

Edge and Surface

Processing instructions for structured boards



HOLZ IN FORM

The differences

Edge development of even structures with shallow pattern:

Even structures with shallow pattern:

2201 Wave	2417 Stone-S
2252 Schilf	2343 Mosaik
2261 Sisal	2390 Delta
2308 Seetang	2395 Python
2432 Groove	2422 Schilfgeflecht

Leave sufficient excess end while coating edges of the structured boards on a conventional edge banding machine.



Deep and narrow pattern:

2451 Split
2420 Stone-T
2468 Spalt
2430 Gneis

Refinish the excess length with a router. To avoid bunks chamfer 45° at the joint against your tools rolling direction and towards the surface.



Deep and broad pattern:

2344 Ocean
2369 Flame
2306 Dune
2450 Pluto

Use primarily small tool profiles for bevels or radius such as millers for 45° bevels or for 1.5 to 3mm radius.



Our diversity in structures: shallow structures, deep and narrow structures, deep and broad structures.

Albeit the basically identical edge and surface processing there are a few structural characters.

We would like to provide some insider information for optimal results. Please visit www.holz-in-form.info icon English - Products - or - Processing for references, data sheets, drawings and videos.

Grind the edge subsequently parallel to structure path with a sanding pad (ap. grain 100).



Finally clean structure oriented with a fine copper wire brush.





Edge development on deep and narrow structures

Leave sufficient excess end while coating edges of the structured boards on a conventional edge banding machine.



Refinish the excess length with a profile cutter. Use primarily small tool profiles. A ball bearing guide ensures a smooth tool guidance.



Use appropriate carriers to sandpaper narrow structures.



Grind the edge subsequently parallel to structure path with a sanding pad (ap. grain 100).



Finally clean structure oriented with a fine copper wire brush.

Edge development on deep and broad structures

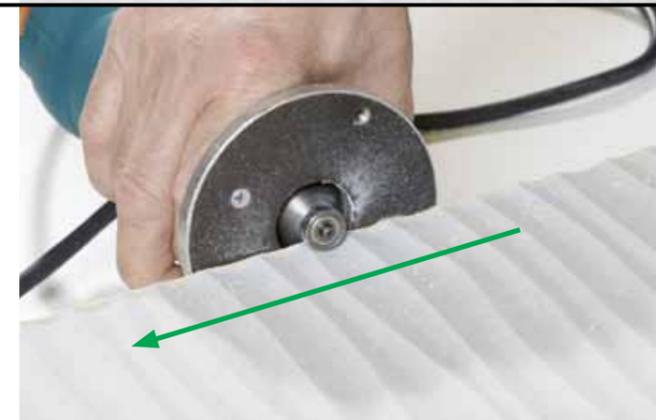
Leave sufficient excess end while coating edges of the structured boards on a conventional edge banding machine.



Refinish the excess length with a profile cutter. Use primarily small tool profiles. A ball bearing guide ensures a smooth tool guidance.



To avoid bunks chamfer against your tools rolling direction.



Finish the edge with a draw blade in a 90° angle to orientation of structure.



Finally clean structure oriented with a sanding pad (ap. grain 100).

Edge development of Spalt linear and Spalt fiddleback



Spalt linear boards don't really need edge banding however it is feasible (see page 4). After cutting for crushing and trimming the edge - here is how we do it: Mount 10 to 15 layers of sand paper face to face separated by washers on a thread bar and secure it with a nut at the end. Powered by a drill or cordless screwdriver this tool simplifies your finishing of our Spalt surfaces.



Finally clean structure oriented with a sanding pad (ap. grain 100).

Surface.

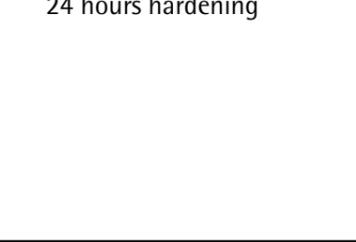
Polishing of the whole surface with sanding pads or wire wool (ap. grain 100) is essential before any lacquering. We recommend solvent one or two-component lacquer (clear and coloured). The drying time shouldn't be shorten by addition of dilutor agents as this could lead to weak integration with the ground and possible peeling. To much lacquer per run is subject to collecting in the slots and the different hardening times could lead to bubbles and/or cracks. In the lacquering process particularly the large sheets need to be placed holohedral to avoid deformation due to the weight of the boards.

Lacquering of veneered boards

Don't use water-based paint. We don't recommend mordanting Alpi-Veneers. If it is required to change the colour of the veneer add coloured pigments into the clear lacquer balanced of the lacquer system used.

Lacquering of boards coated with foil

Use water-based paint only in consultation with the technicians of Holz in Form.

Surface: dull	Surface: high gloss	Surface: dull	Surface: high gloss
Prime coat 	Prime coat 	Prime coat with slight prime filler 	Prime coat with thick prime filler 
↓	↓	↓	↓
grinding in between 	depending on veneer multiple grindings in between 	grinding in between 	grinding in between 
↓	↓	↓	↓
Finishing clear Lacquer 	Finishing 2 times with grindings in between 	Finishing 	Finishing 2 times with grindings in between 24 hours hardening 

You will find additional information on the different structures at www.holz-in-form.info icon English - Products - or - Processing, data sheets, drawings and videos. Please adhere the terms of the manufacturer for the lacquers you are using.



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Pictures: Patrick Pantze Images

Conceptual design: M. Lange-Gandyra

