ALPIlignum / 18.74

Collection Designer	Designer Atelier Mendini with Alex Mocika
Product	ALPI Pointillisme COL
Texture	Design
Size	2500x620 mm

ALPI

Technical Features /

ALPIlignum / 18.75

Collection Designer	Designer Atelier Mendini with Alex Mocika
Product	ALPI Pointillisme B/N
Texture	Design
Size	2500x620 mm

ALPIlignum /

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

Standard dimensions /

Poplar based Veneer	length 2200-2500 mm; width from 620 to 700 mm
Ayous based Veneer	length 2200-2500-2800-3150 mm; width 360 mm, from 620 to 760 mm
Basswood based Veneer	length 2200-3150 mm; width 360 mm, from 620 to 700 mm

Please note that special dimensions can be manufactured on request.

Nominal thickness available /

Thickness	from 0,42 mm to 2,8 mm

Not all producs are available in all the above esthickness.

Dimensional Manufactoring Tolerances /

Width	-0 / +30 mm
Thickness	complies with standard ISO 18775 < 1,5 mm : +/- 0,05 mm; > 1,5 mm : +/- 4%

Wood Density /

450-900 kg/m3 (measured in compliance with standard ISO 9427) depending on the structure of each product.

ALPIlignum /

Formaldehyde Emission /

In compliance with E1 (analyzed according to EN 717-1).
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 impossible to guarantee a complete absence of traces of formaldehyde as this naturally occurs 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. Upon request ALPI is able to supply an Alpilignum version that, if finished with the correct finishing cycle can reach higher values than 4 on the grey scale (UNI EN 15187:2007).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 Grain /

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 temporarly- 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 destinated 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.

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ALPIlignum / 18.70

	Designer
Collection Designer	Ettore Sottsass
Product	ALPI Sottsass Orange
Texture	Design
Size	2500x640 mm

ALPIlignum / 18.71

Collection Designer	Designer Ettore Sottsass
Product	ALPI Sottsass Red
Texture	Design
Size	2500x640 mm

ALPIlignum / 18.72

Collection Designer	Designer Ettore Sottsass
Product	ALPI Sottsass Brown
Texture	Design
Size	2500x640 mm

ALPIlignum / 18.73

Collection Designer	Designer Ettore Sottsass
Product	ALPI Sottsass Grey
Texture	Design
Size	2500x640 mm

ALPIlignum /

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

Standard dimensions /

Poplar based Veneer	length 2200-2500 mm; width from 620 to 700 mm
Ayous based Veneer	length 2200-2500-2800-3150 mm; width 360 mm, from 620 to 760 mm
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Please note that special dimensions can be manufactured on request.

Nominal thickness available /

Thickness	from 0,42 mm to 2,8 mm

Not all producs are available in all the above esthickness.

Dimensional Manufactoring Tolerances /

Width	-0 / +30 mm
Thickness	complies with standard ISO 18775 < 1,5 mm : +/- 0,05 mm; > 1,5 mm : +/- 4%

Wood Density /

450-900 kg/m3 (measured in compliance with standard ISO 9427) depending on the structure of each product.

ALPIlignum /

Formaldehyde Emission /

In compliance with E1 (analyzed according to EN 717-1).
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 impossible to guarantee a complete absence of traces of formaldehyde as this naturally occurs in wood.

Light Fastness /

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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 Grain /

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 temporarly- 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

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Glueing With Hot Melt Glues

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Sanding /

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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:
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- 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 destinated 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.

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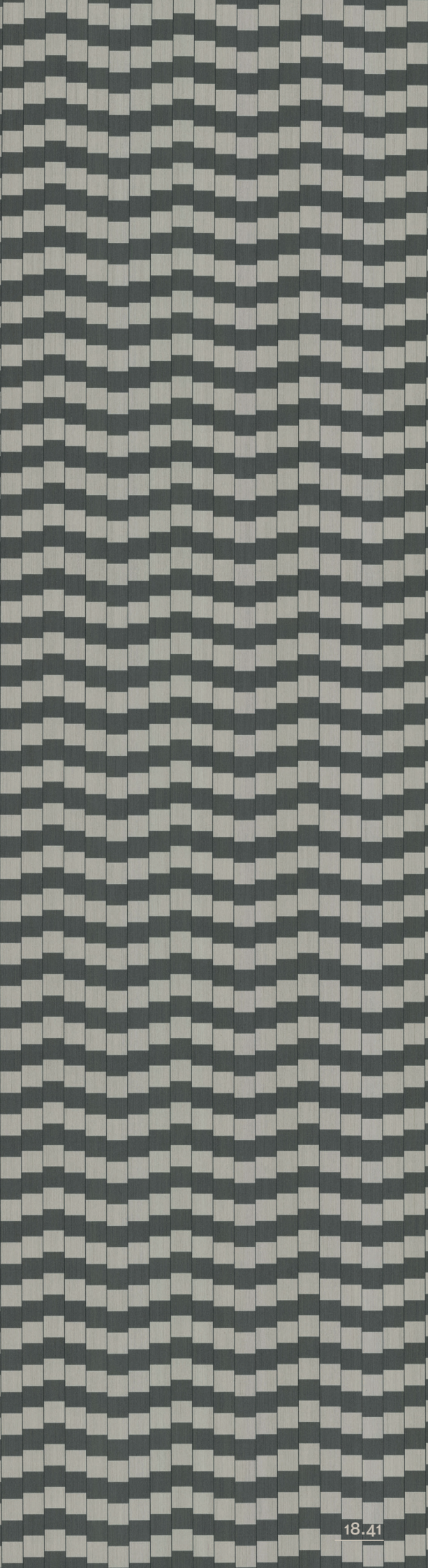
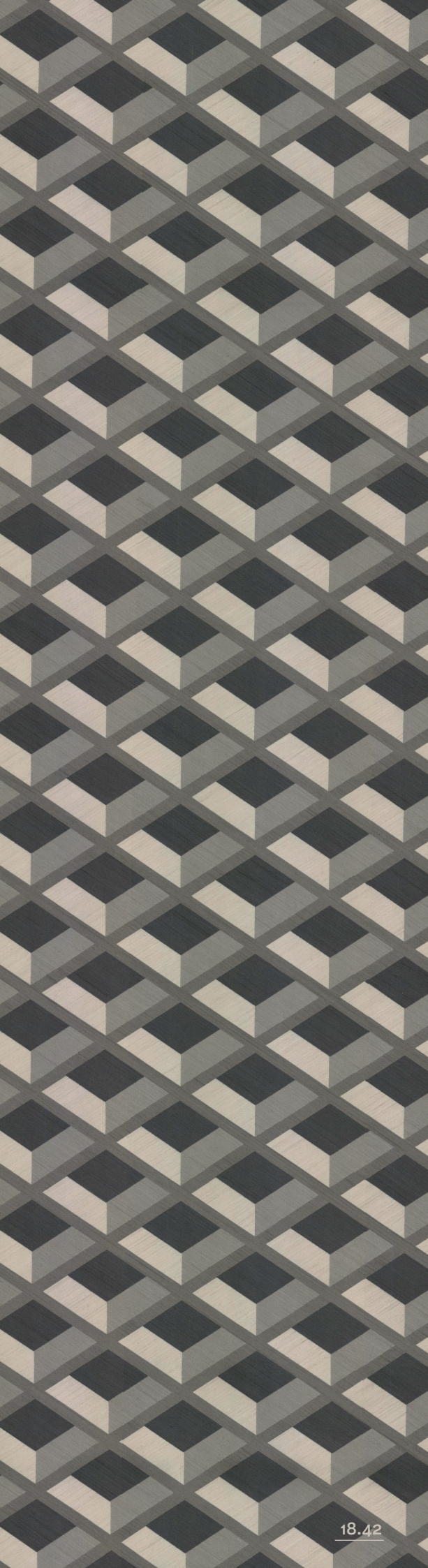


ALPIlignum / 18.41

Collection Designer	Designer Front
Product	ALPI Drapery Wood
Texture	Design
Size	2500x640 mm



ALPIlignum / 18.42

Collection Designer	Designer Front
Product	ALPI Grid Wood
Texture	Design
Size	1500x620 mm

ALPIlignum /

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

Standard dimensions /

Poplar based Veneer	length 2200-2500 mm; width from 620 to 700 mm
Ayous based Veneer	length 2200-2500-2800-3150 mm; width 360 mm, from 620 to 760 mm
Basswood based Veneer	length 2200-3150 mm; width 360 mm, from 620 to 700 mm

Please note that special dimensions can be manufactured on request.

Nominal thickness available /

Thickness	from 0,42 mm to 2,8 mm

Not all producs are available in all the above esthickness.

Dimensional Manufactoring Tolerances /

Width	-0 / +30 mm
Thickness	complies with standard ISO 18775 < 1,5 mm : +/- 0,05 mm; > 1,5 mm : +/- 4%

Wood Density /

450-900 kg/m3 (measured in compliance with standard ISO 9427) depending on the structure of each product.

ALPIlignum /

Formaldehyde Emission /

In compliance with E1 (analyzed according to EN 717-1).
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 impossible to guarantee a complete absence of traces of formaldehyde as this naturally occurs 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. Upon request ALPI is able to supply an Alpilignum version that, if finished with the correct finishing cycle can reach higher values than 4 on the grey scale (UNI EN 15187:2007).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 Grain /

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 temporarly- 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

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Glueing With Vinyl Glues

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Glueing With Hot Melt Glues

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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 /

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- 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 destinated 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.

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18.43

ALPIlignum / 18.43

Collection Designer	Designer GamFratesi
Product	ALPI Cloudy
Texture	Design
Size	2500x640 mm

ALPIlignum / 18.44

Collection Designer	Designer GamFratesi
Product	ALPI Rain 1
Texture	Design
Size	2500x640 mm

18.45

ALPIlignum / 18.45

Collection Designer	Designer GamFratesi
Product	ALPI Rain 2
Texture	Design
Size	2500x640 mm

ALPIlignum /

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Standard dimensions /

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Please note that special dimensions can be manufactured on request.

Nominal thickness available /

Thickness	from 0,42 mm to 2,8 mm

Not all producs are available in all the above esthickness.

Dimensional Manufactoring Tolerances /

Width	-0 / +30 mm
Thickness	complies with standard ISO 18775 < 1,5 mm : +/- 0,05 mm; > 1,5 mm : +/- 4%

Wood Density /

450-900 kg/m3 (measured in compliance with standard ISO 9427) depending on the structure of each product.

ALPIlignum /

Formaldehyde Emission /

In compliance with E1 (analyzed according to EN 717-1).
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Light Fastness /

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Mechanical Specifications /

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Colour and Grain /

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Storage /

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Warnings /

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ALPIlignum /

Veneering /

Glueing With Urea Glues

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Glueing With Hot Melt Glues

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Sanding /

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Varnishing /

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ALPIlignum / 18.46

Collection Designer	Designer Kengo Kuma
Product	ALPI Japanese Cedar
Texture	Design
Size	3150x620 mm

ALPIlignum / 18.47

Collection Designer	Designer Kengo Kuma
Product	ALPI Maritime Pine
Texture	Design
Size	2500x620 mm

ALPIlignum /

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Standard dimensions /

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Please note that special dimensions can be manufactured on request.

Nominal thickness available /

Thickness	from 0,42 mm to 2,8 mm

Not all producs are available in all the above esthickness.

Dimensional Manufactoring Tolerances /

Width	-0 / +30 mm
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Wood Density /

450-900 kg/m3 (measured in compliance with standard ISO 9427) depending on the structure of each product.

ALPIlignum /

Formaldehyde Emission /

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Mechanical Specifications /

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It is recommended that the buyer perform prior tests depending upon the particular purpose and intended use in order to optimize results.

Colour and Grain /

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 temporarly- 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 destinated 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 complied from the current information held by ALPI and may be our best knowledge updated to perform the higher results of the applications.

ALPIlignum / 14.01

Collection Designer	Designer Matteo Ragni
Product	ALPI Day and Night Twill
Texture	Design
Size	2500x620 mm

ALPIlignum / 14.02

Collection Designer	Designer Matteo Ragni
Product	ALPI Smoky Velvet
Texture	Design
Size	2500x640 mm

ALPIlignum / 14.03

Collection Designer	Designer Matteo Ragni
Product	ALPI Frame
Texture	Design
Size	2500x640 mm

ALPIlignum / 14.04

Collection Designer	Designer Matteo Ragni
Product	ALPI Concrete Pinstripe
Texture	Design
Size	2500x660 mm

ALPIlignum /

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

Standard dimensions /

Poplar based Veneer	length 2200-2500 mm; width from 620 to 700 mm
Ayous based Veneer	length 2200-2500-2800-3150 mm; width 360 mm, from 620 to 760 mm
Basswood based Veneer	length 2200-3150 mm; width 360 mm, from 620 to 700 mm

Please note that special dimensions can be manufactured on request.

Nominal thickness available /

Thickness	from 0,42 mm to 2,8 mm

Not all producs are available in all the above esthickness.

Dimensional Manufactoring Tolerances /

Width	-0 / +30 mm
Thickness	complies with standard ISO 18775 < 1,5 mm : +/- 0,05 mm; > 1,5 mm : +/- 4%

Wood Density /

450-900 kg/m3 (measured in compliance with standard ISO 9427) depending on the structure of each product.

ALPIlignum /

Formaldehyde Emission /

In compliance with E1 (analyzed according to EN 717-1).
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 impossible to guarantee a complete absence of traces of formaldehyde as this naturally occurs 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. Upon request ALPI is able to supply an Alpilignum version that, if finished with the correct finishing cycle can reach higher values than 4 on the grey scale (UNI EN 15187:2007).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 Grain /

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 temporarly- 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.

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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:
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- 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 destinated 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.

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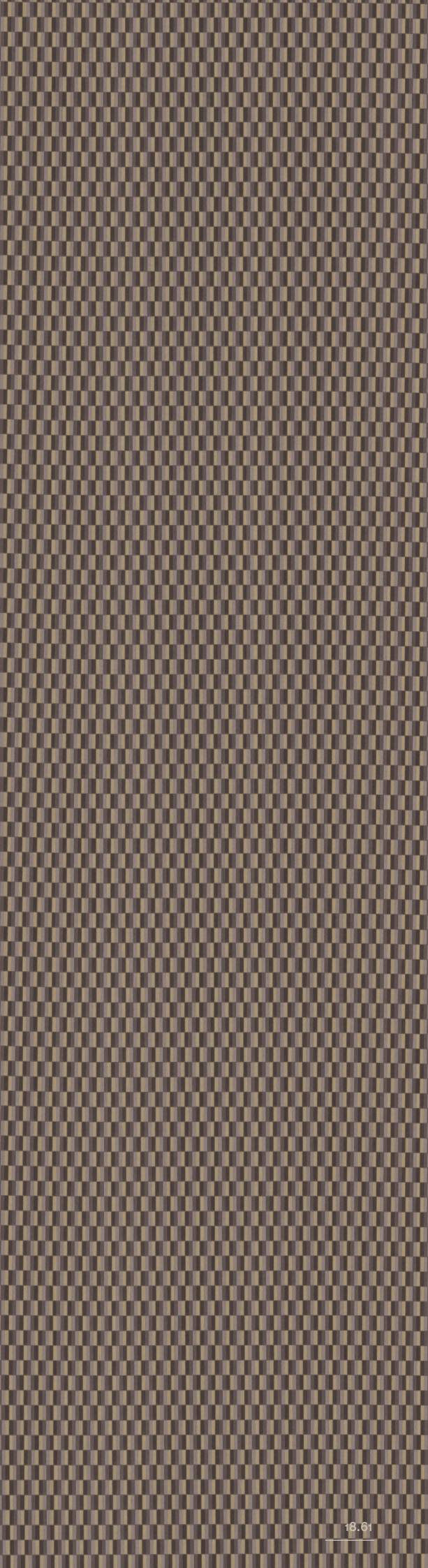
ALPIlignum / 18.60

Collection Designer	Designer Patricia Urquiola
Product	ALPI Grada Rosa
Texture	Design
Size	2500x620 mm



ALPIlignum / 18.61

Collection Designer	Designer Patricia Urquiola
Product	ALPI Grada Grigio
Texture	Design
Size	2500x620 mm

ALPIlignum / 18.62

Collection Designer	Designer Patricia Urquiola
Product	ALPI Quadra Rovere
Texture	Design
Size	2500x620 mm

ALPIlignum / 18.63

Collection Designer	Designer Patricia Urquiola
Product	ALPI Quadra Noce
Texture	Design
Size	2500x620 mm

ALPIlignum /

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

Standard dimensions /

Poplar based Veneer	length 2200-2500 mm; width from 620 to 700 mm
Ayous based Veneer	length 2200-2500-2800-3150 mm; width 360 mm, from 620 to 760 mm
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Please note that special dimensions can be manufactured on request.

Nominal thickness available /

Thickness	from 0,42 mm to 2,8 mm

Not all producs are available in all the above esthickness.

Dimensional Manufactoring Tolerances /

Width	-0 / +30 mm
Thickness	complies with standard ISO 18775 < 1,5 mm : +/- 0,05 mm; > 1,5 mm : +/- 4%

Wood Density /

450-900 kg/m3 (measured in compliance with standard ISO 9427) depending on the structure of each product.

ALPIlignum /

Formaldehyde Emission /

In compliance with E1 (analyzed according to EN 717-1).
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BE - ALPIlignum with a formaldehyde emission level equal to a fraction of the E1 standard.
ZeroF - ALPIlignum without added formaldehyde.
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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. Upon request ALPI is able to supply an Alpilignum version that, if finished with the correct finishing cycle can reach higher values than 4 on the grey scale (UNI EN 15187:2007).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 Grain /

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 /

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Warnings /

Avoid - even temporarly- 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

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Glueing With Hot Melt Glues

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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:
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- 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 destinated 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.

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ALPI

Technical Features /

ALPIlignum / 18.01

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 Striped White
Texture	Quartered
Size	3150x640 mm

ALPI

Technical Features /

ALPIlignum / 18.02

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 Striped Sand
Texture	Quartered
Size	3150x640 mm

ALPIlignum / 18.03

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 Striped Grey
Texture	Quartered
Size	3150x640 mm

ALPIlignum / 18.04

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 Striped Black
Texture	Quartered
Size	3150x640 mm

ALPI

Technical Features /

ALPIlignum / 18.05

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 Striped XL White
Texture	Quartered
Size	3150x620 mm

ALPIlignum / 18.06

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 Striped XL Sand
Texture	Quartered
Size	3150x620 mm

ALPI

Technical Features /

ALPIlignum / 18.07

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 Striped XL Grey
Texture	Quartered
Size	3150x620 mm

ALPIlignum / 18.08

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 Striped XL Black
Texture	Quartered
Size	3150x620 mm

ALPI

Technical Features /

ALPIlignum / 18.09

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 3-Flamed White
Texture	Crown
Size	3150x640 mm

ALPIlignum / 18.10

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 3-Flamed Sand
Texture	Crown
Size	3150x640 mm

ALPIlignum / 18.11

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 3-Flamed Grey
Texture	Crown
Size	3150x640 mm

ALPIlignum / 18.12

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 3-Flamed Black
Texture	Crown
Size	3150x640 mm

ALPIlignum / 18.13

Collection Designer	Designer Piero Lissoni
Product	ALPI Tarsie 2 White
Texture	Design
Size	2500x620 mm

ALPIlignum / 18.14

Collection Designer	Designer Piero Lissoni
Product	ALPI Tarsie 2 Black
Texture	Design
Size	2500x620 mm

ALPIlignum / 18.15

Collection Designer	Designer Piero Lissoni
Product	ALPI Tarsie 3 Sand
Texture	Design
Size	2500x620 mm

ALPIlignum / 18.16

Collection Designer	Designer Piero Lissoni
Product	ALPI Tarsie 3 Black
Texture	Design
Size	2500x620 mm

ALPIlignum / 18.17

Collection Designer	Designer Piero Lissoni
Product	ALPI Tarsie 1 Sand
Texture	Design
Size	2500x620 mm

ALPI

Technical Features /

ALPIlignum / 18.18

Collection Designer	Designer Piero Lissoni
Product	ALPI Tarsie 1 Grey
Texture	Design
Size	2500x620 mm

ALPIlignum / 18.21

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 Planked White
Texture	Planked
Size	3150x620 mm

ALPI

Technical Features /

ALPIlignum / 18.22

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 Planked Sand
Texture	Planked
Size	3150x620 mm

ALPI

Technical Features /

ALPIlignum / 18.23

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 Planked Grey
Texture	Planked
Size	3150x620 mm

ALPI

Technical Features /

ALPIlignum / 18.24

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 Planked Black
Texture	Planked
Size	3150x620 mm

ALPIlignum / 18.25

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 1-Flamed White
Texture	Crown
Size	3150x360 mm

ALPI

Technical Features /

ALPIlignum / 18.26

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 1-Flamed Sand
Texture	Crown
Size	3150x360 mm

ALPI

Technical Features /

ALPIlignum / 18.27

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 1-Flamed Grey
Texture	Crown
Size	3150x360 mm

ALPI

Technical Features /

ALPIlignum / 18.28

Collection Designer	Designed by Piero Lissoni
Product	ALPI Xilo 2.0 1-Flamed Black
Texture	Crown
Size	3150x360 mm

ALPI

Technical Features /

ALPIlignum / 18.50

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 2-Flamed White
Texture	Crown
Size	3150x620 mm

ALPIlignum / 18.51

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 2-Flamed Sand
Texture	Crown
Size	3150x620 mm

ALPI

Technical Features /

ALPIlignum / 18.52

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 2-Flamed Grey
Texture	Crown
Size	3150x620 mm

ALPI

Technical Features /

ALPIlignum / 18.53

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 2-Flamed Black
Texture	Crown
Size	3150x620 mm

ALPI

Technical Features /

ALPIlignum / 18.54

Collection Designer	Designer Piero Lissoni
Product	ALPI Ikat 3
Texture	Design
Size	2500x620 mm

ALPI

Technical Features /

ALPIlignum / 18.55

Collection Designer	Designer Piero Lissoni
Product	ALPI Ikat 2
Texture	Design
Size	2500x620 mm

ALPIlignum / 18.56

Collection Designer	Designer Piero Lissoni
Product	ALPI Ikat 1 White
Texture	Design
Size	2500x620 mm

ALPIlignum / 18.57

Collection Designer	Designer Piero Lissoni
Product	ALPI Ikat 1 Dark Grey
Texture	Design
Size	2500x620 mm

18.80

ALPI

Technical Features /

ALPIlignum / 18.80

Collection Designer	Designer Piero Lissoni
Product	ALPI Velò Natural
Texture	Design
Size	2500x620 mm

ALPI

Technical Features /

ALPIlignum / 18.81

Collection Designer	Designer Piero Lissoni
Product	ALPI Velò Brown
Texture	Design
Size	2500x620 mm

ALPI

Technical Features /

ALPIlignum / 18.82

Collection Designer	Designer Piero Lissoni
Product	ALPI Velò Mocha
Texture	Design
Size	2500x620 mm

18.83

ALPIlignum / 18.82

Collection Designer	Designer Piero Lissoni
Product	ALPI Velò Sand
Texture	Design
Size	2500x620 mm

ALPIlignum /

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

Standard dimensions /

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Nominal thickness available /

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Wood Density /

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ALPIlignum /

Formaldehyde Emission /

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Light Fastness /

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Mechanical Specifications /

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Colour and Grain /

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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 /

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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 destinated 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 complied from the current information held by ALPI and may be our best knowledge updated to perform the higher results of the applications.

ALPI

Technical Features /

ALPIlignum / 18.87

Collection Designer	Curated by Piero Lissoni
Product	ALPI Xilo 2.0 Blush Cherry 2-Flamed
Texture	Crown
Size	2500x620 mm

ALPIlignum /

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

Standard dimensions /

Poplar based Veneer	length 2200-2500 mm; width from 620 to 700 mm
Ayous based Veneer	length 2200-2500-2800-3150 mm; width 360 mm, from 620 to 760 mm
Basswood based Veneer	length 2200-3150 mm; width 360 mm, from 620 to 700 mm

Please note that special dimensions can be manufactured on request.

Nominal thickness available /

Thickness	from 0,42 mm to 2,8 mm

Not all producs are available in all the above esthickness.

Dimensional Manufactoring Tolerances /

Width	-0 / +30 mm
Thickness	complies with standard ISO 18775 < 1,5 mm : +/- 0,05 mm; > 1,5 mm : +/- 4%

Wood Density /

450-900 kg/m3 (measured in compliance with standard ISO 9427) depending on the structure of each product.

ALPIlignum /

Formaldehyde Emission /

In compliance with E1 (analyzed according to EN 717-1).
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 impossible to guarantee a complete absence of traces of formaldehyde as this naturally occurs 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. Upon request ALPI is able to supply an Alpilignum version that, if finished with the correct finishing cycle can reach higher values than 4 on the grey scale (UNI EN 15187:2007).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 Grain /

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 temporarly- 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 destinated 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 complied from the current information held by ALPI and may be our best knowledge updated to perform the higher results of the applications.

ALPIlignum / 18.31

Collection Designer	Designer The Campana Brothers
Product	ALPI Pirarucu
Texture	Design
Size	3150x620 mm

ALPIlignum / 18.32

Collection Designer	Designer The Campana Brothers
Product	ALPI Piaçava
Texture	Design
Size	3150x700 mm

ALPIlignum /

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

Standard dimensions /

Poplar based Veneer	length 2200-2500 mm; width from 620 to 700 mm
Ayous based Veneer	length 2200-2500-2800-3150 mm; width 360 mm, from 620 to 760 mm
Basswood based Veneer	length 2200-3150 mm; width 360 mm, from 620 to 700 mm

Please note that special dimensions can be manufactured on request.

Nominal thickness available /

Thickness	from 0,42 mm to 2,8 mm

Not all producs are available in all the above esthickness.

Dimensional Manufactoring Tolerances /

Width	-0 / +30 mm
Thickness	complies with standard ISO 18775 < 1,5 mm : +/- 0,05 mm; > 1,5 mm : +/- 4%

Wood Density /

450-900 kg/m3 (measured in compliance with standard ISO 9427) depending on the structure of each product.

ALPIlignum /

Formaldehyde Emission /

In compliance with E1 (analyzed according to EN 717-1).
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 impossible to guarantee a complete absence of traces of formaldehyde as this naturally occurs 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. Upon request ALPI is able to supply an Alpilignum version that, if finished with the correct finishing cycle can reach higher values than 4 on the grey scale (UNI EN 15187:2007).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 Grain /

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 temporarly- 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 /

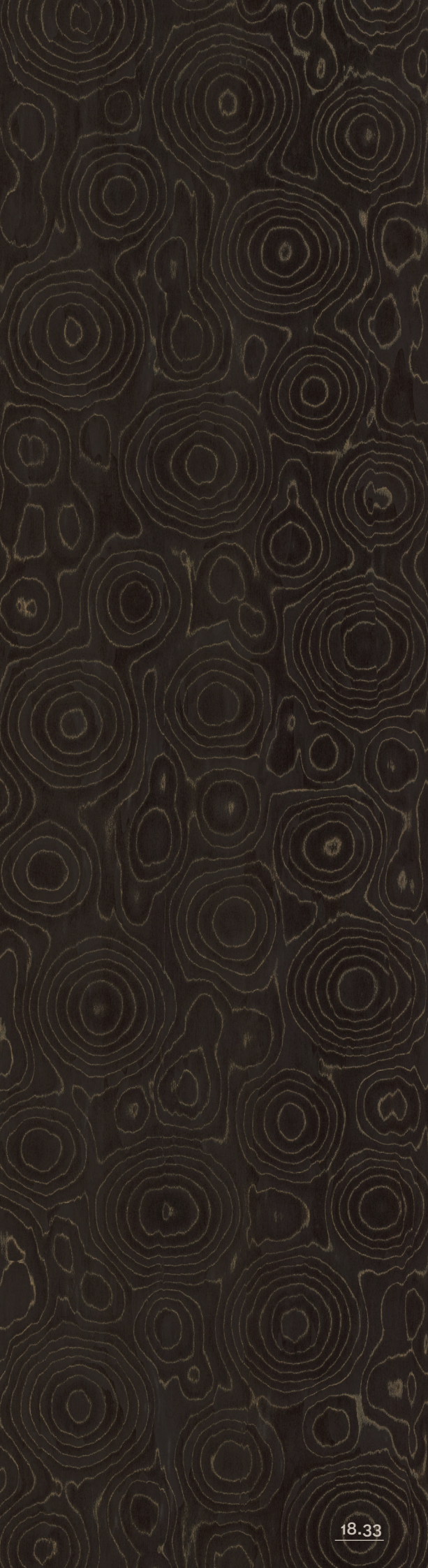
After the veneering process ALPIlignum must be sanded in order to prepare and clean the surface for the varnish application. This process must be carried out with 120-150-180 grit sandpaper in a single step or in sequence using manual or automatic sanding machines. The use of 100 grit or 220/240 grit 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

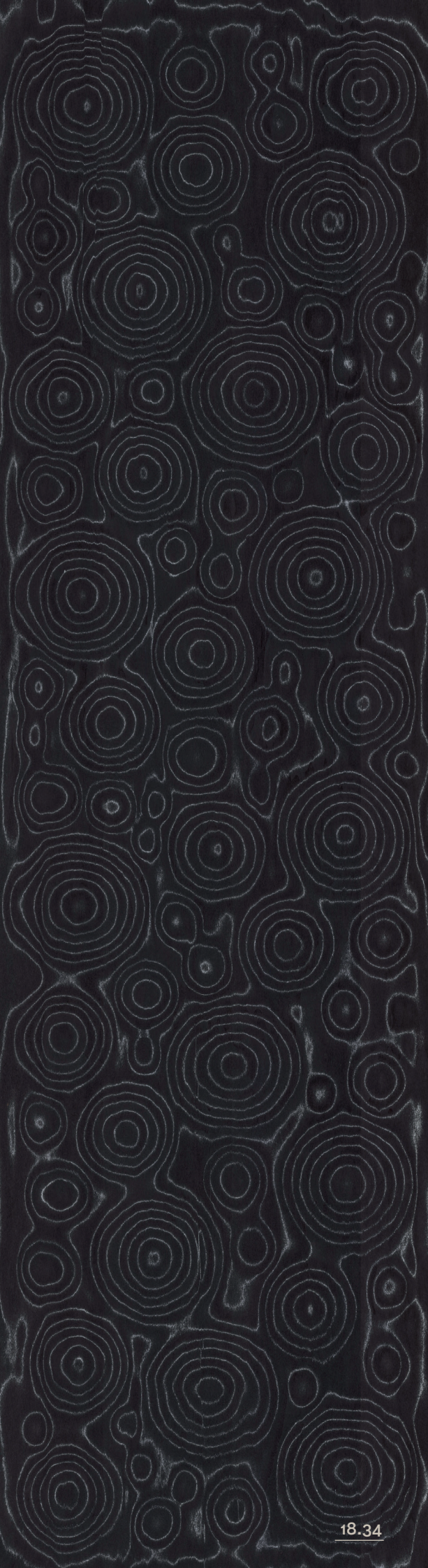
As for water paints, it is advisable to use products that are stable at a moderately acid pH (4-6), such as specific products destinated for acid hardwoods. It is common practice to follow the instructions provided by finish manufacturers and to carry out preventive tests before proceeding to varnishing.

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 complied from the current information held by ALPI and may be our best knowledge updated to perform the higher results of the applications.



ALPIlignum / 18.33

Collection Designer	Designer The Campana Brothers
Product	ALPI Sushi Brown
Texture	Design
Size	2200x620 mm



18.34

ALPIlignum / 18.34

Collection Designer	Designer The Campana Brothers
Product	ALPI Sushi Dark Grey
Texture	Design
Size	2200x620 mm

ALPIlignum /

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

Standard dimensions /

Poplar based Veneer	length 2200-2500 mm; width from 620 to 700 mm
Ayous based Veneer	length 2200-2500-2800-3150 mm; width 360 mm, from 620 to 760 mm
Basswood based Veneer	length 2200-3150 mm; width 360 mm, from 620 to 700 mm

Please note that special dimensions can be manufactured on request.

Nominal thickness available /

Thickness	from 0,42 mm to 2,8 mm

Not all producs are available in all the above esthickness.

Dimensional Manufactoring Tolerances /

Width	-0 / +30 mm
Thickness	complies with standard ISO 18775 < 1,5 mm : +/- 0,05 mm; > 1,5 mm : +/- 4%

Wood Density /

450-900 kg/m3 (measured in compliance with standard ISO 9427) depending on the structure of each product.

ALPIlignum Sushi /

Alpilignum Sushi is a wood venner with metallic effect powders.

Formaldehyde Emission /

ALPIlignum Sushi is without added formaldehyde. It is impossible to guarantee a complete absence of traces of formaldehyde as this naturally occurs in wood.

Light Fastness /

ALPIlignum Sushi is not a finished product and, therefore its resistance to light in part depends on the cycle and chemical nature of the finish. Upon request ALPI is able to supply an Alpilignum Sushi version that, if finished with the correct finishing cycle can reach higher values than 4 on the grey scale (UNI EN 15187:2007).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 Sushi 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 Grain /

Being a natural wood product, ALPIlignum Sushi 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, as the structure may vary from sheet to sheet.

Storage /

ALPIlignum Sushi 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 temporarly- 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 Sushi /

Veneering /

Glueing With Urea Glues

ALPIlignum Sushi 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 Sushi 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 Sushi 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 Sushi 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 Sushi 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.). ALPIlignum Sushi can be varnished with any product or method recommended for wood treatments. However, for this specific structure the best results are obtained by applying a first coat of two-pack water-based primer with a 70-90 gr/m2, then the other products indicated by the desired finishing cycle can be applied. Amongst the various classes of products, we recommend 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 destinated 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 complied from the current information held by ALPI and may be our best knowledge to update them,following new evaluations or new production systems. We reccomend the user to check the product suitability based on the finally application.