

MOSO BAMBOO VENEER - PROCESSING GUIDELINES

Moisture content

To meet the applying and installation conditions of the market, MOSO bamboo veneer is normally produced with a moisture content of 6-9%, which correlates with a relative air humidity range of 40-60%. To avoid moisture absorption during transport, the veneer sheets are protected in carton boxes with inside foil packing. During storage, the relative air humidity should not be out of the above mentioned range.

Pressing

MOSO bamboo veneer normally will be pressed on carrier panels (like chip board, multiplex, MDF / HDF). Both hot pressing and cold pressing methods can be used.

As a reference for hot pressing with most urea formaldehyde adhesives the following parameters can be applicable: temperature range from 80-130 degrees Celsius; pressing time from 1 to 3 minutes; pressure range from 10-15 kgr / cm².

The bamboo veneer and backing fleece can endure shortly temperatures of 200 degrees Celsius. Too long pressing times on high temperatures must be avoided to reduce the risk of decolonization of the veneer.

After hot pressing a considerable cooling time should be taken into account before stacking the cooling sheets. Do not start stacking before the sheets are cooled off below 60 degrees Celsius.

Commonly available industrial and non-industrial adhesives suitable for veneer pressing can be used. Depending on the glue type and carrier material a glue spread of 100-130 gr / m² can be taken as a reference.

MOSO bamboo veneer is suitable for processing to (finger joined) edge banding.

MOSO bamboo veneer is suitable for post forming and laminates bending pressing applications. For this type of processing normally unbacked veneer or 2 ply bamboo veneer sheets will be used. The cellulose backed veneer is not used for this type of pressing.

For each pressing method and press system it is advisable to consult your glue supplier and determine and fine tune the pressing parameters (temperature, press time, glue formula, glue spread, cooling down procedure related to press circumstances and carrier material) by testing.

Splicing:

MOSO bamboo veneer can be spliced with commonly used splicing machines. Depending on the thickness of the veneer, the glue applying amount and splicing speed should be determined. Before splicing, the bamboo veneer sheets should be cut exact and sharp to avoid bamboo tissue defects on the sides and to secure straight sides that easily can be connected and bonded.

Sanding

MOSO bamboo veneer normally is supplied pre sanded with a vacuum veneer sander to secure equal thickness and regular, smooth surface appearance (tolerance +/- 0.05mm). MOSO veneer pressed on a carrier panel can be calibrated/sanded. It is advisable to keep the veneer (including the cellulose backing) after sanding thicker than 0.4 mm to avoid transparent spots in the sheets. For special applications where thinner veneer than 0.4 mm is needed a special transparency check is needed.

Color grading

MOSO bamboo veneer is available in 3 basic colors: natural, caramel and, khaki. Each colour group is graded in a light, middle and dark tone to secure as much as possible colour consistency. Within the veneer sheets some lighter and darker strips can be recognized, which emphasizes a lively, natural look and should be considered as normal.

In case the still existing color variations within and between the sheets should be further minimized for certain applications, an additional detailed grading should be organized. For a good grading judgment, it is important to take into account that MOSO bamboo veneer is pre sanded and that the light reflection in relation to the sanding direction will influence the color appearance.

For additional support during operations, please contact:

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