK

- 8 stories of CLT over 1 story concrete podium
- 8 stories built in 27 days (~1/2 the time of precast concrete)



Franklin Elementary School, Franklin, WV

- 45,200 ft² 2 story elementary school
- 8 weeks to construct

What is the appeal of CLT?

Sustainability

- Reduced Embodied Carbon
- Minimal waste production
- Highly Energy Efficient

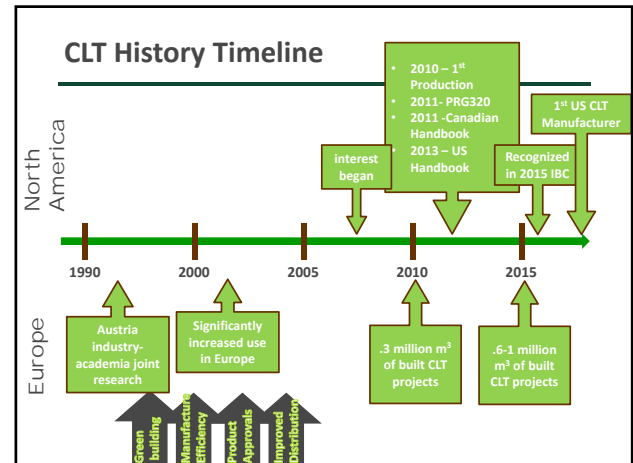
Performance

- Disaster Resilient
- Good Fire Resistance
- High performing Acoustics
- Structural Flexibility

Construction Efficiency

- ~75% lighter than concrete
- Reduced construction time
- Pre-fabricated and Precise

> Pre-fabricated and Precise



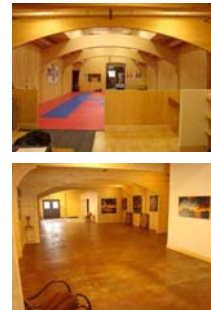
Outline

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- 1st Commercial CLT “Building” in US
- \$145/sqft completed project cost
- Structural shell complete in < 5 days
- Saved 30% in foundation costs
- Saved 6-12% over CMU

Long Hall, Whitefish, MT
Designer: Darryl Bylle, Jason Hatten



- Completed in 2013
- 1st Commercial CLT Building in US built with North American CLT
- CLT used only in the roof



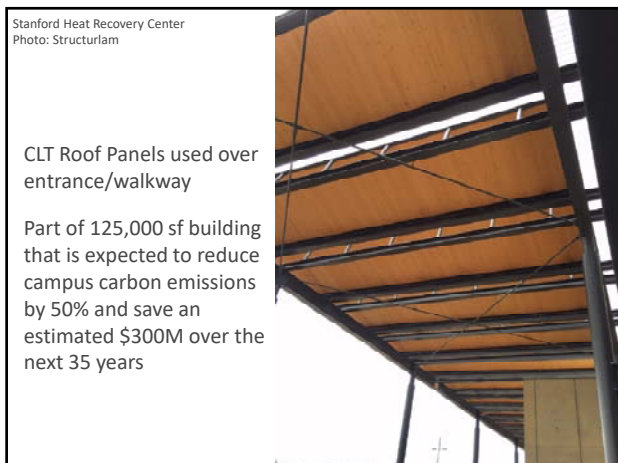
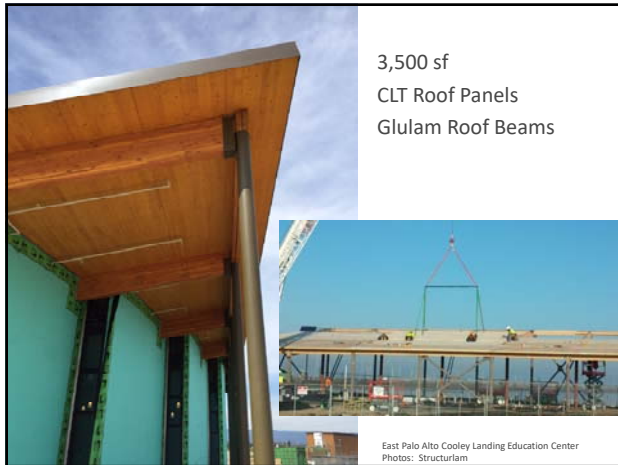
Promega GMP Facility, Fitchburg, WI
Architect: Uihlein Wilson Architects

Cooley Landing Education Center



photo: Michael O'Callaghan

East Palo Alto, CA



Chicago Horizon Pavilion Chicago, IL



Photo Credit: Tom Harris

56' square kiosk

2 Layers of 3-ply, 4-1/8" CLT roof panels in opposite directions, each panel 8' x 56', creating 2 way spanning plate



Chicago Horizon Pavilion
Photos: Tom Harris



Chicago Horizon Pavilion
Photos: Aaron Forrest

Total roof structure
thickness 8-1/4"

Spans up to 30 feet between
columns at points



Western Oregon University Richard Woodcock Education Center Monmouth, OR



Image Credit: Western Oregon University and Mahlum Architects

2 story, 57,000 sf
Offices, classrooms, and
gathering spaces

CLT utilized for floor plates
and bearing/shaft walls

1st project to utilize US
manufactured CLT



WOU Richard Woodcock
Education Center
Top Photo: Oregon Dept. of
Forestry
Bottom Image: Mahlum Architects

Project is currently under
construction, anticipated
completion fall 2016



WOU Richard Woodcock Education Center
Images: Andersen Construction & DR
Johnson



Benefits of CLT Shaft Walls:

- 23 CLT Panels used to form two stairwells
- Each Panel was 5-ply, 6-7/8" thick, 7.5' x 24'
- Each panel weighed 3,330 lbs which is about 20,000 lbs less than a concrete panel of the same size

Source: Andersen Construction

WOU Richard Woodcock Education Center
Image: DR Johnson**Oregon Zoo Elephant Lands
Portland, OR**

Photo Credit: SRG Partnership



2,000 sf visitor center

CLT utilized for roof panels

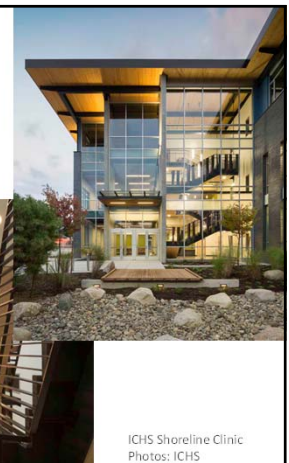
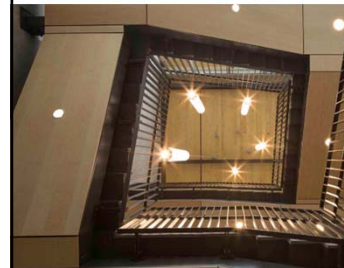
Use of CLT allowed
elimination of 20 percent of
the steel beams originally
needed to support the
standard wood
decking

1st Oregon CLT
projectOregon Zoo Elephant Lands
Top Photo: Oregon Zoo
Bottom Photo: Oregon LiveOregon Zoo Elephant Lands
Photos: SRG Partnership, Equilibrium
Engineers, Oregon Zoo**International Community Health Services
Shoreline Clinic
Shoreline, WA**

Photo Credit: Andrew Pogue Photography

45,000 sf, 3 story medical and
dental services centerCLT utilized for roof panels with
large expressed overhangs

Completed Fall 2014

ICHHS Shoreline Clinic
Photos: ICHHS



Project currently pending LEED Gold approval
Largest CLT project in State of WA at time of construction
Use of CLT roof panels resulted in schedule and labor savings, with the panels being set in a matter of days



ICHS Shoreline Clinic
Photo: ICHS



Sauter Timber Production Facility Rockwood, TN



Photo Credit: Andreas Sauter, Tim Clay Photography

9,000 sf Industrial
production facility

CLT roof and wall panels,
glulam beam & column
frame

23' tall walls



\$55/sf installed
structure cost

2015 Wood Design
Award Winner

Sauter Timber Production Facility
Photos: Andreas Sauter, Tim Clay
Photography



Sauter Timber Production Facility
Photo: Andreas Sauter, Tim Clay
Photography

Glulam Moment Frame Provides Facility's Lateral Resistance

Rocky Mountain Institute – Basalt, CO



Image Credit: Rocky Mountain Institute



Image Credit: Rocky Mountain Institute

Rocky Mountain Institute Innovation Center

- Location: Basalt, CO
- 2 stories
- 15,600 sf
- Goal- 100 year design life



Photo Credit: The Aspen Times

Energy Efficient Office Design

- High energy efficiency construction was a goal not only because it is "green" but because it just "makes sense"
- Targeting Net Zero Energy
- Cross-laminated timber used for floor structure utilizes beetle-kill lumber from British Columbia.
- Use of CLT allowed structure depth to be minimized, allowing natural daylight to penetrate further into building



Photo Credit: StructureLam

Redstone Arsenal Hotel Huntsville, AL



Image Credit: Lend Lease

62,600 sf, 4 story hotel, 92 private rooms

CLT utilized for walls, roof panels, and floor panels

1,557 CLT Panels; Typical floor panel is 8'x50' & weighs 8,000 lbs

Completed Late 2015



Redstone Arsenal Hotel
Photos: Lend Lease & Schaefer

Franklin Elementary School Franklin, WV



45,200 sf, 2 story school
CLT utilized for walls, roof panels, and floor panels

CLT chosen for its construction schedule benefits

Completed January 2015

Photo Credit: Pam Wean, MSES Architects



Photo Credit: Pam Wean, MSE Architects

Integrated Design Building University of Massachusetts, Amherst, MA



Image Credit: Leers Weinzapfel Associates

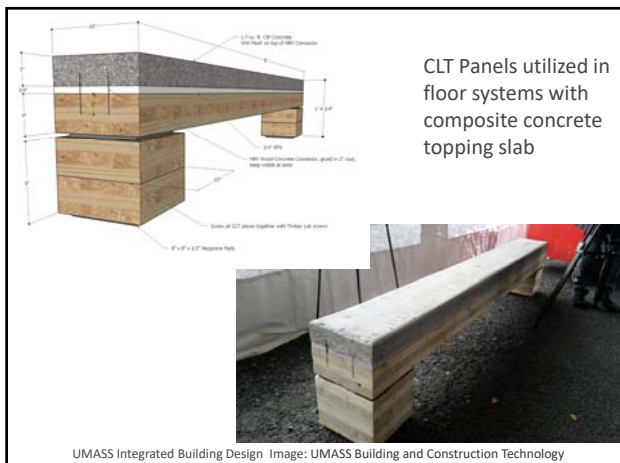
87,500 sf facility with: classrooms, lounges, meeting rooms, materials-testing lab, green-building lab, wood shop, digital fabrication lab, cafe, exhibit space, and library

UMASS Integrated Building Design
Images: Leers Weinzapfel Associates

Currently under construction, expected opening date: January 2017. Total project budget: \$52M



UMASS Integrated Building Design Image: Leers Weinzapfel Associates



UMASS Integrated Building Design Image: UMASS Building and Construction Technology

Brelsford WSU Visitor Center Pullman, WA



Photo Credit: Washington State University

4,277 sf, 1 story visitor center

CLT utilized for roof panels with large, expressed overhangs

Completed Late 2013



Brelsford WSU Visitor Center
Photos: WSU & Benjamin Benschneider

CLT Benefits: Structure Mass, Thickness & Construction Speed



4" CLT roof panels were 6 times lighter and 1/3 thinner than concrete roof panels. Installed faster as no cure time is required



Brelsford WSU Visitor Center Photos: WSU & Benjamin Benschneider

Wood Innovation Design Center

Prince George, British Columbia

8 Levels/6 Stories

97 feet tall

Completed Fall 2014

Architect: Michael Green Architecture
Structural Engineer: Equilibrium Consulting
Contractor: PCL Constructors Westcoast
Photos: Ema Peter Photography



Photo: Ema Peter Photography



- Completed in 2012
- 10 stories
- ~ 105 ft. tall, > 18.6 K sqft.
- 3 million in R&D
- Poor soils required a much lighter building

Forte, Victoria Harbor, Melbourne, Australia

Architect: Lend Lease



Forte, Victoria Harbor, Melbourne, Australia

Architect: Lend Lease

How do you minimize product costs?

1. Use the minimum thickness possible
 1. Floors are usually controlled by vibrations.
 2. Fire rating requirements can effect thickness of panel.
2. Minimize material waste
 1. Keep in mind press sizes available.
 2. Selection of splice type effects % waste.
 3. Openings can be accommodated with out cutting holes in panels.
3. Minimize factory CNC work
 1. Consider field accommodation techniques for MEP
 2. Openings can be accommodated with out cutting holes in panels.
4. Use the standard product options
 1. Species
 2. Finish
 3. Lay-up
5. Choose the right application for CLT.

CLT as an alternate to Concrete/Masonry



Model Building Code Acceptance



CLT is Defined – 2015 IBC

SECTION 202 DEFINITIONS

CROSS-LAMINATED TIMBER. A prefabricated engineered wood product consisting of at least three layers of solid-sawn lumber or structural composite lumber where the adjacent layers are cross-oriented and bonded with structural adhesive to form a solid wood element.

Add new text as follows:

2303.1.4 Structural glued cross-laminated timber. Cross-laminated timbers shall be manufactured and identified as required in ANSI/APA PRG 320-2011.

Add new standard to Chapter 35 as follows:

ANSI

ANSI/APA PRG 320-2011 Standard for Performance-Rated Cross-Laminated Timber

CLT Product Standardization

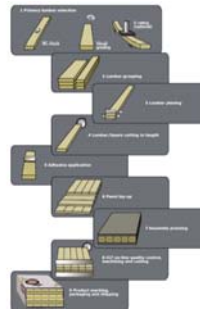


ANSI / APA PRG 320 Standard for Performance Rated Cross-Laminated Timber

Building Code -Product Standard

APA/ANSI PRG 320

- 7 stress classes
- Quality assurance testing
- Identification marking



CLT Grade	CLT Thickness (in.)	Lamination Thickness in CLT Lay-up (in.)				Major Strength Direction		Minor Strength Direction	
		1	2	3	4	F_b (ksi)	E (ksi)	F_b (ksi)	E (ksi)
E1	4 1/8	1 3/8	1 3/8	1 3/8		4,325	115	0.46	160
	6 7/8	1 3/8	1 3/8	1 3/8	1 3/8	10,400	440	0.92	1,370
	9 5/8	1 3/8	1 3/8	1 3/8	1 3/8	18,375	1,089	1.4	3,125
E2	4 1/8	1 3/8	1 3/8	1 3/8		3,825	102	0.53	165
	6 7/8	1 3/8	1 3/8	1 3/8	1 3/8	8,825	389	1.1	1,430
	9 5/8	1 3/8	1 3/8	1 3/8	1 3/8	15,600	963	1.6	3,275
E3	4 1/8	1 3/8	1 3/8	1 3/8		2,800	81	0.35	110
	6 7/8	1 3/8	1 3/8	1 3/8	1 3/8	6,400	311	0.69	858

Code Approvals - Product Reports



StructurLam CrossLam
StructurLam Products LP

PR-L314

Issued May 23, 2013

Products: StructurLam CrossLam
StructurLam Products LP
2176 Government Street
Penticton, British Columbia, CA
(250) 492-8912
www.structurLam.com



Nordic X-Lam
Nordic Engineered Wood

PR-L306

Revised May 23, 2013

Products: Nordic X-Lam
Nordic Engineered Wood
1100 Avenue des Canadiens-de-Montréal, Suite 504
Montréal, Québec, Canada H3B 2S2
(514) 871-8526
www.nordicewp.com

Product Reports

Table 1. Allowable Design Properties^(a) for Nordic X-Lam (for use in the U.S.)

CLT Grade	Major Strength Direction						Minor Strength Direction					
	F _{u0} (psi)	E _x (10 ⁶ psi)	F _{u1} (psi)	F _{u2} (psi)	F _{u3} (psi)	F _{u4} (psi)	F _{u0} (psi)	E _y (10 ⁶ psi)	F _{u1} (psi)	F _{u2} (psi)	F _{u3} (psi)	F _{u4} (psi)
E1	1,950	1.7	1,375	1,800	135	45	500	1.2	250	500	135	45

For S1: 1 psi = 0.006895 MPa

^(a) Tabulated values are allowable design values and not permitted to be increased for the lumber size adjustment factor in accordance with the NDS. The design values shall be used in conjunction with the section properties provided by the CLT manufacturer based on the actual layout used in manufacturing the CLT panel (see Table 2).

Table 2. The Allowable Bending Capacities^(a) for Nordic X-Lam Listed in Table 1 (for use in the U.S.)

CLT Grade ^(b)	Lam. # ^(c)	Thick-ness (in.)	Lamination Thickness (in.) in CLT Lam.						Major Strength Direction						Minor Strength Direction					
			1	2	3	4	5	6	F _{u0} (psi)	E _x (10 ⁶ psi)	F _{u1} (psi)	F _{u2} (psi)	F _{u3} (psi)	F _{u4} (psi)	F _{u0} (psi)	E _y (10 ⁶ psi)	F _{u1} (psi)	F _{u2} (psi)	F _{u3} (psi)	F _{u4} (psi)
E1	19-3s	3.18	1.104	1.110	1.104				2,325	48	0.34	1,070	90	1.4	0.47	380				
	105-5s	4.18	1.35	1.35	1.35				4,525	115	0.45	1,430	180	3.1	0.61	495				
	135-5s	5.18	1.164	1.110	1.164	1.110	1.164		5,500	184	0.60	1,470	795	35	0.64	1,330				
	175-5s	6.18	1.35	1.35	1.35	1.35	1.35		15,400	440	0.62	1,870	1,370	81	1.2	1,430				
	220-7s	8.14	1.35	1.110	1.35	1.110	1.35	1.110	15,875	823	1.4	2,400	2,190	194	1.5	1,580				
	240-7s	9.18	1.35	1.35	1.35	1.35	1.35		23,700	1,404	2.0	3,230	1,370	81	1.9	1,430				
	314-8s	12.38	1.502	1.35	1.35	1.35	1.35	1.35	31,700	2,764	2.4	3,075	3,120	309	2.5	1,580				

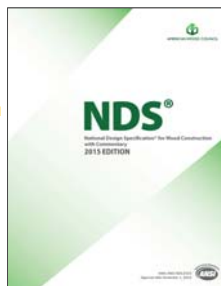
For S1: 1 in. = 25.4 mm; 1 lb = 304.8 mm; 1 lb ft = 4.448 N

^(a) Tabulated values are allowable design values and not permitted to be increased for the lumber size adjustment factor in accordance with the NDS.

^(b) The CLT grades are developed based on ANSI/APA PRG 320, as permitted by the standard.

^(c) The layout designation refers to the panel thickness (in mm), the number of layers, and the layout combination ("Y" for standard perpendicular layers, and "T" for standard alternating parallel layers).

Structural Design Standardization



National Design Specification for Wood Construction
2015 Edition

CLT in NDS 2015

New **Chapter 10** in 2015 NDS covering Adjustment Factors for CLT
Formatting Similar to Wood Structural Panels

Table 10.3.1 Applicability of Adjustment Factors for Cross-Laminated Timber

	ASD only	ASD and LRFD	LRFD only
Load Duration Factor			
Wet Service Factor			
Temperature Factor			
Repetitive Member Factor			
Beam Stability Factor			
Column Stability Factor			
Roofing Area Factor			
Partial Composite Factor			
Resistance Factor			
Size Effect Factor			
$F_u(S_u) = F_u(S_u)$	N	C _u C _u C _u C _u	2.54 0.85 λ
$F_u(A_{perp}) = F_u(A_{perp})$	N	C _u C _u C _u C _u	2.70 0.80 λ
$F_u(I_u) = F_u(I_u)$	N	C _u C _u C _u C _u	2.88 0.75 λ
$F_u(I_b Q_{u1}) = F_u(I_b Q_{u1})$	N	C _u C _u C _u C _u	2.88 0.75 λ
$F_u(A_{perp}) = F_u(A_{perp})$	N	C _u C _u C _u C _u	2.40 0.90 λ
$F_u(A) = F_u(A)$	N	C _u C _u C _u C _u	1.67 0.90 λ
$(E)_{app} = (E)_{app}$	N	C _u C _u C _u C _u	- - -
$(E)_{app} = (E)_{app}$	N	C _u C _u C _u C _u	1.76 0.85 -

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Questions?

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