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*Ipir*®

## IPIR – ITALY

Our Company has been one of the biggest manufacturers of Recomposed Wood Veneers for more than 50 years. Our products are exported in more than 87 Countries all over the world.

Our Veneers are subject to stringent Quality Control and deliveries are punctual in order to meet our customers' requirements.

We are also committed to the Environmental issue through the principles of Recycling, Water Minimisation and Eco-balance Preservation.

Our Company is particularly sensitive to the ecological issues of sustainable supply sources for the wood we use to manufacture our Recomposed Veneers.

The production of our veneers is based on two sources of raw material: Italian Poplar and Ayous (Triplochiton Schleroxylon).

### POPLAR:

Italian Poplar is a product that grows in regular Italian plantations, renewed every year to grant constant availability of raw material. The logs are purchased from certified companies.

### AYOUS:

Our Company possesses, through its Cameroon subsidiary PLACAM, regular concessions for the exploitation of the forests where Ayous grows.

Ayous (Triplochiton Schleroxylon) is a very common tree species that grows in extensive areas of tropical Africa and is present in large quantities in our own concessions in Cameroon. We were granted these concessions by Government bodies and logging in the forests is made under the direct control of the Cameroon Government and of the World Bank.

The cutting is only allowed when the plant has reached its maximum growth and is limited to one tree per hectare.

In this way a selection and a rational renewal of the forest is carried out and forests will maintain their global integrity through a constant redevelopment.

### WORKING PROCESS:

The working process begins by peeling logs of Italian Poplar and Ayous forest trees.

The peeled wood sheets are selected in order to use only those that do not have knots and other defects, the same sheets are dyed to obtain the required colour shades and later glued together to get regular shaped blocks which will eventually be sliced into the desired thickness.

Our Recomposed Veneers are subjected to 5 quality inspections during the different production stages:

The first inspection is made on the quality of the peeled wood sheets we're going to use for our production.

The second is carried out in the dry kiln department during the peeled wood drying stage.

The third after the dyeing stage to check the colour.

The fourth after the production of the actual blocks.  
The fifth one is made after the slicing.

## TECHNICAL DATA

### Composition of the product:

Ipir recomposed wood veneer is composed as follows:

Ayous or Poplar wood:	70-80%
Dyes:	1 – 2 %
Resins:	15-25%
Moisture:	10-14%

on request it is possible to reduce moisture content to 4%

### Standard dimensions:

Ayous based models

Panel size:

length: 250, 280, 310, 340 cm with a tolerance of +2 cm  
width: 65/75 cm with a tolerance of +1 cm

Door size:

length: 220 cm with a tolerance of +2 cm  
width: from 65 to 88 cm with a tolerance of +1 cm

other dimensions are available on request

Poplar based models:

length: 220, 250 cm with a tolerance of +2 cm  
width: 65/75 cm with a tolerance of +1 cm

Thickness: from 0,30 mm to 1,50 mm with a tolerance of +/- 0,03  
from 1,50 mm to 3,00 mm with a tolerance of +/- 0,05

Wood density: 450-900 kg/m<sup>3</sup> (depending on the models)

Moisture: < 14%

Formaldehyde emission: in compliance with E1, analysed according to EN717-2/94

Colour variation: colour as per original sample with a possible slight difference considering that the base raw material is wood (a natural product) and a colour difference up to 5% must be accepted. No colour variation in the same pallet.

Holes: scattered, not gathered, from 1 mm up to 3 mm

Open splits: max. 0,5 x 100 mm

Close splits: small scattered splits

Surface: as smooth as possible, considering that the raw material is wood with its own natural characteristics

Oil and glue spots: not allowed

Dead knots: dia. < 8 mm, no sharp colour contrast

Knife marks: not significant

Each pallet marked with unique pallet number and week of production.

### Recommendations for storage:

Avoid contact with water and other liquids.

The veneer must be shielded from direct and indirect sunlight.

It is advisable to keep humidity range between 35/40% and 65/70% and a temperature of 20/25° C.

### Recommendations for use:

- With ureic glues: 130/150 g/m<sup>2</sup>
- Pressure: from 1,5 to 5 BAR
- Temperature: between 85/90° C and 115/120° C.

The use of pigments with similar shades to the veneer base colour is always recommended.

- With vinyl glues: 80/100 g/m<sup>2</sup>
- Pressure: from 1,5 to 3,5 BAR
- Temperature: between 60/65° C and 85/90° C.

For other type of gluing such as polyuretane, EVA etc. it is always recommended to make some tests taking into consideration the characteristics of the products.

### Varnishing:

IPIR recomposed veneer can be varnished with any product recommended for wood treatments, always keeping in mind that best results are achieved by selecting products having the following characteristics:

- \* high UV protection
- \* good properties of yellowing retention

**LIGHT RESISTANCE:** On request we can supply veneers with a light resistance power four times stronger than that of the standard production.

Ipir Veneers, devoid of defects, can be laid on panels or applied to furniture components, the application is easier than that of natural veneers and can be carried out with traditional glues. The varnishing process can be made with polyester resins or other resins.

Being a natural wood based product with no defects, our Recomposed Veneer can be used without any production reject or waste whatsoever.

We have many different shades of colours and a lot of different grain structures available in order to reproduce the same colours and grains of natural veneer types.

Our company offers a large range of products in the Recomposed Veneer sector and, on

request, our lab can also produce match samples of different colours and grains.

Rinini, Italy

21/05/2019