

ALPIlignum /

ALPIlignum is a decorative multilaminar wood veneer that complies with standard ISO 18775.

Average Weight Composition /

Poplar wood and/or Ayous wood, and/or Basswood	70-80%
Resins	16-26%
Dyes	< 1%
Moisture content	min 4% - max 14%

Being a wood product, ALPIlignum's moisture content may vary depending on environmental conditions during transport and storage.

Possible Dimensions /

Ayous Veneer	length 2000-2200-2300-2500-2600 mm width 620-680 mm*
Poplar Veneer	length 2000-2200-2500-2800-3150 mm width 620-680 mm*
Basswood Veneer	length 2200-2500-2800-3150 mm width 620-680 mm*

Veneer dimension may be customized upon request and for specific product lines.

*With the exception of some product lines.

Thickness /

0.5-2.5 mm	with the following nominal thickness intervals
Up to 1.5 mm (included)	nominal interval 0.05 mm
Over 1.5 mm	nominal interval 0.10 mm

We can customize veneer dimensions for specific product lines upon request.

Dimensional Tolerances /

Length and Width	pursuant to sales agreements
Thickness	complies with standard ISO 18775

Wood Density /

450-900 kg/m³ (measured in compliance with standard IS9427)

ALPIlignum /

Formaldehyde Emission /

In compliance with E1 (analyzed according to EN 717).

On request ALPI can supply ALPIlignum with two levels of formaldehyde emissions below the E1 standard:

BE - ALPIlignum with a formaldehyde emission level equal to a fraction of the E1 standard.

ZeroF - ALPIlignum without added formaldehyde. It is in any event impossible to guarantee a complete absence of formaldehyde in ALPIlignum wood veneers as formaldehyde is a naturally-occurring substance in wood.

Light Fastness /

ALPIlignum is not a finished product and, therefore its resistance to light in part depends on the cycle and chemical nature of the finish. The buyer is advised that discoloring may occur. It is recommended that the buyer perform prior tests depending upon the particular purpose and intended use in order to optimize results.

Mechanical Specifications /

The mechanical characteristics of ALPIlignum depend on the cycle and chemical nature of the finish and the type of backing. It is recommended that the buyer perform prior tests depending upon the particular purpose and intended use in order to optimize results.

Colour and Structure /

Being a natural wood product, ALPIlignum may vary in its reference colour. It is recommended that before use the buyer check both the colour and the grains of the delivered product as against the ordered product.

Storage /

ALPIlignum is mainly made of wood and its moisture content may therefore be subject to variation depending on the storage and work environment. It is therefore advisable to maintain humidity in the range between 40% and 70% (RH) and a reference ambient temperature of 20°C.

Warnings /

Avoid - even temporarily- any contact with water and other liquids. Avoid any moisture condensation on product surface. The product must be stored on a flat surface at least 200 mm from the ground. ALPIlignum must be protected from direct and indirect light.

ALPIlignum /

Veneering /

Glueing With Urea Glues

ALPIlignum veneer can be glued on all wood backing using by means of urea glues. Different kinds of backing must be tested and assessed on a case-by-case basis. The quantity of glue to be used per square meter 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/m² of glue at pressures ranging from 1.5 to 5 bars. The recommended veneering temperature may range between 85°C and 120°C. The glue may be added with organic or inorganic fillers to modify its rheological properties in order to control bleeding through the veneer layer. The use of pigments with similar shades to the veneer base color is always recommended. Basswood-based products should be laminated on panels, using urea glue with an application of at least 120/140g/m².

Glueing With Vinyl Glues

ALPIlignum veneer can be glued on all wood support using vinyl glues. Different kinds of support need to be previously tested. 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 in order to avoid undesirable pass-through of the glue which would prove difficult to eliminate through sanding. It is generally advisable to use between 80 and 100g/m² of glue at pressures ranging from 1.5 to 3.5 bars. The advisable veneering temperature may vary between 60°C and 90°C. The use of pigments with similar shades to the veneer base color is always recommended.

Glueing With Hot Melt Glues

ALPIlignum veneer can be glued on all wood backing using hot melt glues such as polyolefin, EVA and reactive polyurethane. Different kinds of backing need to be tested. This type of glueing is mainly used to bond small surfaces, such as edges, with the help of automatic systems that have a 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.

Sanding /

After the veneering process ALPIlignum must be sanded in order to prepare and clean the surface for the varnish application. This process must be carried out with 120-150-180 grit sandpaper in a single step or in sequence using manual or automatic sanding machines. The use of 100 grit or 220/240 grit sandpaper is advised only for special decorative effects. The transversal sanding process with 120-150-180 grit sandpaper must be carried out at low strength and in any case may cause some microgroove traces and superficial rifts mainly on basswood-based ALPIlignum, it is advisable to follow the instructions provided by the glue supplier.

Varnishing /

Like all other types of wood, the varnishing process for ALPIlignum must be performed 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 (scratches, dents, etc.). Wood veneer can be stained without any particular problems. ALPIlignum can be varnished with any product or method recommended for wood treatments. However, the best results are achieved by selecting, among the various classes of products, those with the following characteristics:

- High wetting power
- High yellowing retardation power
- High UV protection

As for water paints, it is advisable to use products that are stable at a moderately acid pH (4-6), such as specific products destined for acid hardwoods. It is common practice to follow the instructions provided by finish manufacturers and to carry out preventive tests before proceeding to varnishing.

Please contact ALPI's technical office for any further clarification. This technical data sheet supersedes and replaces any previous version. The information and recommendations herein have been compiled from the current information held by ALPI and may be our best knowledge updated to perform the higher results of the applications.