ELTONGROUP

Alpi
Designer Collections

# Directions for Use

## 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 above the ground. ALPIlignum must be protected from direct and indirect light.

## Application Information

ALPIlignum veneer can be glued on all wood supports using urea, acrylic or hot melt glues. Different kinds of support must be tested and assessed on a case-by- case basis.

Glueing with Urea Glues

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 veneered on panels, using urea glue with an application of at least 120/140g/m².

Glueing with Vinyl Glues

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

Polyolefin, EVA, reactive polyurethane, etc. 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.

## Polishing

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 (photo-degradation, 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 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. 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.

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