

## DATA SHEET

### MULTILAMINAR | RECONSTITUTED VENEER DATA SHEET

**PRODUCT NAME** Busnelli International Multilaminar | reconstituted veneer

**PRODUCT CATEGORY** Multilaminar veneer of real natural wood from ayous, poplar and other species, stained with acid-based dyed in water solution and reconstituted using ureic resins conforming to current international regulations, according to standard ISO 18775.

**COMPOSITION** The average ponderal composition of Busnelli International multilaminar veneer is as follows:

- Wood [slices of natural wood poplar and/or ayous and/or linden wood]: 75 ÷ 80%
- Resins [ureic resins with low formaldehyde content]: 12 ÷ 15%
- Dyes [acid-based dyes in water solution]: 1%
- Moisture content (on delivery): 8 +/- 4% \*

\* During the stages of transportation and storage of the product the moisture content may undergo changes due to the specific environmental conditions.

**STANDARD MEASUREMENTS OF SUPPLY** Multilaminar veneer sheets are supplied with the following standard measurements: \*\*

- Length: 220-250-280-310-340 cm
- Width: 60-66 cm
- Thickness: 0,5 ÷ 2,5 mm

**NOMINAL INTERVALS BETWEEN THICKNESS** Up to 1.5 mm (included): nominal interval 0.05 mm  
over 1.5 mm: nominal interval 0.10 mm

\*\* It is also possible to request consignments in customised sizes based on the specific purposes of use.

**FORMALDEHYDE EMISSIONS** The formaldehyde emissions of Busnelli International multilaminar veneer conform to current Class E1 'low emission' regulations (analyses according to EN 717).

**LIGHT RESISTANCE** As it is not a finished product the light resistance of multilaminar veneer varies according to the cycle and chemical type of the finish. Colour variation over time, therefore, cannot be considered a defect of the material.  
We recommend carrying out preliminar tests based on the required use and the finish to be applied, in order to optimise the performance and characteristics of the product.

**COLOUR AND STRUCTURE** Being a product based on natural wood, the colour of multilaminar veneer may vary; we recommend, therefore, checking the colour and pattern of the material delivered before proceeding to finish and use the product.

## **STORAGE INSTRUCTIONS**

As multilaminar veneer is composed mainly of natural wood its moisture content may vary in relation to the environment in which it is stored and worked; we recommend, therefore, maintaining in the areas reserved for storing and working the veneer a humidity rate of between 50% and 80% (Ur) at a reference temperature of 20-22° C. Avoid all contact, even temporary, with water or other liquids, condensation and dripping onto the surface of the product.

The product should be stored flat at a height of at least 200-250mm from the floor and the veneer must be protected from all light, both direct and indirect.

## **VENEERING**

Multilaminar veneer can be glued onto all wood-based supports with ureic or vinyl glues. For gluing onto supports in different materials we recommend first carrying out tests to check for any technical problems and assess the performance of the finished product.

## **GLUING WITH UREIC GLUES**

When using ureic glues it is generally advisable to avoid applying more than 150 g/m<sup>2</sup>, at pressures varying from 1.5 bar to 3 bar and veneering temperatures between 80° C and 125° C. Additives may be added to the glue in order to adjust its rheological properties and avoid undesirable seepage. We also suggest pigmenting the glue with shades similar to the veneer colour.

## **GLUING WITH VINYL GLUES**

Due to the thermoplastic characteristics of this type of glue, the amount to be applied must be accurately regulated according to the veneer, the support and the kind of press used, in order to avoid unpleasant seepage that is difficult to remove during the sanding operation. Generally speaking, the quantity of vinyl glue used should be between 80 g/m<sup>2</sup> and 110 g/m<sup>2</sup>, at pressures varying from 1.5 bar to 3.5 bar and veneering temperatures between 60°C and 80° C.

## **SANDING**

To remove from the product any traces of manipulation and/or glue left over from the gluing operation, the veneer should be sanded with grade 100/150/180 sandpaper, used singly or in succession on manual or automatic sanders.

Sanding carried out at right-angles to the grain, if done forcefully, may leave on the material visible micro scratches or tears; it is necessary therefore, to perform tests beforehand in order to assess the result and decide which specific sanding techniques to adopt.

## **VARNISHING**

Multilaminar veneer may be varnished using the methods and classes of products recommended for varnishing natural wood, which are designed to preserve the material from phenomena of chemical/physical (photodegradation, thermal degradation) and mechanical (scrapes, blows, etc.) deterioration. It is advisable, in any case, to follow carefully the specific instructions provided by the varnish manufacturer, and to carry out tests before subjecting the multilaminar veneer to varnishing processes.

The information, instructions for use and suggestions contained herein are based on the current knowledge of Busnelli International and refer to the most common manufacturing uses and techniques, users are responsible, therefore, for checking that the product is suitable for their specific requirements and their manufacturing system.