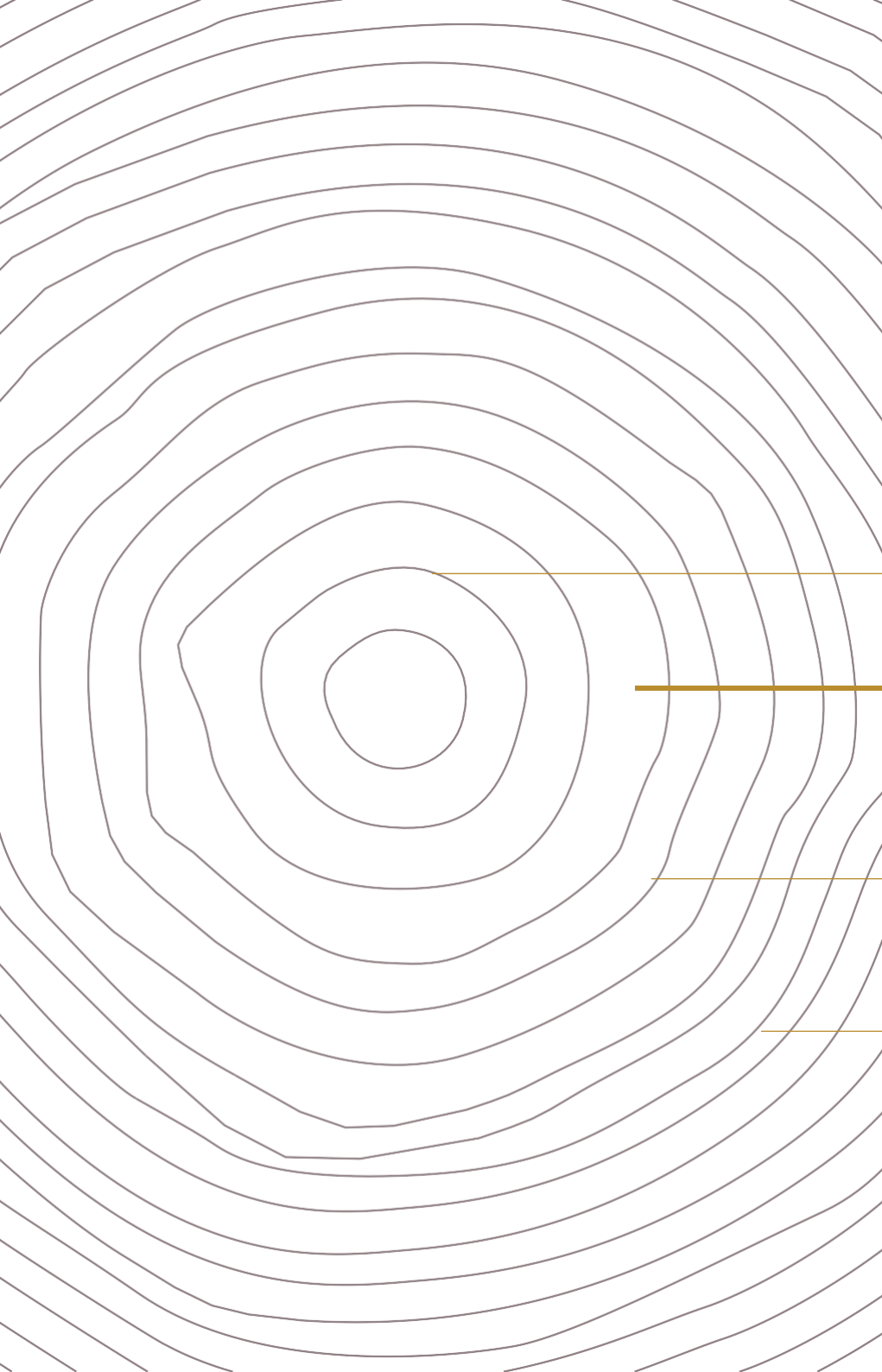


TRANCIATI

LEGNO PRECOMPOSTO
ENGINEERED
WOOD VENEER



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CORÀ RAPPRESENTA IL PIÙ
GRANDE GRUPPO ITALIANO
NELLA PRODUZIONE,
IMPORTAZIONE E DISTRIBUZIONE
DI PRODOTTI IN LEGNO.

Corà is the largest group of
companies in Italy manufacturing,
importing and distributing wood.

www.coralegnami.it

The Company

Corà has been a key player in the wood market both in Italy and internationally since 1919.

Due to its continuous development, today multinational Corà Group is the largest business entity in Italy involved in the production, import and distribution of wood products that have been manufactured industrially from raw materials. Thanks to its experience, its advanced technological and organisational structure, and its extensive distribution network, Corà is synonymous with development and renewal and has attained its position as a leading company in Italy and abroad throughout its generations.

Corà's Veneer Division provides its clients with a strong commercial and logistical structure based on a 1 million-square-metre warehouse filled with more than 60 designs of engineered wood veneer that have been carefully selected.

TRANCIATO PRECOMPOSTO

Engineered Wood Veneer

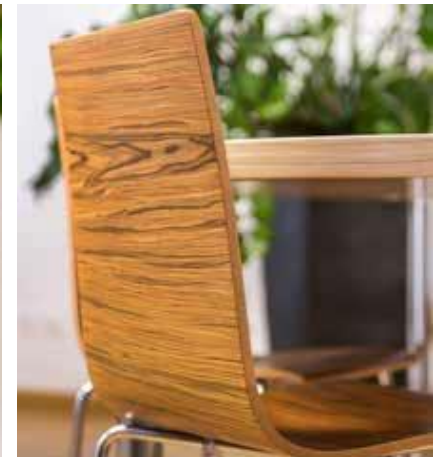
Although in English, it is commonly referred to as Engineered Veneer, in Italian we call it Multilaminate or Recomposed Veneer, though to experts in the field it is known as Reconstituted Veneer.

It is an innovative type of wood veneer obtained by means of a sophisticated manufacturing technology that makes it possible for decorative or surface veneer to provide:

- consistent colour and grain over time;
- a use for wood waste material by all end-users from small craftsmen up to wide-scale industrial manufacturers.

Ethical/environmental issues are just as important for us: with the development of reconstituted wood technology, it is now possible to produce industrialized veneers that have a similar colour and grain to natural veneers, thus enabling us to leave our natural reserves of rare and protected wood species intact.

All finished and semi-finished products created with Corà Prex can be marked as real wood products.

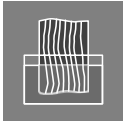


Manufacturing Process



Trunk Rotary Peeling

The process begins with peeling a log (of Ayous, Poplar or other species) in order to obtain thin and homogeneous veneer sheets. This is made possible by selecting prime growing areas for harvesting.



Dyeing

The sheets are then immersed in dye vats in an effort to obtain the desired colours using organic, non-metallic dyes in an aqueous solution.



Drying

The dyed veneer sheets are dried in dryers so as to attain a moisture level that is suitable for further processing.



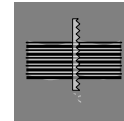
Multilaminar Trunk composition

The dyed veneer sheets are assembled and bonded together into a block according to a formula that simulates natural wood grains or to make pre-designed exotic patterns.



Pressing

The block is then pressed in special moulds to obtain plain-, quarter- or rift-cut grains or other special designs.



Squaring

The sides of the recomposed block are then squared so as to obtain a rectangular-shape. As the conical shape of the original log is converted into a regular square-edged one, any scraps and wastage produced during processing are minimized.



Veneering

Corà Prex is obtained by slicing the recomposed block into a variety of thicknesses.



Testing

A quality control team subjects all the veneer sheets to a light test and removes any defective pieces.

Characteristics

COMPOSITION

Generally speaking, Corà Prex consists of:

Wood (Ayous, Poplar or other): 90-92%

Resin/glue: 8%

Dye: max 2%

Moisture content: 8/12%. The moisture content may change during transportation and warehousing due to varying environmental conditions.

TECHNICAL SPECIFICATIONS

The most frequently used wood species is Ayous, which is found in the tropical forests of Africa where logs are harvested in compliance with current laws. Poplar, a plantation species, is also widely used and can, upon request, be sourced from FSC certified forests.

Since Corà Prex is real wood, there may be slight colour variations between production batches, but this should not be considered a defect.

AVAILABLE FORMATS

Length: minimum 2150 mm to maximum 3400 mm; Width: minimum 630 mm to maximum 1000 mm; Thickness: from 0.4 to 3.0 mm.

Measurement tolerances: Length: +/-10 mm, Width: +/-10 mm, Thickness: +/-0.05 mm

LIGHT RESISTANCE

Corà Prex may change colour if it is subjected to prolonged exposure to direct sunlight or artificial light. A variation in wood colour over time should not therefore be considered a defect. The reference standard is UNI EN 15187, using a Xenon light source for a period of exposure lasting approximately 20 hours. The results are displayed as a "greyscale".



GLUING TIPS

The glue-spreading rate per square meter depends on the type and thickness of the substrate, the structure of the veneer (side-cut or top-cut), the thickness of the veneer and the way it is pressed.

Normally, we suggest using 100g/120g of adhesive per m², at a pressure ranging from 2.5 to 5 bars. The temperature may range between 90 and 120°C. After pressing, the substrate must be cooled immediately to avoid surface charring or colour change. It is possible to add organic or inorganic additives (hardener/catalyser) to the adhesive as a way to prevent glue from bleeding through the veneer pores. We suggest using an adhesive with a colour that is similar to that of the veneer.

BONDING WITH VINYL ADHESIVE: TIPS

Corà Prex may be bonded to any wood fibre substrate using vinyl adhesives. Different substrates should be checked and evaluated each time before use. Due to the thermo-plastic characteristics of this type of adhesive and in order to prevent glue from bleeding through the veneer pores, the glue-spreading rate should be carefully formulated according to the veneer, substrate and pressure used. We normally suggest using from 80g/m² to 100g/m² of adhesive at a pressure of 2.5-3.5 bars. The bonding temperature may range from 60 to 90°C.

THERMAL BONDING: TIPS

Corà Prex may also be bonded with adhesives such as polyolefin, EVA and polyurethane at a temperature.

Note: Any other bonding methods should be carefully examined during preliminary tests. In any case, we recommend following the instructions supplied by adhesive manufacturers.

POLISHING TIPS

To obtain optimal panel flatness, we recommend sanding it first with 100-grit sandpaper and then with 150-grit. The roughness of the paper used during the last sanding stages should be selected on the basis of the varnish that will be applied to the finished panel. For example, with a water based varnish, the use of 120/220-grit sandpaper is recommended.

VARNISHING

Acrylic – solvent-based varnishes

Lightfastness: High

Resistance to cold liquids and surface hardness: Excellent

Note: Recommended for an "open pore" effect in Oak and Ash designs as well as for light-coloured designs such as Birch, Maple, etc.

Polyurethane – solvent-based varnishes

Lightfastness: Not very high, requires UV filters and specific catalysers.

Resistance to cold liquids and surface hardness: Good

Note: Excellent price-to-performance ratio.

“Bi-component” water-based varnishes

Lightfastness: Good

Resistance to cold liquids and surface hardness: Excellent

Note: Good concealing and insulating ability, recommended for Oak or Chestnut designs.

“Single component” water-based varnishes

Lightfastness: Good

Resistance to cold liquids and surface hardness: Excellent

Note: Good concealing ability and exceptional transparency.

UV – cured varnishes (for mass production)

Resistance to cold liquids and surface hardness: Excellent

Note: These products may be used only in installations that are especially designed to allow polymerisation. They are generally used in mass productions.

Note: Each varnishing method should be carefully tested in cooperation with the varnish manufacturer.

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