Information

Product information September 2011

REHOLZ® 3D-veneer

1. Product	product name:		3D-veneer (three-dimensional deformable veneer)
	color:		natural wood colors or dyed veneer, depending on wood species and dyes
	material:		mechanically treated veneer natural veneer texture and structure back supported by glue threads
	thickness:		1,15 mm ± 0,05 mm
	size:	length:	max. 1300 (2100) mm
		width:	max. 980 mm
			(wider veneer dimensions have to be spliced)
2. Wood species for 3D veneer	face veneer		• rotary cut veneer Beech • sliced veneer Beech, Am. Walnut, Euro Walnut, Am. White Oak, Euro Oak, Black Cherry, Euro Cherry, and others • Vinterio veneer • reconstituted veneer (e.g. Alpilignum)
	core		• rotary cut veneer Beech • rotary cut veneer Ilomba/Kapokier • others
3. Application	• for manufacturing of three dimensional formed plywood mouldings for indoor use e.g. chair shells, back rests, front elements for furniture, accessories, mouldings for automotive industry and others • moulding thickness (1,5)...5,5…(20) mm • for veneering of core stock (e.g. MDF, plastic, metal and others) e.g. housings for medical devices and more		
4. Processing	with all common wood working processes, e.g.: • sawing • milling • sanding • drilling		
5. Disclaimer	The provided information is based on today's technology. It is recommended that customers test our products to determine if they are suitabel for their manufacturing processes. The processing of our veneer products is beyond our control and Danzer Group/Reholz assume no responsibility. Yet, we ensure the quality of our products, based on our general terms of sales and delivery. Wood is a natural product and variations in structure and color are possible and should be expected.		

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Recommendations for processing September 2011

REHOLZ® 3D-veneer

1. General information		veneer should be stored indoors, handle carefully
2. Tools for plywood manufacturing		• for prototypes: pressing tool made from plywood for cold pressing (consists of 2 or 3 parts -> swage, stamp and if required a forming ring) - depending on the product geometry also a vacuum bag may be used • for serial production: pressing tool made of aluminum for hot pressing (consists of 2 or 3 parts -> swage, stamp and if required a forming ring)
3. Tools for veneering		• vacuum bag or membrane press, if required with special forming ring • special pressing tool analog to plywood manufacturing (please refer to point 2)
4. Glue for plywood manufacturing		conventional UF glues, hot or cold pressing
examples for	hot process example A:	• Kaurit 390 powder + hardener 70 + extender Bonit
	hot process example B:	• Kaurit 234 (100 T) + hardener 70 oder 500 (10 T) + extender Bonit
	cold process	• Kaurit 234 (100 T) + hardener 30 (10 T) + extender Bonit (20T)
5. Glue for veneering		
core stock wood		• conventional UF glues (hot or cold pressing), PVAc-glue
core stock plastic or metal		• special glues, if required in combination with a special primer
6. Processing		• do not moisten or apply glue to surface layers • apply glue both-sided to every even numbered veneer layer • all core layers: always have glue threaded backs face towards center of workpart • glue amount: approx. 130 g/m² • open time: respect open time, normally 10 - 15 min., depending on room temperature and humidity • press temperature: approx. 100°C • press time: according to the recommondations of the glue manufacturer • specific pressure: approx. 2,0 MPa (important for subsequent mechanical processing) • processing of the 3D-veneer with a wood moisture of approx. u = 8%
7. Mechanical treatment of 3D-plywood mouldings		• especially important for thin moulded parts: support of the moulded parts without any vibration best by full surface vacuum • we recommend the use of an end mill cutter in a 90° angle to the moulded part's edge of the surface