



*f.lli zangheri & c.*

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C.C.I.A.A. Rimini n. 146773  
Capitale Sociale € 52.000,00

*Ipir.*

## TECHNICAL DATA

PRECOMPOUND ZINGANA WOOD VENEER.

### Composition of the product:

Ipir precompound 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:

Models produced with Ayous

Panel size:

length: 250, 280, 310, 340 cm  
width: 65/75 cm

other dimensions are available on request

Door size:

length: 220 cm  
width: from 65 to 88 cm

Models produced with Poplar:

length: 220, 250 cm  
width: 65/75 cm

Thickness: from 0,50 mm up to 0,60 mm

Wood density: 600-900 kg/m<sup>3</sup> (depending on models)

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

### Recommendations for storage:

Avoid contact with water and other liquids.

The veneer must be shielded from direct and indirect light.

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



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### Recommendations for use:

- With urea 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.

Our Precompound wood veneer is safe for use as per European standards and does not fall under the category of volatile organic compounds.

### Varnishing:

IPIR precompound veneer can be varnished with any product recommended for wood treatments, considering that best results are achieved by selecting products having the following characteristics:

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

### Uses:

Precompound wood blocks and precompound wood veneers processed through steam and dryers are free from wood borers etc and no tendency to bend with change in temperatures gives them great advantages over unprocessed lumber and wood veneers.

Sliced precompound wood veneer and lumber for architectural wood work, high class furniture making and quality interiors. Due to its high strength and elasticity suitable for production of doors, chairs and seats. Used especially for gunstocks and aircraft propellers.

Traditional wood for upright and grand piano making. Burls veneers also used for interior of cars, luxury vehicles.

### Machining:

There is not difficulty to working this wood with all hand or machine tools. Precompound wood is excellent for moulding.

### Jointing:

Screw, nail and glue joints are easily made and of normal tensile strength. Alkaline glues, however, can cause reaction stains.



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**Warranty:** Our material has a warranty of manufacturing defects for one year. Being a wood based product, natural defects and pores have no warranty. Besides, we have technical production limits within which we can control our quality. Colour can vary up to a maximum of 7% for each batch of production from the colour of the original sample.

**Disclaimer:**

This technical data sheet is for guidance. Buyers must make their tests before proceeding with their production. No claim acceptable for our technical data.

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Cerasolo AUSA, Coriano (RN)