

**ALPI**lignum

**ALPI**

**ALPIlignum** is a wood veneer (Standard ISO 18775) usually available in sheets with a thickness of 0.6 mm, a width of between 620 and 680 mm and a length from 2000 to 3150 mm.

On request, **ALPIlignum** can also be manufactured with a thickness ranging from 0.5 to 2.5 mm for the veneer and from 4 mm upwards for boards.

#### **EFFICIENCY**

Consistency and uniformity of colours and patterns, the absence of typical defects of traditional wood and a considerable range of sizes allow customers to minimize the amount of waste and reduce the number of cutting and splicing operations.

#### **VERSATILITY**

**ALPIlignum** is manufactured in large batches with predetermined dimensions. Its availability is guaranteed over time, making it the perfect choice both for mass production (furniture and doors) and for large contract use. The special manufacturing process makes it possible to recreate the characteristics of rare and precious woods as well produce creative and customized patterns. It may be installed and coated like any other wood veneer.

#### **DESIGN**

**ALPIlignum** boasts the characteristics of uniformity, continuity and repeatability of colour and grain; it can be customized into an infinite combination of patterns and colours to meet customers' needs.

#### **ECO-SUSTAINABILITY**

**ALPI's** processing makes it possible to produce more or protected wood, using sustainable raw materials from plantations or controlled forests.

#### **AVAILABILITY**

A range of items is available for prompt delivery to satisfy customer requirements\*

\*Availability of **ALPI** veneers may vary and require minimum quantities and technical delivery times. We suggest you therefore contact our Customer Service to check on veneer availability and/or request further sampling.

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MORE INFO. Technical data sheets, certification and further information about **ALPI** products and distributors is available on our website: [www.alpi.it](http://www.alpi.it)



## WOOD COLLECTION

PRODUCT CODE	TYPE	TEXTURE	SIZE	ALPIDEOS MATCHING
10.89	Maple	Crown	3150x640	
10.60	Wavy Oak	Planked	3150x640	
10.61	Oak	Quartered	2500X640 3150x640	☉
10.82	Icecool Oak	Quartered	2500X640 3150x640	
10.64	Décapé Oak	Quartered	2500X640 3150x640	☉
10.63	Steady Oak	Quartered	3150x640	☉
10.84	Slavony Oak	Planked	3150x640	
10.71	Zebrawood	Quartered	2500X640 3150x640	☉
10.88	Zingana	Quartered	3150x640	
10.74	Teak	Quartered	3150x640	☉
10.24	Santos Rosewood	Crown	3150x640	☉
10.23	Indian Rosewood	Quartered	2500X640 3150x640	☉
10.18	Steady American Walnut	Quartered	3150x640	☉
10.19	Wavy American Walnut	Planked	3150x640	
10.16	American Walnut	Quartered	3150x640	☉
10.31	Steady Wengè	Quartered	3150x680/740	☉
10.68	Thermotreated Oak	Planked	3150x640	☉
10.85	Smoked Oak	Planked	3150x640	
10.33	Brown Wengè	Quartered	3150x640	
10.67	Dark Oak	Quartered	3150x640	☉
10.32	Wengè	Quartered	3150x680/740	
10.41	Makassar Ebony	Quartered	2500X640 3150x640	☉
10.42	Ammara Ebony	Quartered	2500X640 3150x640	☉
10.43	Gabon Ebony	Quartered	3150x640	☉
10.09	Pure White Erable	Burl	2500x640	
10.03	Erable Frisé	Burl	2500x640	
10.02	Erable	Burl	2500x640	
10.08	Myrtle Burl	Burl	2500x640	
10.04	Ash Burl	Burl	2500x640	
10.07	Walnut Burl	Burl	2500x640	
10.05	Elm Burl	Burl	2500x640	
10.06	California Burl (Walnut)	Burl	2500x640	

## COLOUR COLLECTION

PRODUCT CODE	TYPE	TEXTURE	SIZE	ALPIDECOS MATCHING
11.01	Sahara Sand Oak	Quartered	3150x640	
10.81	Ivory Oak	Planked	2500X640	
11.06	Shell Sand Oak	Quartered	3150x640	
10.83	Sand Oak	Quartered	2500X640 3150x640	
10.69	Breeze Oak	Planked	3150x640	
11.03	Clay Oak	Quartered	3150x640	
10.87	Ocean Sand Oak	Quartered	3150x640	
11.02	Platinum Oak	Quartered	3150x640	
10.66	Steady Grey Oak	Quartered	3150x640	
10.65	Smoke Grey Oak	Quartered	3150x640	
11.05	Steady Dove Grey Oak	Quartered	3150x640	
11.04	Dark Dove Grey Oak	Quartered	3150x640	
11.07	Sand Erable	Burl	2500X640	
11.08	Pearly Grey Vavona	Burl	2500X640	

## DESIGN COLLECTION

PRODUCT CODE	TYPE	TEXTURE	SIZE	ALPIDECOS MATCHING
13.02	Savanna	Crown	2500X640	
13.04	Country Stripes	Quartered	2500X640	
13.03	Urban Stripes	Quartered	2500X640	
13.05	Heaven and Heart	Quartered	2500X640	
13.06	Fossil Forest	Burl	2500X640	
13.09	Living Rock	Quartered	2500x640	
13.01	Crown Bark	Crown	2500X640	
13.07	Ebony and Ivory	Crown	3150x640	
13.08	Black Diamond	Quartered	3150x640	

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

## AVERAGE WEIGHT COMPOSITION

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**POPLAR WOOD (AND/OR AYOUS WOOD, AND/OR BASSWOOD), 70-80%**

**RESINS, 16-20%**

**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.

## DIMENSIONS

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<b>AYOUS VENEER</b>	<b>length 2000-2200-2500-2800-3150 mm</b>	<b>width 620-680 mm*</b>
<b>POPLAR VENEER</b>	<b>length 2000-2200-2300-2500-2600 mm</b>	<b>width 620-680 mm*</b>
<b>BASSWOOD VENEER</b>	<b>length 2200-2500-2800-3150 mm</b>	<b>width 620-680 mm*</b>

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

\*With the exception of specific product lines.

## THICKNESS

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**0.5-2.5 mm with the following nominal thickness intervals**

<b>Up to 1.5 mm (included)</b>	<b>nominal interval 0.05 mm</b>
<b>Over 1.5 mm</b>	<b>nominal interval 0.10 mm</b>

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

## FORMALDEHYDE EMISSION

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

## 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.

## DIMENSIONAL TOLERANCES

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**LENGTH AND WIDTH: pursuant to sales agreements**  
**THICKNESS: complies with standard ISO 18775**

## WOOD DENSITY

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450-900 kg/m<sup>3</sup> (measured in compliance with standard IS9427)

## COLOR AND STRUCTURE

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

## CAUTION

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

# RECOMMENDATIONS FOR USE

## VENEERING

### GLUEING WITH UREA GLUES

**ALPI lignum** 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 metre 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/m<sup>2</sup> 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 blended with organic or inorganic excipients 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/m<sup>2</sup>.

### GLUEING WITH VINYL GLUES

**ALPI lignum** veneer can be glued on all wood backing using vinyl glues.

Different kinds of backing need to be tested and assessed on a case-by-case basis.

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, the base and the press, in order to avoid undesirable pass-through which would prove difficult to eliminate through sanding.

It is generally advisable to use between 80 and 100g/m<sup>2</sup> of glue at pressures ranging from 1.5 to 3.5 bars.

The advisable veneering temperature may vary between 60°C and 90°C.

### GLUEING WITH HOT MELT GLUES

**ALPI lignum** 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 and assessed on a case-by-case basis. This type of glueing is mainly used to glue 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 **ALPI lignum** must be sanded in order to free the surface from handling and glue traces. 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 **ALPI lignum**.

## VARNISHING

Like all other types of wood, the varnishing process for **ALPI lignum** must be performed with a suitable product that is 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 (scraping, dents, etc.). Wood veneer can be colored without any particular problems, and it is advisable to do so.

**ALPI lignum** 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 certain specific products designed for acid hardwood.

It is always sound practice strictly to follow the instructions provided by paint 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 subject to change if new knowledge or new production systems become available. Users are advised to apply their own judgement about the suitability of this product in relation to their specific purpose and intended use.

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