

## Technical data

### **Product Name:**

Alpilignum is a decorative multilaminar veneer, in compliance with standard UNI 10396 requirements.

The average weight composition of the veneer is as follows:

poplar wood	and/or	
ayous wood	and/or	
kotò wood	and/or	
lime wood		70÷80%
resins		16÷26%
dyes		<1%
moisture content		4÷14%

Being a wood product, Alpilignum may have a different moisture content depending on environmental conditions during transport and storage.

### **Technical features**

#### **Alpilignum**

**Supplied dimension:** Decided trough trade agreements

#### **Dimensional tolerances:**

- Length and width: decided through trade agreements
- Thickness: in compliance with standard ISO DIS 18775

**Wood density:** 450÷900 kg/m<sup>3</sup> (measured in compliance with standard ISO 9427)

**Formaldehyde emission:** Upon request and for specific product lines, formaldehyde emission in compliance with E1 (analysed according to EN 717)

**Lightfastness:** Alpilignum is not a finished product and, therefore, its resistance to light depends on the cycle and chemical nature of the finish. The buyer is advised that discolouring may occur. It is recommended that the buyer performs preventive tests according to the particular purpose and intended use, in order to optimise results.

**Mechanic aspect:** The mechanical characteristics of the Alpilignum depend on the cycle and chemical nature of the finish and the type of support. It is recommended that the

buyer performs preventive tests according to the particular purpose and intended use, in order to optimise results.

**Colour and structure:**

Being a natural wood product, Alpilignum may vary with respect to its reference colour. It is recommended that the buyer checks before use both the colour and the grains of the product delivered as against the ordered product.

**Storage**

Alpilignum is mainly constituted by wood and, therefore, its moisture content may be subject to variations depending on the storage and work environment.

It is therefore advisable to keep humidity range between 40% and 70% (Ru) and a reference ambient temperature of 20°C.

Avoid - even temporary- contact with water and other liquids.

Avoid any moisture on product surface.

The product must be stored on a flat surface at least 200 mm from the floor.

Alpilignum must be shielded from direct and indirect light.

**Recommendations for use****Veneering**Gluing with urea glues

Alpilignum can be glued on all wood supports by means of urea glues. Different kinds of supports need to be tested and assessed on a case-by-case basis.

The quantity of glue to be used per square metre depends on the base type and thickness, on the veneer structure (quartered cut, tangential cut, burl, etc.), on its thickness and on the type of pressing.

It is generally advisable not to use more than 150 g/m<sup>2</sup> of glue at pressures ranging from 1.5 to 5 bars.

The advisable veneering temperature can range between 85°C and 120°C.

The glue can be blended with organic or inorganic excipients to modify its reologic properties in order to control its bleeding through the veneer layer.

The use of pigments with similar shades to the veneer base colour is always recommended.

Gluing with vinyl glues

Alpilignum veneer can be glued on all wood supports by means of vinyl glues. Different kinds of supports need to be tested and assessed on a case-by-case basis.

Because of the thermoplastic features of this type of glue, the quantity to be applied must be carefully measured according to the type of veneering, the base and the

press, in order to avoid undesirable passing through, which would be difficult to eliminate during sanding.

It is generally advisable to use between 80 and 100g/m<sup>2</sup> of glue, at pressures ranging from 1.5 to 3.5 bars.

The advisable veneering temperature can range between 60°C and 90°C.

### Gluing with hot melt glues

Alpilignum veneer can be glued on all wood supports by means of hot melt glues such as polyolefin, EVA and reactive polyurethane. Different kinds of supports need to be tested and assessed on a case-by-case basis. This type of gluing is mainly used to glue small surfaces, such as edges, with the help of automatic systems with mechanical clamp.

The use of other veneering systems must be checked through preliminary testing. In every case, however, it is advisable to follow the instructions provided by the glue supplier.

### **Varnishing**

Like all other types of wood, varnishing process of Alpilignum must be done with a suitable product, capable of protecting and preserving the wood as much as possible from chemical and physical deterioration (photodegradation, thermal decay, etc.) as well as from mechanical degradation (scraping, crashes, etc.).

Multilaminar wood can be stained without any particular problems, and it is advisable to do it.

Alpilignum can be varnished with any product or method recommended for wood treatments. However, the best results are achieved by selecting, among the different classes of products, those having the following characteristics:

- High wetting power
- Good properties retention yellowing
- High UV protection

As for water paints, it is advisable to use products, which are stable at a moderately acid pH (4-6), such as some specific products designed for acid hardwood.

It is always good practice to follow strictly the instructions provided by paint producers and to carry out preventive tests before proceeding to varnishing.

Please, contact Alpi's technical office for any further clarifications.

This technical data sheet supersedes and replaces any previous edition.

The information and recommendations herein have been compiled from the current information owned by Alpi and may be susceptible to changes if new knowledge or new production systems are available. Users are advised to make their own determination as to the suitability of this product in relation to their particular purpose and intended use.