

Title (en)

Method for manufacturing a multilayer blockboard from solid coniferous wood lamella for an increased hardness and abrasion resistance

Title (de)

Verfahren zur Herstellung einer Tischlerplatte aus soliden Nadelholzlamellen für eine verbesserte Härte und Abnutzbeständigkeit

Title (fr)

Procédé de fabrication d'un contreplaqué latté multicouche à partir de lamelles solides de bois de conifère à dureté et résistance à l'abrasion améliorées

Publication

EP 2574436 A1 20130403 (EN)

Application

EP 11461539 A 20110929

Priority

EP 11461539 A 20110929

Abstract (en)

Method for production of multilayer blockboard from solid coniferous wood lamella of increased hardness and abrasion resistance is made by having those lamellas of the same thickness with milling of the surface which forms the glue fugue sorted and chosen, which width of growth rings does not exceed 2,5 mm and which grain arrangement in proportion to the working surface is at an angle of 90 degrees with a deviation in both directions of no more than 25 degrees for lamellas of a thickness of from 10 - 14 mm. One of the milled sides of the lamella is covered with a class D4/C4 resistant adhesive and is connected into the panel. The glued in the press panel is calibrated and afterwards the calibrated panel is glued crosswise into a standard blockboard with the use of glue as stated before. A panel of a thickness above 14 mm is in turn cut again into lamellas transverse to the configuration of growth rings and lamellas are again glued into the panel and afterwards the monolayer panel prepared in such a way is calibrated and glued into a multilayer blockboard with lamellas put crosswise, whereas the finished panel is calibrated and finally the grinded panel is covered with hot melt curing agents.

IPC 8 full level

B27M 3/00 (2006.01); **B27M 3/06** (2006.01); **E04F 15/04** (2006.01)

CPC (source: EP)

B27M 3/0053 (2013.01); **B27M 3/06** (2013.01); **E04F 15/047** (2013.01)

Citation (applicant)

- US 5034259 A 19910723 - BARKER EARL M [US]
- WO 2008113890 A1 20080925 - STORA ENSO TIMBER OY LTD [FI], et al
- US 2003010434 A1 20030116 - GRENIER RAOUL [CA]
- PL 346794 A1 20011008 - BAYER AG [DE]
- PL 331003 A1 19990621 - HENKEL KGAA [DE], et al
- US 2006263567 A1 20061123 - HOFSTE ROY J [NL]
- RU 2357054 C2 20090527 - GREKOV ALEKSANDR VLADIMIROVICH [RU]

Citation (search report)

- [X] US 3481810 A 19691202 - WAITE JOHN C
- [I] EP 1721714 A1 20061115 - HOLZINDUSTRIE LEITINGER GES M [AU]
- [ID] WO 2008113890 A1 20080925 - STORA ENSO TIMBER OY LTD [FI], et al
- [ID] US 5034259 A 19910723 - BARKER EARL M [US]
- [I] WO 2010086051 A1 20100805 - FRITZ EGGER GMBH & CO OG [AT], et al
- [I] US 3878016 A 19750415 - SADASHIGE TAKESHI
- [A] CN 101302887 A 20081112 - DIANMAN WU [CN]
- [A] DE 2404898 A1 19750814 - KREIBAUM OTTO
- [A] DE 3904066 A1 19900419 - THANHEISER SCHREINER WERKSTAET [DE]
- [A] US 5213861 A 19930525 - SEVERSON THOMAS A [US], et al
- [A] FR 2719252 A1 19951103 - PITKANEN RISTO HEIKKI [FI]
- [A] GB 787169 A 19571204 - WINSORFLOR LTD
- [A] US 5050653 A 19910924 - BROWN DONALD W [US]

Designated contracting state (EPC)

AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

Designated extension state (EPC)

BA ME

DOCDB simple family (publication)

EP 2574436 A1 20130403

DOCDB simple family (application)

EP 11461539 A 20110929