



BauBuche Panel
Thicknesses 20, 25, 30, 35,
40, 45, 50, 55, 60 mm
Widths 120 – 680 mm
Lengths up to 18 m

GENERAL

BauBuche Panel behaves in a similar way to solid wood boards. After transport it is necessary to ensure that the material can adjust slowly to the workshop climate. This means that, after cutting to size, stickers (spacing sticks) should be placed between the individual boards.

Longitudinal edges, particularly if the length is greater than 2.0 m, are often not exactly parallel with the laminations, so even after careful cutting (or parallel cutting) the glued joints become visible. If necessary, a solid wooden edge (e.g. made of Pollmeier beech sawn timber) can be glued on. If this is done with an automatic edging machine, it must be ensured that the glued surfaces of the edges have not been planed, but have a sanding pattern with a grit size of 40 or 60. The edges should be treated with an adhesive primer (e.g. Dorus ND 183/1). Even better results will be achieved through the use of a PVAC glue (D3 or D4).



SURFACE TREATMENT

All drilling, cutting and edge finishing should be completed before the surface treatment.

- _ Sand on a cylinder sanding machine (grit size 80/100) for the first pass.
- _ Depending on the cutting quality of the abrasive, set the machine to "Calibrate".
- _ Sand with 120/150 grit in the sanding machine, using a sprung table or compressed air sanding shoe, depending on the type of machine.
- _ Then thoroughly blow-clean the surfaces with compressed air to remove dust and loose fragments.
- _ Level out any voids that have occurred with filler (solvent mixed with sanding dust, e.g. Pallmann Fugenkitt-Lösung (joint filler solution) No. 39948).
- _ Using precisely working sanding machines, the surface can be machine-sanded (grit size 150/180) after filling.

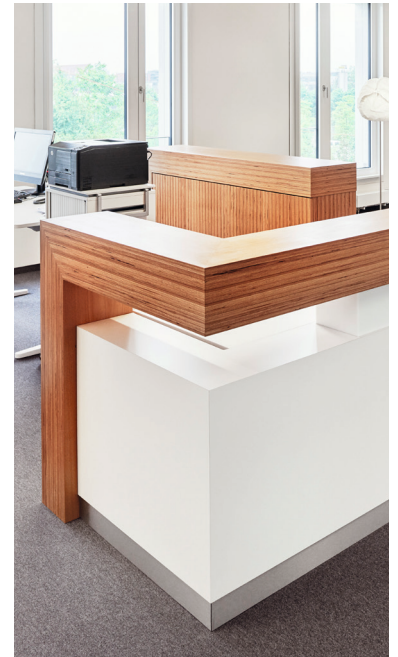
VARNISH APPLICATION

The surfaces in the pictures were treated with PUR Lignal Varnish 433, gloss level 2.

- _ Priming: Applied quantity approx. 200 g/m², sprayed crosswise and lengthwise. The subsequent intermediate sanding is ideally done after drying overnight in a temperature-controlled drying room.
- _ Sand in sanding machine using varnish sandpaper, grit size 220, or with orbital sanders.
- _ 2nd varnish coat at least 170–190 g/m².
- _ The edges have to be varnished several times in order to avoid varnish runs.
- _ After an adequate drying time of at least 1.5 to 2 days at a constant temperature of between 18°C and 20°C, the boards can be stacked with wide intermediate supports. If these supports are too narrow or too hard, they will cause pressure points, due to the weight of the boards.

Kitchen worktop and office shelving
Carpentry Gerhard Freis, Lieser

In general, the technical guidelines for processing solid wood and solid wood boards apply to BauBuche Panel. Fine joints between the veneers are a characteristic feature on the material originating from the production process. They can remain visible even after varnishing. The surface treatment lies in the responsibility of the contractor. We recommend to agree upon the surface quality with the client on the basis of samples.



SURFACE TREATMENT

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The surface shown on the pictures was processed as follows:

- _ Cut to size on horizontal panel saw
- _ Gluing of edge veneer using an edge banding machine with integrated edge grinder
- _ Carcass connections, drilling and milling for the fittings
- _ Plugging of flaws using wood filler, colour tone walnut
- _ Surface grinding with wide belt sanding machine, grain 150
- _ Controlling and plugging of flaws if necessary
- _ Surface grinding with wide belt sanding machine, grain 150

HARD WAX OIL APPLICATION

The surface shown on the pictures was treated with a hard wax oil from company Osmo:

- _ 1st application of hard wax oil
- _ Wiping off excess oil with cloth
- _ Drying time
- _ Intermediate grinding, grain 240
- _ 2nd application of hard wax oil
- _ Wiping off excess oil with cloth
- _ Drying time
- _ Bonding and final assembly at carcass line

Office furniture

Friedrich Ziegler GmbH, Offenberg

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