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SEPTEMBER - OCTOBER | 2015 | Vol. 25 • No. 3

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STITCHWOOD

**IN HOME FURNITURE,
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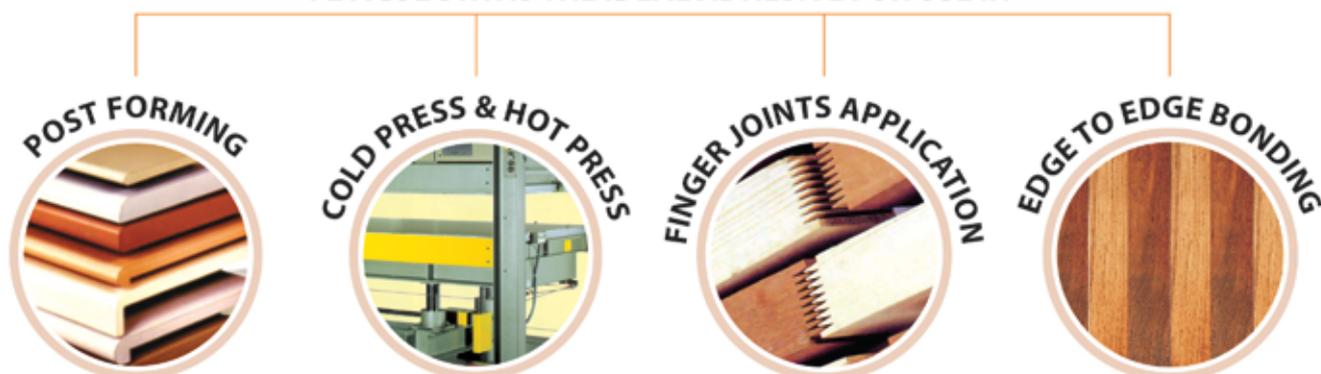
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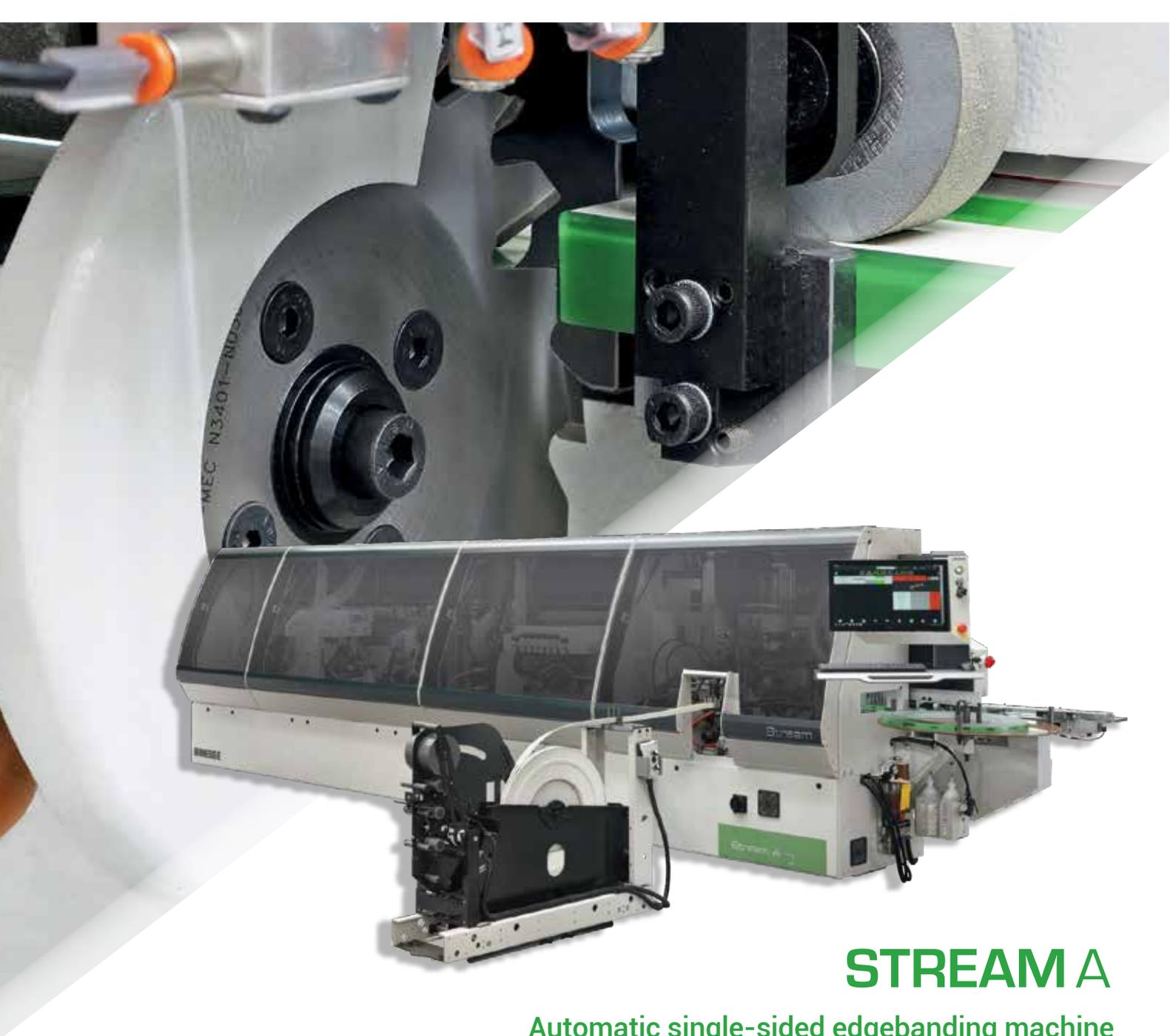
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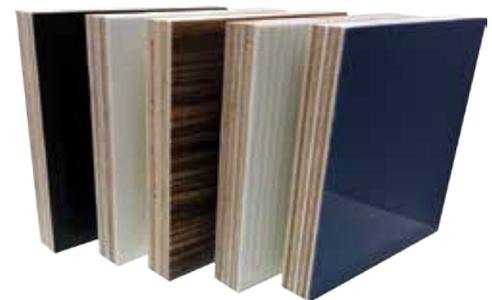
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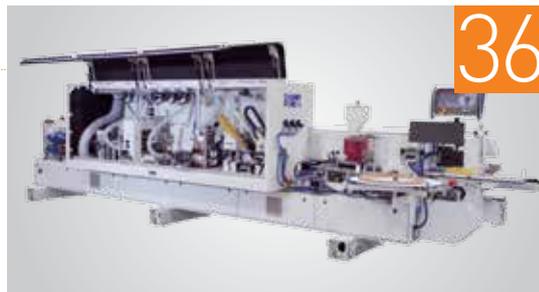
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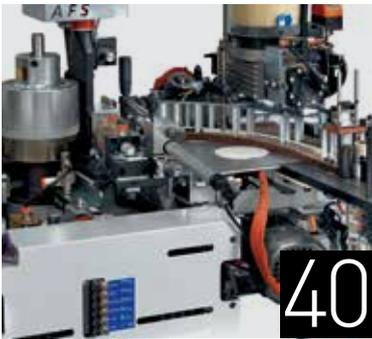
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Printed by:

Repromen Offset Printers Pvt. Ltd., Bangalore, India.

WoodNews is published bi-monthly by PDA Trade Media, a division of Pradeep Deviah and Associates Pvt. Ltd. Material from the magazine may be reproduced, in part or in full, only with prior permission and giving due credit to the source. Articles express the views of the authors, not necessarily those of the management. No responsibility is undertaken for the absolute accuracy of information published. All correspondence, including material for publication, may be addressed to the Chief Editor.

PDA
TRADE MEDIA

ISSN No. 0971-6734

PDA Trade Media, A Division of Pradeep Deviah and Associates Pvt. Ltd., 32/2 Spencer Road, Frazer Town, Bangalore, 560 005, India.

Tel.: +91-80-4250-5050 Fax: +91-80-2551-3078

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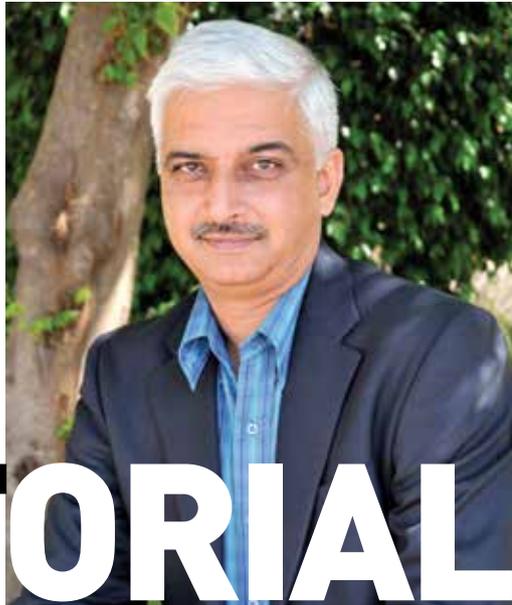
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EDITORIAL

On to MumbaiWood

Hello Readers!

As we head towards the second edition of MumbaiWood (1-3 October, 2015), *WoodNews* is glad to carry forward its largely successful exercise of bringing together the e-commerce furniture marketplace and manufacturers face-to-face, so that they can understand each other's requirements, assess each other's strengths, and exploit the opportunities to mutual benefit. At MumbaiWood, expect to interact with representatives from eBay, FabFurnish, Flipkart, Furlenco, Furniture Dekho, Pepperfry, Snapdeal and Urban Ladder.

Since we last met or spoke, there have been more e-retailers that are offering technology platforms to fulfil a large demand from end-consumers, and there is space for more! That is what I gleaned from my first detailed interaction with the founders of stitchwood.com, excerpts of which appear in this issue. There will be more such discussions in issues to come!

We have all heard of Canadian wood species, especially the ones suited to Indian climatic conditions and furniture-making requirements: Douglas Fir, Spruce-Pine-Fir (SPF), Western Hemlock, Western Red Cedar and Yellow Cedar. They can be easily milled, intricately carved and beautifully stained. The attractive grain, colour and strength of these species are to be seen to be believed! For a touch-see-feel experience, there is a unique display centre, right in the middle of Mumbai. And, going by my recent experience there, I can say that visitors to MumbaiWood must not miss that chance!

A recent development must certainly grab our attention: the Union Ministry for Environment, Forests and Climate Change recently proposed that degraded and depleted forest land be handed over to private entrepreneurs for intensive forestry, to meet the ever-growing demands of industry. The motive seems simple: bring scientific planning and processes to bear on making these neglected tracts productive. There will be apprehensions and opposition from many quarters of society; but how the whole scheme pans out remains to be seen. Needless to say the furniture industry must act to stake its share of such resources.

All that glitters is not gold; but a detailed understanding of how high-gloss and scratch-proof lamination film is made leads me to believe there are yawning gaps in quality between the good and the also-rans. There was a two-day symposium on adhesives and flat lamination that brought together 70-odd participants from across the country: very informative, to say the least! We bring you a glimpse into that event; and hopefully follow it up with detailed articles for the benefit of all *WoodNews* readers. Let's meet at MumbaiWood for more exchange of ideas!

Dhananjay Sardeshpande

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Opportunity knocks, once again!



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The second edition of MumbaiWood takes place at the Bombay Convention & Exhibition Centre in Goregaon-East, Mumbai, from October 1 to 3 this year. This is another great opportunity for architects, interior and furniture designers, builders and real estate developers, research organisations, training institutes and industry associations from the hospitality and export-import sectors.

After its successful debut in 2014, MumbaiWood has established beyond doubt that it is Western India's only trade show for machinery, technologies, tools, fittings, accessories and raw materials for furniture production.

It is now an ideal B2B platform for the industry's decision-makers to explore the latest manufacturing technologies and product innovation under one roof.

So what is new this time around?

The *WoodNews*-organised 'Sourcing Forum', to bring together furniture manufacturers and e-commerce giants – among them eBay, FabFurnish, Flipkart, Furlenco, Pepperfry, Snapdeal, Stitchwood and Urban Ladder – to identify business opportunities and join hands to exploit the huge domestic



market potential in wood-based furniture!

'Sourcing Forum', scheduled for 2 October (10.30 am to 5.30 pm) is now a well-planned activity and widely accepted platform, having proved its credentials at DelhiWood 2015, and again in Bangalore earlier this year. It has acted as a catalyst to the business, and several manufacturers have already benefitted from it.

This year MumbaiWood will provide a platform to 200 exhibitors, who have confirmed more than 15 launches of machinery, material, products and technologies!

Key information Venue:

Bombay Convention & Exhibition Centre (BCEC), also known as Nesco Grounds, Goregaon-East, Mumbai

Timings:

Thursday, 1 October:
10:30 am to 6 pm

Friday / Saturday, 2 & 3 October:
10 am to 6 pm.



Reasons to Attend

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- Stay up-to-date with emerging and changing trends
- Gain new ideas and insights to grow your business
- Engage with your industry community locally and globally

It will play host to more than 8,000 visitors, primarily from the Mumbai-Pune, Ahmedabad-Surat and Jaipur-Jodhpur manufacturing hubs, as well as the hinterland of Maharashtra, Gujarat, Madhya Pradesh, Goa, North Karnataka and Rajasthan.

Investment options

Here is what some prominent business consulting entities had to say about MumbaiWood and the way ahead for the furniture industry in Western India.

According to Mr. Marc Pfetzing, Senior Consultant with New Delhi-based Schuler Consulting, manufacturers have realized



that now is the time to take a step back and organize themselves, so that they can become a true force in the global woodworking industry.

In light of the new Union government's 'Make in India' campaign, he says, "This is definitely a positive development, which we embrace. From our experiences in other countries, we recognise it as indicative of Indian manufacturers wanting to be recognised."

According to Mr. T. Gopi of Bangalore-based WoodTech Consultants, the Indian woodworking industry is poised for high growth in parallel with the growth of the building sector (home and office). "The renovation business is also growing, and this offers ample opportunity for growth," he notes.

Business opportunities are in plenty for anyone in the woodworking field, according to Pfetzing of Schuler Consulting. "In recent times customers have become very quality-conscious; so if you are able to deliver a good quality product it





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would not be too difficult to find buyers," he says.

Furniture manufacturing opens new avenues for investors looking for niche markets and offbeat business opportunities. Says Mr. Santosh Ekbote of 360-Degree Consulting, "There are large, untapped possibilities in solid wood processing, door and shutter manufacturing, veneer processing, etc."

For Gopi, there is very good potential to expand as the growth rate in this industry is very high. "Since the growth potential is very high, it is indeed very attractive for new investors. There are plenty of opportunities to set up manufacturing of kitchens, office and bedroom furniture," he notes.

Product diversification

Door and shutter manufacturing for kitchens and wardrobes; wood-based sports equipment and musical instruments are worth considering. Flooring and wood windows have been largely untapped. Because very large capital is needed to be able to supply at competitive rates and large quantities, investors can tap into this segment.

Gopi says India has a huge demand for good raw materials; so new investors have a tremendous window of opportunity in either manufacturing or trading (export-import) in good quality



plywood, particle boards, MDF, veneers, etc.

Moreover, notes Pfetzing, many suppliers who imported furniture for their customers are starting to produce the furniture themselves. Not only are they striving to better the quality of imported furniture, they are able to offer better pricing and also earn more.

Ekbote attributes this to an ever-growing tribe of very quality-conscious consumers, who settle for nothing but the best.

Gopi seconds this observation, saying imported furniture has many limitations. The end user can only buy what is displayed, s/he has no choice to choose his/her own design, dictate his/her own dimensions, or even express preference for a colour.

Homemade furniture opens up a lot of options in terms of customisation in design, dimensions, colour, etc. Indian factories can handle customisation without any hitch, offer products at a lower cost, and drastically shorten the delivery time, he asserts.

E-marketplace

The entry of e-commerce companies with online sales platforms for furniture has forced manufacturers to rethink their positions in the marketplace. "They are beginning to understand the need to get organised," says Pfetzing, "The concept of high-volume production has never really been explored in India, but now it is a matter for serious contemplation!"

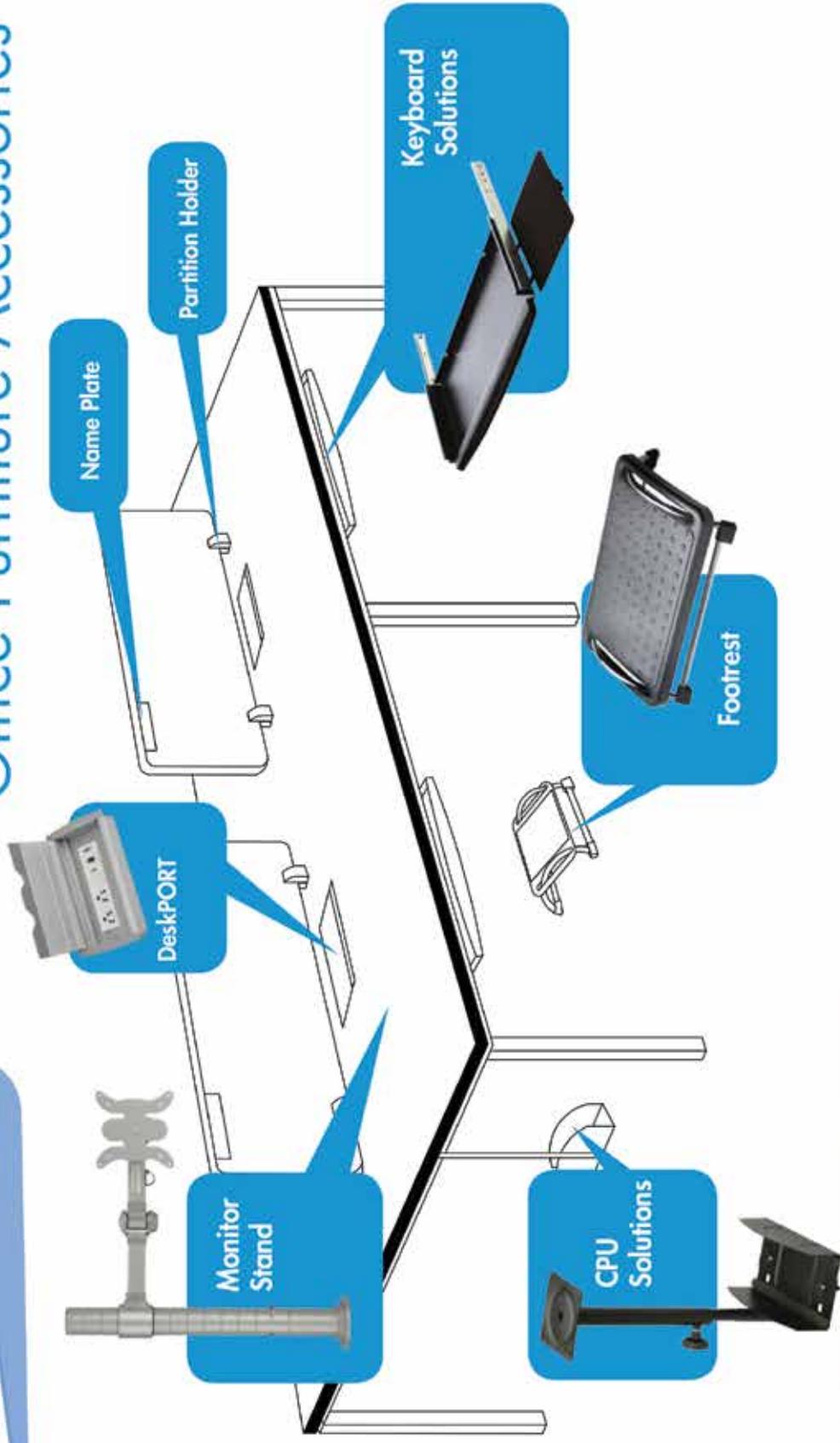
Gopi concludes: "These e-retail platforms are certainly a positive development for the industry. Apart from affording a pan-India presence, e-commerce is already motivating the industry to scale up production and upgrade technology."



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In home furniture, customisation is king

The latest entrant to the burgeoning furniture e-commerce space in the country wants to redefine “problem solving” and stamp its identity by offering its clients customised solutions, says **Mr. Ajit Shegaonkar**, who along with Mr. Vikas Nair, co-founded Stitchwood.com.





What is your background?

We are both mechanical engineers from IIT-Bombay. Later I moved to the United States, where I completed a post-graduate programme in the same field. Vikas went onto finish his MBA from IIM-Ahmedabad.

We were into investment banking and business strategy consulting for many years, but because we both have a penchant for problem-solving, we kept looking out for an opportunity to hit out on our own.

Why did you choose furniture for your online retail business?

The volume in the home furniture segment in India is to the tune of \$10 billion a year. Of this 80% is custom-made and relates entirely to the unorganised manufacturing domain. But the buying experience even in such a large segment is rarely good.

We (Ajit and Vikas) and our close friends also had some terrible experiences in finding good furniture when doing up our respective homes. Being problem solver at heart, this unsatisfactory situation set our minds into providing a better option to the thousands of buyers in the country.

Could you elaborate on the unsatisfactory experience?

By and large it is common knowledge that it is difficult to get good carpenters. There are the usual problems people encounter with such an unorganised sector of artisans: lack of quality, unscientific work methods, no adherence to timelines, inevitable cost escalation, etc.

In light of this, ready-made furniture seems a logical answer; but it is mostly not to most customers' liking. Interior designers are another option, but they don't work on piecemeal jobs. Moreover, their services are not always affordable.

Did you not occur to you that you could get into furniture manufacturing?

Yes, it did flit through our minds; but it is a different ball game altogether. Moreover, like I said, Vikas and I are basically problem-solvers. Instead, when we saw that such large and untapped resources were available, we realised we could help better by connecting manufacturers with the huge and growing market through our technology (e-commerce) platform.

How did you go about establishing your business?

We had earlier toyed with food and garments, but settled on customised furniture. We began by meeting furniture manufacturers, vendors, retailers and customers at trade fairs. We connected with woodworking machinery manufacturers to meet owners of factory-sized units around Mumbai-Thane, Jodhpur and the National Capital Region of Delhi, Gurgaon, Faridabad and Noida.

Then we identified vendors who could marry customisation to factory-scale production of furniture. We simultaneously brought on board our technology team to build our e-commerce platform. In about six months' time, the founding team was in place before we launched Stitchwood in March this year.

Are you planning to expand from your home base of Mumbai?

Yes of course. We now have a vast clientele in Mumbai-Pune. We have also started supplying in the National Capital Region and opened recently in Bangalore. We will definitely be upscaling our platform, adding vendors and expanding our clients list in other metros and cities very soon.

Additionally, the technology team will expand, and we will take on board more product and interior designers. We are a

Ajit Shegaonkar (left) and Vikas Nair, both IIT-Bombay alumni, decided to invest their energies to float a technology platform for the growing furniture segment.





Stitchwood is all about product customisation for its buyers and guided manufacturing for its vendors.

start-up, so team-building will be an ongoing exercise.

How did the name Stitchwood come about?

We are actually Tangramme Furnishing Solutions, but we needed ease of brand projection and recall. Although there is no such word in the dictionary as “stitchwood”, we decided our expertise in customisation of furniture would give it its definition.

Your web portal (www.stitchwood.com) shows a fairly vast mix of sofas, dining sets, wardrobes, stools, beds, chairs and benches. Where is the customisation?

Our designers have put together a collection of these furniture pieces. There are online tools by which our customers can customise the designs, right from changing arm styles for a given sofa design to choosing upholstery, or they can simply call or email or WhatsApp us with their customisation requirements.

Once our designers and vendors are convinced we can manufacture the required furniture unit, the customer is sent a virtual reality model and cost for the customisation before he/she can place an order. There is also a vast array of materials and finishes that the customer can choose from.

We also offer on-site visits to understand customers’ needs and deliver to specifications. Lastly, there is also the exchange model. We realise that people don’t want to buy new stuff until they can dispose of the old. We are offering to help them with that.

How do you choose your vendors?

Like I said, we began interacting with factory-sized units, private limited companies in the Mumbai-Pune belt, as well as in Bhiwandi and Navi Mumbai. Many of them were suppliers to established furniture brands; yet others were manufacturing for export houses.

We studied their technology status, checked their manufacturing history, assessed the capability of their proprietor and workers. We began by conducting pilot projects. Some of the failures can be seen here! (Ajit points to a dozen-odd sofas and chairs strewn around in a corner of the office in Andheri). If there was scope for improvement, we helped them; a few others we had to leave by the wayside.

How do you ensure quality?

We have on board trained furniture and interior designers from such institutions as the National Institute of Design in Ahmedabad. There is a team of quality control personnel that fans out to all our vendors for regular checks in the factories and reports to these designers. Remember, we offer a 3-year warranty to all our clients against structural or manufacturing defects!

What about institutional and commercial furniture?

There’s nothing to beat home furniture: it is so much more creative, challenging and dynamic! But yes, we are in the pilot project stage with some vendors for commercial furniture.

What about the logistics costs in this business? Isn’t that getting bigger?

Our main costs are maintaining the technology platform and establishment costs. Logistics really don’t bother us because 80% of our manufacturing for any market is carried out locally. For that reason, and because of our customisation, there are no costs of maintaining inventories or paying for warehousing.

How does Stitchwood really distinguish itself in the highly competitive e-commerce space?

Firstly, the other e-commerce companies have furniture as only one among many hundred categories. They work on a model where buyers and

vendors alike treat it like a market place: you bring your wares and the buyers pick out what they like or want.

We are a start-up, but we stand apart because we are only into customised furniture. Because of our product customisation for our buyers and guided manufacturing for our vendors, we interact with them (buyers and vendors) all the time.

Yes, the seniors have helped us learn many lessons, especially those relating to material, workmanship and quality. That said, there is plenty of space for more players in the furniture segment to exploit the market potential!

How have manufacturers benefitted from their relationship with Stitchwood?

We already have close to 20 manufacturers on board as partners. It might be too early to say more.

How has your experience been with IndiaWood, DelhiWood and the ‘Sourcing forum’ launched by WoodNews magazine?

IndiaWood, DelhiWood and the ‘Sourcing forum’ organised by WoodNews magazine have been very useful to us in terms of connecting us with manufacturing vendors. We hope they continue with this great work.

What would be your message for furniture manufacturers?

For some, I would say look at the bigger picture, at the large untapped market. For some others I would say take risks: success won’t come calling if you don’t do so!

- Dhananjay Sardeshpande

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Bewitching beauty

A touch-feel-see experience centre in Mumbai for wood species from British Columbia is a must-visit

International demand continues to make British Columbia, a resource-rich province of Canada, the world's largest exporter of coniferous wood. It is also a global leader in sustainable forest management.

The attractive grain, colour and strength of Canadian wood species are prized qualities in furniture manufacturing. Light coloured wood species offer the flexibility and versatility to be stained to resemble a wide range of lighter or darker coloured wood species.

Wood from B.C. is certified by credible, third-party independent forest certification standards such as FSC, CSA and SFI, among others. The CSA and SFI standards are recognized by the international Programme for the Endorsement of Forest Certification (PEFC) schemes.

The panelling in a bar display immediately brings out the beauty of the wood grain and its sand-tight knots.



FEATURE

Canadian Wood

Suitable Species

Canadian wood species can be used to create intricate, carved or contemporary designs to suit the customer's needs. The wood's properties make it ideal for interior uses, as well as the demanding requirements of windows and exterior door applications.

As consumption of wood increases in India, the Canadian province of British Columbia presents a viable and suitable alternative to increasingly scarce tropical hardwoods. Douglas Fir, Spruce-Pine-Fir (SPF), Western Hemlock, Western Red Cedar and Yellow Cedar have been identified as being particularly suited to Indian climate and in their various applications in interiors, outdoors and structural uses.

These species have density values lower than most hardwoods, making it easy to face-laminate, edge-glue and/or finger-join, to make large or small cross-sectional window and door elements. They are also ideal for wood interior design, mouldings, trim and other architectural decorative features.

Forestry Innovation Consulting India Pvt. Ltd. (Canadian Wood) is a not-for-profit market development agency for Canadian lumber. Its mandate is to lead research to identify new opportunities for Canadian wood products and companies in India.

In November last year FII-India inaugurated an exclusive audio-visual display centre featuring varied applications of their wood species and

new-age technologies in the wood business. The centre is spread across 1,300 square feet in the heart of Mumbai's commercial district.

FII-India's world-class team of wood experts can assist architects, interior designers, turnkey contractors, solid wood products manufacturers or real estate developers with technical advice: from choosing the right specie to the grade and size of lumber, depending on the intended use. All of this at no cost!

Charmed world

Entering the office-cum-display centre you are transported to a different world! The wall panelling is Western Red Cedar, the roof sports SPF panels, and the furniture is from impressively stained Yellow and Red Cedars.



SPF and Western Red Cedar adorn the roof and walls of the reception.



The conference room has a huge table and wall panelling fashioned out of Hemlock.



The Douglas Fir Room is so named after the use of the species in the wall panelling and table.

The latter are also suitable for the outdoors, being naturally resistant to termite and fungus infestation. The sand-tight knots in some of the panels – retained on purpose to demonstrate their durability and inherent beauty – become part of the grain and do not come off.

The adjoining two rooms are named after the wood they are furnished with! The Hemlock Room can seat a dozen people, has wall panelling and a huge conference table made from the species. The smaller Douglas Fir Room sports a table and stained wall panels made from that species.

Nearly all doors and door frames have been fashioned out of Yellow Cedar. Most office furniture and wall panelling also employs one of the xx species of Canadian wood suitable for Indian climatic conditions. What better proof of their dependability and durability?

The display centre has at its heart a pergola, outdoor decking, and a bar made from Yellow Cedar, Douglas Fir and other species. There is also an impressive array of doors, windows and home furniture – from dining sets to beds, tea tables and sofas to wall cabinets – all designed and made by Indian manufacturers!

To meet the team of FII experts, view Canadian wood species and check out exciting products made by Indian manufacturers, call 22-49221600 or write to rowena.desouza@bcfii.in.

On display is furniture designed and manufactured in various Indian factories, a true testimony to the adaptability and suitability of Canadian species.



All office furniture and storage units and wall panels are made from various species of Canadian wood.



Why wood is good!

By Dr. Satish Kumar

Since time immemorial wood has been a natural first choice for furniture and cabinet work and has been rightly so because of its eco-friendly nature. All period and traditional furniture was crafted from the choicest wood species; selection being based on its colour, dimensional stability, strength, immunity to insects, and figure.

Figure, which is obtained on cutting wood at different angles, carries more weight, especially for furniture that is polished using different types of transparent finishes. This feature is of little importance if the furniture is finished with translucent or opaque paint films.

Forest trees generally produce wood of high quality. However, such trees take a long time (50-100 years) to grow to proper girth to yield wide boards with unique figure. Teak, shisham, rosewood, walnut, etc. have been preferred for high class furniture.

However, with diminishing resources of these prized wood species, solid wood has been replaced by engineered wood-based panels especially in mass production of furniture. Moreover, such panels are less expensive, involve low labour costs in working, and can be surfaced with figured-face veneers produced from decorative wood species.

Recon veneers, produced from plain looking wood, have further reduced the costs of so-called decorative faced panels.

Wood availability

The total area under trees inside and outside forests is just 24% of the total geographical area of the country. The growing stock is estimated at 5,658

million cubic metres, a decrease of 389 million cubic metres over 2011 ISFR, as per the latest ISFR 2013. Wood stock in agro-forestry systems (trees outside forests) is around 1485 million cubic metres.

The total timber demand for timber in India was estimated at 52 million cubic metres per annum during 2010-2015; likely to exceed 150 million cubic metres by 2020 as per the International Tropical Timber Organisation's (ITTO) report of 2011. With local availability of around 29 million cubic metres – contribution of forests pegged at 2.38 million cubic metres – from recorded sources, around 6 million cubic metres were met from imports, while the rest came from unknown sources.

The local supply being static for the last several years, extra efforts are needed to generate sources as timber import is not a viable solution in the long term. Most of the forest wood available in the country is produced from thinning operations as per approved working plans (removal of extra trees to promote healthy growth of remaining trees) and dead trees. Almost all species growing in Indian forests are thus theoretically available, although in varying quantities in different locations.

Plantations have been raised in many countries, including India, to augment wood supplies for industrial use. The choice of species for plantation is based on local conditions and commercial returns. Most commercial plantations are being raised by farmers on marginal lands and periphery of agriculture fields.

Poplar and Eucalypts have been the most favoured species for plantation as the same can be harvested on short rotation (8-10 years) and fetch good price

because of their good demand in the plywood sector.

Teak, gamari, babul and kadam have also been planted in several locations; but they take comparatively longer to grow to usable dimensions.

Rubberwood, primarily raised for latex, is another source available with a rotation period of 20-25 years.

Future growth

With rapid economic growth, the purchasing power of the Indian masses has increased several fold. As a result, furniture has become an essential requirement in small towns and even villages, resulting in opening of many small enterprises across the country in recent years. While furniture sector requirement was estimated a mere 3 million cubic metres in 1992, its current requirement is around 10 million cubic metres, with a potential to touch 20 million cubic metres by 2020.

In addition to domestic requirement, there is a large potential of exports. Apart from traditional exporters of refurbished furniture in Rajasthan, Haryana, Uttar Pradesh, several e-retailers – Ebay, FabFurnish, FlipKart, Gulmohar Lane, HomeLane, Pepperfry, Snapdeal, Urban Ladder, etc. – have recently come up to meet domestic and international demands in recent years.

The online furniture market is estimated to cross Rs. 15,000 crore in the next three years, from the current Rs. 750 crore, with several upcoming players like Prismma, Saaraf Furniture and Woodenstreet, to name a few. MebelKart is another entity which has found favour with investors attracting investments of the order of US\$ 20 million in the current year.

As demands for furniture increase, supplies of wood are unlikely to keep pace with the growth. Several materials like steel, aluminum and different grades of plastics have already invaded the furniture sector. Cheap furniture manufactured from reconstituted panels is being imported to meet the increasing demands.

However, furniture from these materials (sometimes more expensive) has been considered as a cheap substitute and have found favour only in low-cost eateries, small restaurants, offices and rural areas.

Some products being based on raw materials coming from non-renewable resources also consume more energy during processing and are not rated as green substitutes. Wood, being a renewable resource and least energy-intensive – energy required for growth of trees comes free from the sun, a non-exhaustible resource – is the only green material.

Alternate materials

The Indian market has been flooded with low-cost furniture (imported as well as locally made) manufactured from petroleum-based plastics, steel and reconstituted wood-based panels. Steel and plastic furniture looks elegant for a limited period, losing its original shine and looks in a few years. Once damaged, it is impossible to repair such furniture (Fig. 1) in contrast to wooden furniture (Fig. 2)



Light weight plastic chair (non-repairable). Cost Rs. 300; residual value Rs. 20.



Poplar chair with leg base of babul after 20 years of service (current cost Rs. 2,500)

Use of reconstituted panels does help reduce wood consumption, but such use has been found to often be counter-productive. The major problem with these panels (mostly urea-formaldehyde bonded) is their early de-laminating. Being reversible, U-F bonds result in release of formalin, associated with a variety of health risks finally leading to cancer.

There are worldwide concerns about release of formalin and many countries have adopted very stringent codes about the same. Breakage of bonds and release of formalin leaves un-reacted urea in wood. Urea being hygroscopic in nature changes the moisture uptake behaviour of panels with fluctuations in atmospheric relative humidity.

The situation is worse in poorly ventilated areas: the moist wood becomes vulnerable to mold, decay and fungi, resulting in premature failure (Fig. 3, 4, 5).



Mold and fungus attack on drawer bottom made of U-F bonded 4-mm plywood.



Fungal decay invited termites to completely destroy the plywood panel.



Termite attack on commercial grade block-board.

The wide price difference in U-F bonded and P-F bonded board products prompts furniture manufacturers to go in for cheaper U-F bonded boards. There are BIS standards for these products and the market is flooded with BIS-marked products. The situation is very complex because even the high-value branded boards carrying BIS certification fail in service.

Emission concerns

The author provided consultancy to one leading manufacturer of panel products for imparting termite resistance to block-boards. The core battens were treated with controlled doses of Boron salts, just enough to prevent termite attack and maintain compatibility with PF resins.

Inspection of their stock in Bhubaneswar (Odisha), which was reported to have termite infestation, showed that termites did crawl over the board surface but did not damage a single board. Since Boron

FEATURE

Finding Alternatives

salts are systemic poisons, boards treated with such salts do not prevent contact of insects (Fig. 6).



Block-boards cut from the middle to show thorough penetration of Boron based preservatives.

Prevention of movement over wood surface is possible by using contact insecticides. Since block-boards are to

be used after further conversion at work site, Boron salts are the safest to use for products of this nature. Moreover, surface application is only temporary.

The author sourced some block-board (PF bonded) pieces from the factory and used the same for flooring, which are performing perfectly even after 12 years.

Formalin emission problems exist in use of particle boards as well. Another problem involved with reconstituted wood products (especially particle boards and MDF) is their poor screw and nail holding strength. Special screws and connectors are required to be used for using these products, which make them more expensive than plywood.

Of course, Indian manufacturers are aware of these problems and are

apparently keen to improve, but technical and cost constraints seem to be unfavourable to implement any improvements and solutions.



Dr. Satish Kumar

– The writer is an internationally known wood technologist and worked for several years at the Forest Research Laboratory, Oregon State University, Corvallis, USA. After earning his Master's degree in Wood Science & Technology from the University of California, Berkeley, he worked for several decades at the Forest Research Institute, Dehra Dun, in various positions. He now provides consultancy to government and private organizations, and can be contacted at satishkumar1940@yahoo.in.

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Back to basics, and then some more



National-level event in Bangalore throws light on PUR hot-melt adhesive, flat lamination technology

More than 75 manufacturers who attended the two-day seminar participated in the deliberations.

July this year saw an important event being organised in Bangalore for the benefit of the furniture and panel-making industry in India. Kleiberit Adhesive Technology, the world player in coatings and adhesives from Germany, paired up with Barberan, the Spain-based specialist in panel finishing and printing, to organise a two-day educational workshop.

Hosted by Kleiberit-India, the symposium on flat lamination and hot-coating had more than 75 important furniture and panel manufacturers from across the country in attendance. The audience was in rapt attention as half a dozen experts from Kleiberit and Barberan spoke about polyurethane (PUR) adhesives for industrial use; flat lamination technology, processes and machines; hot-coating technology, process and machinery.

The experts also answered questions about adhesives, addressed long-held misconceptions about them, and

provided solutions to problems in PUR, hot-coating and flat lamination.

WoodNews spoke with Mr. Wolfgang Hormuth, Kleiberit's Business Unit Manager for Industrial Adhesives, at the culmination of the symposium. What prompted the planning of such a symposium? Hormuth, who is not new to South-East Asia or the Indian sub-continent, puts it down to inadequate awareness and knowledge about glues and adhesives in the woodworking industry here.

Understanding glues

"The aim of this symposium was to bring about clarity in the Indian market about state-of-the-art technologies and materials in the wood-based furniture and panel manufacturing industry," he said, adding that he sensed several misconceptions and doubts about adhesives – especially PUR hot-melts – in his visits to IndiaWood, DelhiWood and tours of Kleiberit's clients' factories.

As an example, he quotes a recent visit to a big furniture manufacturer in South India. A few minutes into his discussions with the young owner of the factory, the proprietor called in his operators, production managers and even his retired father to listen in on Hormuth's presentation!

At the end of the prolonged session, this proprietor admitted that to Hormuth that his new-found, expanded knowledge about the chemistry of adhesives had made him grasp the implications of the material in his business, and placed him and his team in a better position to make informed decisions!

Although PUR hot-melt was developed by Kleiberit a decade ago, it took time for the value chain to mature: machinery to make its industrial-scale application viable, and end-users to accept its technological edge over other types of adhesives. But why the stress on PUR hot-melt in the symposium?

EVENT REVIEW

Kleiberit Symposium



Mr. Wolfgang Hormuth, Kleiberit's Business Manager for industrial adhesives.

"We believe in our slogan of 'Competence PUR'," Hormuth said. "We are into white glues in the Indian market too; but our forte here is PUR hot-melts for flat lamination, as well as profile wrapping for doors and (PVC) windows." More and more Indian factories are adopting hot-melt technology for flat lamination and profile wrapping; among them the Delhi-based Merino Laminates and Mumbai-based Prestige Interio Concepts.

Many apprehensions

What were the main doubts in the minds of Indian consumers? Hormuth points to some misplaced concerns about health and safety issues. "As you saw first-hand in the symposium, there were apprehensions about emissions of isocyanate and VOC (volatile organic compounds), which we dispelled here," Hormuth explained.

There were also doubts about the performance of PUR hot-melt. With detailed explanations of its correct nature and application – along with display of various incorrect and perfect samples – the Kleiberit team attempted to allay fears about the results of the technology.

On competitive pricing, Hormuth said: "We need to invest more in education to convince the Indian market. Once we do that, pricing will hardly be a matter to debate!" He added that the setting up of Kleiberit-India as a subsidiary indicated the German company's seriousness and expectations on doing business in the country.

Noting how Kleiberit had achieved great success in the European and China markets, Hormuth said the need for education becomes all the more imperative, given the fragmented and unorganised furniture-making industry in India.

Why the tie-up with Barberan for the symposium? The aim was to demonstrate the applications of the PUR hot-melt technology along with the flat lamination process. Without the correct machines and processes, the best of material may not yield the correct results.

So what holds India back? "You will be surprised that in technologically advanced countries like Malaysia, Indonesia and the Philippines, it is only Chinese and Indian managers and decision-makers that call the shots," Hormuth said by way of setting the record straight.

In conclusion he feels the new government at the Centre will make conduct of business in India easier. But, he stressed, it would be the end-consumers (of furniture) that would drive business decisions. "They will insist on quality, which will drive mechanisation and technology upgradation, and spur investments in this industry. They will demand innovation! The question we have to ask ourselves is: Are we ready?!"



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Taiwan manufacturers prove their mettle



Innovator Machinery's winner was this cross-feed veneer splicer for panel-sized veneer faces.

The country's biggest woodworking event in July drew 188 exhibitors, more than 6,000 international and domestic visitors

Since the last woodworking show in 2011, the machines on display at 'Wood Taiwan 2015' demonstrated that Taiwan-made machines are gradually improving their quality, aiming at better competing with other international high-end manufacturers, while offering more affordable prices.

The 'Made in Taiwan' machines were welcomed by nearly 900 international from more than 50 countries across the globe, mainly Malaysia, Japan, China, Thailand and Indonesia.

Many machinery manufacturers also received orders from countries in Asia, the Middle-east, Africa, India and other developed countries like Sweden, Russia, Canada and Australia. The orders are expected to touch 20 million New Taiwan dollars.

The Taiwan External Trade Development Council, the co-organizer, reached out to its 60 overseas offices and invited buyers from Israel, the US and Ukraine to join the one-to-one buyer meetings held during the show. This event achieved excellent levels, with over 80%

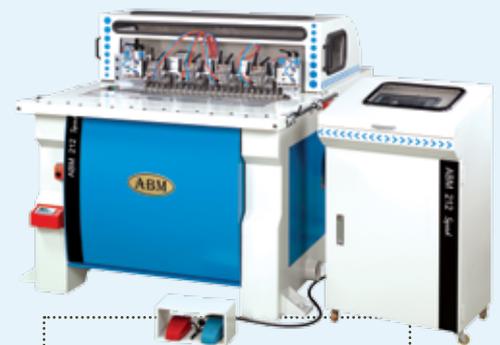
satisfaction among buyers, perceiving potential orders.

'Wood Taiwan 2015' sent out a strong image to the world, saying that Taiwan is capable of making high-speed automated machines with multi-task machining and smart sensor systems. These outcomes are expected to spur more innovative products for the next 'Wood Taiwan' fair, scheduled to be held in 2018.

Winners all

One of the highlights at the show was the 'Extraordinary Product Award Competition'. This year, amidst fierce competition, Co-Matic, ABM, ChampFond, Boarke, Innovator and Leadermac stood out as winners with their outstanding and well-designed products.

ABM's Speed-212 is a line boring machine configured with both horizontal and vertical drilling spindles group with 21 drill spindles each. The machining length of 640 mm suits most maximum length requirements of 21 holes on 32-mm centers (32x21= 640 mm).



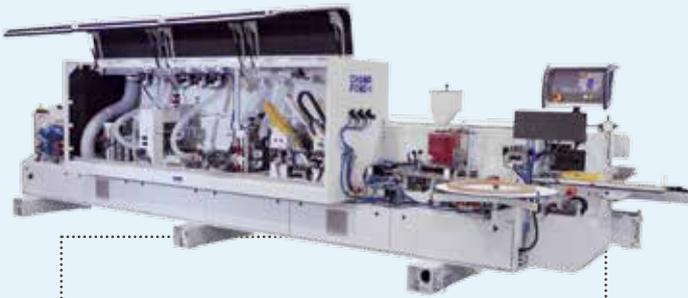
The Speed-212 is a PLC-controlled line boring machine configured with both horizontal and vertical drilling spindles.

It is a PLC machine and incorporates an independent pneumatic pressure system and is designed for easy adjustment. The controls retain customized modular batch programs and easily switches between job specifications.

This CNC uses servo motor feed that is comparatively superior to pneumatic cylinder drive used with semi-automatic processing. The price of the machine is very affordable because instead of CNC, the PLC controls on a traditional drilling machine provide great savings.

EVENT REVIEW
Wood Taiwan 2015

It doesn't require tool changes and, compared to CNC setups, it costs half as much, with up to three times the output. Plus, maintenance is simple and quick.



The ChampFond EL-800 is an edge bander with quick setup device features.

The ChampFond EL-800 is an edge bander with quick setup device features. Although a rigid, heavy-duty machine frame, its quick startup time for hot-melt glue system requires minimum standby time.

It comes with a precision hardened rail, dual material embedded chain pad, heavy-duty chain and high-tension steel pressure beam. The 3-position quick setup and 1.5-metre outboard support roller rain offer stable and continuous pressure force.

Innovator Machinery's UltiMate cross-feed veneer splicer is designed for glue-spliced joints for long and panel-sized veneer faces. Veneer bundles can be well-cut straight with double knife guillotines and then pre-glued on the edges as preparation.

The efficient production output of the cross-feed splicing machine is a great deal faster than longitudinal splicing machines, especially beneficial for long veneers. Veneers with the thinness as low as 0.2 mm can even be jointed with the UltiMate series.

The Leadermac Randomizer is a hand-scraped flooring machine that not only cuts the cost of labour, it increases production efficiency as well. It has eight automatic pneumatic scraping spindles driven by servo motors, with scope for adjustment of the inclined knife.

At the end of the out-feed brush wheels remove the wood chips from the flooring after scraping. The feed speed of the machine, movement speed and distance of scraping spindles, timing of the pneumatic jumping spindles are all controlled by PLC with touch-screen.

The feed rollers are driven independently by gear boxes tied in with an inverter motor. At the end of the out-feed a movable auxiliary control box and emergency stop switch increases convenience for the machine operator.



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Biesse launches 'Stream A'

The market demands a change in manufacturing processes, enabling companies to accept the largest possible number of orders. This is coupled with the need to maintain high quality standards while offering product customisation with quick and defined delivery times, as well as responding to the needs of highly creative kitchen designers.

Biesse meets these requirements with technological solutions that enhance and support technical expertise, as well as process and material knowledge.

At Ligna 2015 (Hanover, Germany: 11-15 May), Biesse launched Stream A, calling it the "new identity of edge banders". The company said the product was developed in response to the market demands.

"Biesse meets these requirements with technological solutions that enhance and support technical expertise, as well as process and material knowledge," said Mr. Stefano Bottene, Director of Sales & Marketing, Biesse India.

Stream A is the new range of automated single-sided edge banding machines aimed at medium to large sized enterprises who wish to increase their production capacity and flexibility. It seamlessly adapts to any machining needs, thanks to its configuration possibilities.

Machine structure

The sturdy structure guarantees the precision and reliability typical of production-line machines. The monolithic base provides high stability and allows the machine to operate over several work shifts while continuing to deliver high quality standards.

The sturdy 25-mm columns, fixed directly on the base, fully absorb all



vibrations generated during machining. Machine customisation depending on production requirements.

The machine gets its working units from the double-sided edge banding machines. There are 18 working units available, which can be combined and, in some cases, repeated, to obtain high quality, customised products.

Thanks to the advanced technology of some units, it is possible to manage endless machining positions; the machine adapts to the process being executed based on the edge's thickness and material.

Gluing unit

The Air Force system, as an option available on this machine, is based on the physical principle of convection. By using compressed hot air, the edge bonds perfectly with the panel, guaranteeing resistance to water and heat and an excellent, long-lasting, high-quality finish. No joints and no glue line, in perfect harmony with the panel.



As a standard feature, the machine can be used with hot melt glue and PUR glue on demand.

Pressure beam

The top pressure beam is specially designed and is a rigid structure. The rubber belt with stain-proof coating ensures no wheel marks on surface of delicate panels, especially when processing those for high glossy kitchens.



End trimming

The linear movement of this high-speed unit is perfect for delicate tapes or tapes with peel coat, because the copying system follows the panel without any sliding movements. Also, the shorter panel gap of 350 mm, is a revolutionary technology in respect to all the competitors. Hence, at the same track speed, Biesse's solution ensures higher productivity.



The fast, intuitive and user-friendly technology means that the edge banding machine management is 100% through touch screen, with no need for external devices. The 21.5-inch full HD screen guarantees optimal visibility.



(www.biessemanufacturing.com)

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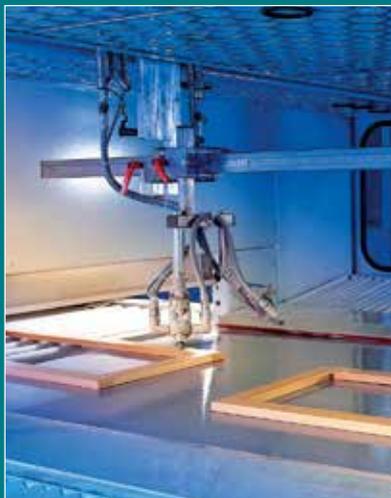
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Festool plugs into intelligent efficiency



Festool's "unplugged" cordless tool range adopts the brushless EC-TEC motor technology for optimal power usage, greater efficiency, and longer battery life.

Festool introduced its updated "unplugged" (cordless) tool range early this year, introducing a new generation of independence, lasting even longer and providing excellent results for sawing, drilling and screw-driving jobs.

The combination of 5.2-Ah high-performance battery packs and brushless EC-TEC motor technology ensures optimal power usage, greater efficiency and longer tool life. In addition, with the new PowerSelect selection system, Festool offers variants that are attractive and fair.

Cordless tools from Festool are concerned with more than just durability, precision and performance: they also place great importance on ensuring a balanced relationship between ergonomic work and intelligent energy efficiency.

Festool's product manager, Mr. Patrick Haußmann explains, "With our new cordless range, we are focusing on increased intelligence, increased



The new Syslite II work light ensures a perfectly lit workspace.

efficiency, and longer tool life." Festool is focusing on the intelligent interplay between its tried-and-tested brushless EC-TEC motor technology and the latest cell technologies.

"Our battery packs and tools have all been compatible for years. This applies across systems for older battery packs with NiCd and NiMH cells, which can be used in current-generation Li-ion tools," he adds.

Beginning January this year, Festool's PowerSelect option allows customers to purchase battery packs and chargers at a later date without any additional costs, so they can buy at their leisure as and when they really need to.

Its unique service all-inclusive package for its "unplugged" range includes: protection from repair costs and theft protection for 36 months, "risk-free purchasing" for 15 days, and a 10 year "replacement parts availability guarantee". A special feature here is that all of these services also apply to battery pack and charger accessories purchased at a later date.

Festool is represented in India by Mumbai-based Caple Traders (www.caple.in)



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ALTENDORF

GreCon adds ChiplInspector to panel-making tools



GreCon's ChiplInspector works to provide contamination-free wood chips by automatic separation of foreign objects.

For the first time ever, rubber can now also be reliably recognised and eliminated in the wood chip flow. The wood chip cleaner, ChiplInspector, presented for the first time at Ligna-2015, irradiates the complete raw material flow by means of a combination of low and high energetic X-radiation.

For the first time also, materials with the same area density – such as wood and rubber – can be reliably differentiated using this technology through the material-specific absorption behaviour of organic materials.

As the raw material is irradiated, it is possible to identify contamination in the material flow independent of the composition of the surface or the moisture content of the raw material.

The identification of the impurities also works for thick layers; with the ChiplInspector, it is not compellingly necessary to move into the thinnest position. Recognition is secure even if



The system for inline fibre quality control and refiner optimisation.

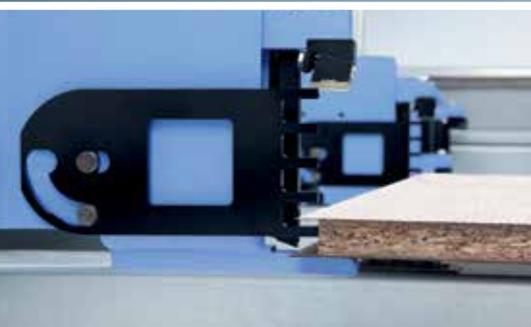
the impurities are covered by wood chips.

Through reliable identification and exfiltration of bits of rubber before defibration in the refiner, the risk of contamination of the board through rubber particles on the surface is significantly reduced.

GreCon's FiberView – already in operation with three major European wood-based panel manufacturers – allows an economical and objective assessment of the fibre quality in the running process. The measured values supplied by FiberView enable the operator of the refiner to produce a consistent fibre quality.

Using the patent pending FiberView, the cooking and refining processes can be precisely adjusted and the consumption of energy and the fibre quality thus be optimised. A saving potential of up to 10 kW per hour per tonne of wood that is refined can be calculated.

Being able to manipulate the fibre sizes in a determined and reliable way, the manufacturers of MDF panels are now able to produce specific fibre qualities. Customer requirements can be specified in such a way that an allowed number of shives per class per square metre can be determined. ▶



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Especially in the case of complaints, concrete data is available whether the fibre quality was sufficient or not. Such a degree of objectiveness has been unparalleled so far.

The next step is the regulation of the refiner via an automatic control loop. Thus, reaction times are reduced, and further cost saving potentials can be realised, thanks to faster adjustment.

FiberView is based on an imaging method: the surface of the passing fibre

mat is continuously inspected by a line-scan camera with vertical illumination over a width of about 400 mm.

The basic construction of the measuring system is a solid frame construction. The visual field of the camera is protected from dirt and dust by a closed tube. The system is equipped with an automatic height adjustment so that camera and illumination unit automatically adjust to changes in the mat height depending on the mat

moisture and, of course, upon product changes.

Thus, it is ensured that the surface to be inspected always lies in the focus of the camera and that clear pictures are taken. Furthermore, the illumination of the system is automatically regulated to compensate influences by colour from different cooking conditions or wood types.

German firm brings new spark extinguishing system



A spark detector installed at a blow pipe.

Fire and dust explosions are a well-known in the woodworking industry. The results are not only damage to production machines, dust filter equipment and silos, its consequences are also often disruption of costly production schedules.

The source of these fires are usually sparks that arise during the production process, in operations such as sawing, sanding and all kinds of machining.

The German company, Electronic Wood Systems (EWS), is introducing a new

generation of spark extinguishing system. The sparks will be seen by sensitive spark detectors which are installed in the exhaust pipes.

As soon as sparks are detected downstream of the airflow, a nozzle sprays a water pattern for a short time into the blow pipe, whereby the sparks will be automatically extinguished.

The installation costs for EWS' new version have been drastically reduced. The water required for spark extinguishing has also been reduced

significant, without losing its high efficiency, thanks to a new and innovative spray nozzle.

"In a broad view, this development can be considered as a spark extinguishing system with the potential to supersede previous technology in this field," the company said.

Electronic Wood Systems GmbH is based in Hameln, Germany. For more information visit www.electronic-wood-systems.com.

LOW COST SERIES CNC ENGRAVING MACHINES



LC-DS-1325

LC-DX 1325 CNC Engraver Machine

Description	Parameter
1. XY,Z Working Area	1300 x 2500 x 200mm
2. Table Size	1400 x 2700mm
3. XY Axis	Ball screw
4. Z axis	Rail Linear Bearings
5. Spindle power Motor	Ball Screw
6. Spindle speed	3.0kw water cooling Spindle
7. Driving System	6000 - 24000 RPM
8. Working Voltage	Stepper system
9. Command	AC220V/50/60Hz (optional: 380V 3PH)
10. Operating System	G code, M code
11. Collet	NC Studio (optional DSP System)
12. Software compatibility	ER16 Type3, UcanCam, MasterCam, Delcam And any other CAD/CAM Software



LC1325

LC-8'XA' - 6 Kw High Speed CNC

Description	Parameter
1. XY,Z Working Area	1500 x 3000 x 200 mm
2. Table Size	1300 x 3000 mm
3. Structure	Steel Base
4. XY Axis	square Guide ways & Rack and Pinion
5. Z Axis	Ball Screw and square guide ways
6. Max. power consumption	5.0Kw without spindle
7. Spindle	6.0Kw Italy Air cool Spindle
8. Max. speed	25,000 mm/min
9. Spindle speed	0- 18000 RPM
10. Driving System	Stepper system
11. Working Voltage	AC 350/220V/50/60Hz
12. Command	G code, "uoo, "mmg, "pl
13. Operating System	DSP System
14. Interface & Flash Memory	Printer Port 56pin and USB, 32MB
15. Collet	ER25
16. Software compatibility	Type3, UcanCam, MasterCam, Delcam
17. Gross Weight	2000KG (approx)

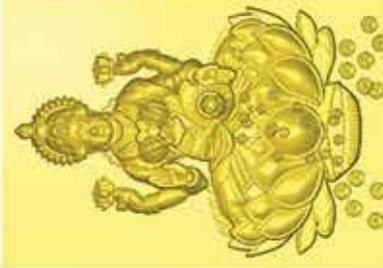
BRM-1530 DA Pattern Making Machine

Description	Parameter
1. XY,Z Working Area	1600x 1500x 600 mm (option 700mm / 800mm / 1000mm)
2. Table Size	1600 x 3100mm
3. XY heavy duty steel Structure	Rack and Pinion Drive, Hiwin Rail Linear Bearings
4. Z Structure	Ball screw and Hiwin Rail Linear Bearings
5. Max. Speed	30,000 mm/min
6. Spindle Power Motor	7kw air cooling Italy spindle
7. Spindle Speed	6000-24000 RPM (Electronic Fan)
8. Driving System	Japan Servo system
9. Working Voltage	AC 380V / 50 / 60Hz 3PH
10. Comm and	G code, M code
11. Operating System	DSP System
12. Collet	ER 32/Option / ER 40 / BT 30 / BT 40
13. Software Compatibility	Type 3, UcanCam, MasterCam, Delcam
14. Gross Weight	3000KG (approx)



1530 DA Pattern Making Machine

*service warranty 12 months on all models



LC-10'x5' - DUAL SPINDLE Signage 3D CNC

Description	Parameter
1. XY,Z Working Area	1500 x 3000 x 200 mm
2. Table Size	1875 x 3100 mm
3. XY Structure	Rack and Pinion Drive, Screw Ball, Hiwin Rail Linear Bearings
4. Z Structure	Ball Screw and Hiwin Rail Linear Bearings
5. Max. Speed	32000mm/min
6. Spindle power Motor	3.5kw Air cooling spindle
7. Spindle speed	6000 - 18000 RPM
8. Driving System	Stepper system
9. Working Voltage	AC380V/50/60Hz 3PH(optional: 220V)
10. Command	G code, M code
11. Operating System	DSP System (Mach3 PC Software)
12. Collet	ER25
13. Software compatibility	Type3, UcanCam, MasterCam, Delcam
14. Gross Weight	2500KG (approx)



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Note : All above parameters subject to change without prior notice.

*conditions Apply

Hettich's SlideLine 56 a cost-effective, space saving solution



What is the one thing almost all home owners crave? Answer: More space! Space is always an issue in city homes, especially when your clients have growing families. Upgrading to a bigger home is not a financially apt option for all; so you need to get innovative with their décor and create space, or at least the illusion of space.

This includes using space-saving, innovative techniques, prime among which is the sliding door. As any interior decorator will tell you an uncluttered view of the floor gives a greater impression of space. For wall cabinets you have a variety of option of sliding door styles to choose from.

Why, Hettich, one of the leading international brands in sliding doors, has numerous options for different interior preferences, which are easy and quick to

install. While most will roll their eyes at the mention of sliding doors, we are not talking about the old-fashioned channels that would jam or warp after some time.

Economical option

Welcome to the new-age sliding doors which gently slide or practically glide and close with a hush. Besides, with an international brand like Hettich, which comes with the backing of German technology, you can be sure that there will be none of the hitches that are commonly associated with the traditional sliding doors.

Also, when it comes to making a style statement, nothing can beat the Hettich sliding doors. Without compromising on quality, Hettich has introduced the economical bottom-running SlideLine 56 sliding door system.

Priced at an MRP of Rs. 2499 only (kit with four tracks of 2 metres each), it is also available in 3-metre variant. The identical top and bottom panels are provided with two routed grooves that cut-to-length aluminium profiles are pressed into.

The system is particularly versatile and can be fitted with adaptive Silent System soft-closing. The SlideLine 56 sliding door system is suitable for universal application for every furniture segment, including standalone free-standing (not inbuilt) wardrobes, and is the perfect solution for niche and cavity space as well.

SlideLine 56 is extremely easy to install and allows for uncomplicated and straightforward handling in everyday use. At the same time, any sliding door unit that uses SlideLine 56 adds a feel of luxury because running action is particularly smooth and quiet.

Hettich's innovative technology produces superior solutions to meet the requirements for every home owner. They not only meet the style quotient but provide space saving options as well. It's all about creating more room for your clients!



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Wood Working Machines



Multi Boring Machines

Leitz has specialists for all jobs



The Quattroform tooling system combines four profiles.

Furniture manufacturers currently work with a mixture of completely different edge materials and thicknesses. With batch sizes constantly becoming less, the mixture of materials can only be handled efficiently by super-fast profile changing for the edge refinishing process.

Machinery manufacturers have responded to these requirements by producing a new generation of edge refinishing aggregates. The tools for the majority of these aggregates are from Leitz, according to Mr. Andreas Kisselbach, Head of Research and Development at Leitz.

Most recently, Leitz engineers designed the Quattroform tooling system for the Holz-Her turret mill aggregate. It combines four profiles, as the aggregate is designed for high flexibility to satisfy medium output quantities.

Customer use has shown that the greatest strengths of the new tool are the automated profile change without tool change, its high processing quality and the low-noise during operation. A patent has been applied for by Leitz for the Quattroform tool.

For all other manufacturing steps in furniture production, Leitz customers can select from a large range of different tooling systems – both in through feed- and for stationary situations. Additionally, Leitz equips Biesse, Brandt, EBM, Fraval, Holz-Her, Homag, IMA, Ott and SCM-Stefani milling aggregates.

“We have specific tooling solutions for nearly all machines, materials and procedures for furniture production,” said Kisselbach. “The optimal processing quality with the highest possible efficiency tool variants are available according to the desired production volume.”



Zero-joint finishing in panel edge banding is possible using the WhisperCut.

When edge banding panel materials, zero joint technology is a focus. Quality starts with sizing. Here users have the jointing cutter WhisperCut and WhisperCut-Plus as well as the EdgeExpert programs at their disposal. For processing panels with conventional melamine resin coatings, Kisselbach recommends a WhisperCut jointing cutter with standard cutting geometry.

In contrast, panels with high gloss decors or very thin paper coatings are better to be processed by EdgeExpert tools with their increased shear angles. Depending on the required production output, different processing concepts have been developed.

Optional pre-cutting could be made by DT Plus hoggers or jointing processing could be divided over several spindles, thereby increasing the performance times of the jointing cutters.

Leitz provides a comprehensive program of circular saw blades for cross-cutting. For every conventional machine aggregate a suitable version of blade exists. A completely new design of the toothed ring reduces the noise of the circular saw blades.

In practise the new LowNoise cross-cut saw blades have proven to be up to 10 dB(A) quieter than the standard ones – this means halving the sound volume.

Thus Leitz provides both a simple scraper for multi-purpose requirements and also the Duo Multi-Profile scraper for high-gloss materials. Both of the scrapers have an anti-stress whitening bevel as standard and so supply smooth and colour-fast edges.



The new design of the toothed ring reduces the noise of the circular saw blades.

The Felder-Group Family

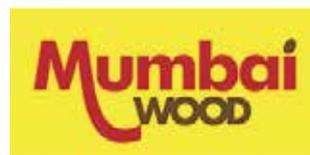
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WPC extrusion machine Woodplex launched



Rajoo Bausano Extrusion Pvt. Ltd. is one of India's leading manufacturers of plastic extrusion machinery. In 2010 it entered into a joint venture with Bausano & Figli of Italy, to manufacture and market pipe and profile extrusion lines, including wood-plastic composite (WPC) profiles in India.

The JV is a blend of Bausano's pioneering technology and Rajoo's best-in-class infrastructure.

The WPC extrusion machine comes in a range of capacities (200 kg/hr to 1200 kg/hr) to manufacture profiles and boards that would use up to 80% of wood powder. Construction, flooring, furniture and decking companies are expected to

significantly benefit with the deployment of these machines.

WPC applications range from non-load-bearing applications such as decking, railings, window frames, porches and docks in buildings; garden furniture and fences; outdoor flooring; noise barriers and sheet pilings for landscaping.

Indoor, WPC products are used in doors frames and profiles; cupboard legs and kitchen cupboard frames, chairs and window sills. It can also replace MDF in areas of high humidity.

WPC has demonstrated good mechanical properties and high dimensional stability, even in long life cycle applications. It has excellent thermal properties, low moisture absorption, and is resistant to swelling or shrinkage.

It is also termite- and borers-proof, as well as water- and fire-proof.

New 'Start 45' from Altendorf



The new Altendorf 'Start 45' is priced under Rs 5 lakh.



High performance cuts in various materials rendered with ease by 'Start 45'.

Manufactured in Europe for Wilhelm Altendorf, Germany, the model 'Start 45' is the latest addition to Altendorf's stable of panel saws.

This heavy duty and sturdy, entry-level machine has all the basic features for cutting panels, solid wood, plastics,

composites and even aluminium extrusions.

The machine is manufactured to the specifications and quality standards of Altendorf. Priced under Rs 5 lakh (taxes and transportation extra), the 'Start 45' is value for money.

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Blow Detection CONTI-SOUND on Panel Board Production Line

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Wood-Mizer walks tall in Asian high production sawmilling arena



Wood-Mizer's powerful LT70 42-HP turbo-diesel portable sawmill.

Wood-Mizer's high output sawmilling range is in the spotlight – the company is offering high production sawmilling solutions across both its portable Orange and Green industrial ranges.

Wood-Mizer's focus on leading edge thin-kerf, narrow bandsaw sawmilling technology has provided countless emerging and established saw millers from around the world with the tools to run successful businesses in competitive timber markets.

A number of recent product launches together with proven tech in Wood-Mizer's high production green and orange ranges have highlighted the solutions that customers can tap into to grow their businesses to the next level.

The **LT70** range is a popular choice for existing Wood-Mizer owners who now need higher production levels, and also by entrepreneurs who realise the value of the increased productivity, yield and returns generated by the technology.

The LT70 head carries 600-mm diameter belted wheels and travels along the static bed on a single column mast, which ensures easy alignment and accurate, flat cutting. The bed is available in various lengths to handle logs from 4.8 metres to 8.4 metres.

Log handling options, together with standard features like LubeMizer and

extras like a debarker unit, combine with powerful Accuset or PLC computer Setworks to provide for increased productivity and higher profits.

Electric, petrol and diesel engine options are available for the LT70.



The new WB2000 wide band sawmill offers 6 tonnes log capacity and a massive 900-m throat opening.

The 2014 launch of Wood-Mizer's **WB2000** wide band mill has delivered a sawmilling solution that combines the best that narrow and wide-band technologies have to offer.

The heavily constructed WB2000 offers massive log processing capacity (6 tonnes/1000-mm diameter) and a range of features that makes it easy to process large logs quickly and efficiently.

Electronic Setworks and a raised operator control station allow a single operator to manage all sawing and hydraulic log handling functions while maintaining a clear view of his work. The advanced PLC Setworks display key parameters such as board and cant sizes, current head height, feed position and blade power.

The WB2000 can work as a standalone unit or as part of an existing business to process irregular logs, or to produce custom orders that the existing equipment is not suited for.

One of Wood-Mizer's most recent high production machine launches has been the HR700 large capacity, heavy-duty multi-head resaw. In its maximum six-head configuration, the **HR700** converts large cants into six boards and one slab in one pass.

Its solid sub frame plus heavily engineered features like the twin-track steel belt conveyor and heavy powered rollers are ideal for large, heavy and tension-filled cants measuring up to 400x 400 mm.

A separate control stand holds all controls for the resaw.



The HR700 horizontal resaw offers modularity and larger capacity for high production timber processors.

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euroTech introduces Gripper range



The Gripper for lifting of smooth, rough sawn and uneven structures.

euroTech provides handling and transport solutions in the area of vacuum technology, developing customer-specific vacuum systems and components for automated handling tasks.

The euroTech modular construction system enables flexible adjustment of

the components to the corresponding customer requirements and fast and cost-saving exchange of replacement parts.

The Gripper range is positioned as an alternative to suction plates, flat suction cups and suction carpets. With the new material-efficient light metal profiles,

the suction boxes in the Gripper range are now around 30% lighter.

With its compact design and optimised arrangement of flow limitations, the Gripper offers the maximum in suction air rates. With construction widths from 80 mm to 250 mm and flexible length dimensions, the suction boxes are highly versatile. They can form part of both a portal and a robotic solution.

Suction boxes from euroTech are suitable for frequently changing surfaces, they are capable of handling smooth, rippled and uneven structures. The new suction boxes can also be retrospectively equipped with the requisite tools. Wear parts can be exchanged quickly and cost-efficiently.

Multiple suspension and fastening options can be realised as interfaces for adaptation to the user's system, along with a wide range of suitable fans, pumps and ejectors for vacuum generation.

The modular and manageable device configuration, with just a few parts and low tendency to wear, makes the suction boxes from euroTech efficient tools in handling technology.

Blum's hinge provides 107° solution



Hafele has introduced Blum's innovative hinge solution: The Clip-Top Blumotion in a new opening angle of 107°. The new solution comes with all the components needed for a soft and effortless closing integrated into the hinge to offer the right solution for every door.

These simple yet technically intricate soft-closing hinges can be used for a wide range of cabinet applications. If the cabinet doors are smaller or lighter, the soft-close Blumotion feature can be simply switched off, thus ensuring that

all doors – regardless of size, weight and closing speed – will always close softly and effortlessly.

Hafele's existing range of Clip-Top Blumotion hinge solutions includes hinges with an opening angle of 110° and 95°. While Blum's current 110° Clip-Top standard hinge is suitable for a door thickness of approximately 24 mm, the boss drilling depth of the new Clip-Top 107° hinge is an impressive 11.5 mm and can be used for a door thickness of 15 mm or more, thus providing greater flexibility.

Additionally, the Clip-Top 107° solution brings with it the infamous tool-free attachment with Blum's tried and tested clip technology and the proven 3-dimensional adjustment technology.



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 **BIESSE**

New design option for Blum's larder unit



There might be little space available, but the Space Tower unit uses every inch of it, here with Tandembox Antaro inner pull-outs.

The unit is extremely flexible and can even be used in bedrooms for hanging items of clothing with pull-outs for T-shirts.

A larder unit that offers plenty of storage space, whose interior can be tailored to individual needs and that provides easy access from all three sides – that's the Space Tower by Blum.

Blum's larder unit now comes in a new design: Legrabox free. The glass design elements provide clear visibility from all three sides. And if your client wants to open handle-less fronts with ease, opt for Blum's mechanical or electric opening support system.

This gives your client the possibility to harmonise the design of his/her entire home and the freedom to individualise cabinet interiors. The result is a light and transparent look, giving the users even better visibility of contents.

Blum's practical Space Tower larder unit – with a door and flexible inner pull-outs – can be manufactured in any height, width or depth. All the fittings needed for the Space Tower unit either stem from the standard Tandembox range or from Legrabox.

The flexible Ambia-Line or Orga-Line inner dividing systems make sure that contents are held securely. Thanks to full extensions, users have clear visibility and easy access to items. Up to 55%

Blum will launch the new box system, Legrabox, in India by the end of 2015. Blum has consistently maintained its strategic orientation in the 2014-15 financial year with the development of new products and services, such as the Aventos HK-XS and Cliptop Blumotion 107°.

more storage space can be created with higher side walls.

Each individual Space Tower inner pull-out has a loading capacity of 70 kg and, thanks to integrated soft-close Blumotion, all the pull-outs close softly and effortlessly.

The larder unit can be equipped with Blum's Servo-Drive electric opening support system, or the Tip-On mechanical opening system, which also brings one-touch opening to the handle-less larder unit door.

When assembling Legrabox and Tandembox, no special cutting dimensions are needed for base and back panel. The fronts can also be simply clipped on. In addition, the fronts can have any design: even doors with glass infill are possible.

Blum's Dynalog planning software helps you determine the right position of fittings with ease. The software also helps you order the right fittings components for the Space Tower unit quickly and efficiently.

Opt for the Cliptop 155° zero protrusion hinge, so that your client can use the entire cabinet width.



The Legrabox free, with glass design elements, produces a light and transparent look, giving users clear visibility of contents.

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Low-cost edge banders from Jai stable



Jai Industries' J-5100PRc.in is an auto edge bander with pre-milling and round cornering capabilities. It is a sturdy built heavy-duty machine to suit Indian working condition for precise application of edge banding material with round cornering.

It is Jai's advanced-technology, highest-features and best-price machine for edging the required materials of veneer, melamine, PVC or ABS to the linear edges. Model with round cornering (J-5100Rc.in) also available.

Salient features:

- High performance machine with feeding speed of 14 m/min gives more production. Very easy to operate & nominal setting required during operation.
- Robust feed chain-and-conveyor system with German gearbox (with long life synthetics lubricant) for effective pressure on small /big panels.
- It has a specially designed tank that consumes less glue.
- Three edge banding pressure rollers actuated by pneumatic cylinders and gas spring give adequate pressure on edge for effective banding.
- High frequency Italian motors sliding on prismatic guide ways for perfect finishing with trouble-free performance.
- All electronic and pneumatic parts are from well known international

brands, such as Schneider and Pneumax.

- Easily accessible, user-friendly PLC touch-screen control panel positioned at machine in-feed, for quick operations.
- No setting required to change thin to thick PVC edge band.
- Low maintenance machine, easily available cost-effective spares with best service support.
- Easy selection to change over in control panel as per profile.
- Rounding of edges on straight, chamfered and simple post formed 50-mm thick panels up to 3-mm edge banding thickness.
- For full rounding, edge banding thickness should be 1mm.



Trimming, rounding, cutting unit:

Compact and powerful, it guarantees great finish on edge. Trimmer 2R cutter for PVC/ABS gives perfect rounding on straight, chamfered and regular post formed edges. Always the best finishing on all operations, using high frequency motors (12,000 rpm) sliding on prismatic guide ways.



Pre-milling unit: This is an optimal unit for panel edge pre-milling with two high-frequency motors. Individual pneumatic cylinder for perfect preparing panel for gluing. Smoothen panel for achieving perfect joint line of the edge.



Edge scraping unit: Gives the best finishing touch to the PVC/ABS edges, ▶



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PRODUCTS AND PROCESSES

leaving no trimming marks on the job. Unit completes with rotating copiers.

Technical Specification	Unit	J-5100 PRc.in	J-5100Rc.in
Work piece thickness range	mm	10 - 50	10 - 50
Min. work piece width / length	mm	90 / 90	90 / 90
Edge banding thickness for PVC & ABS in coil form	mm	0.4 - 3	0.4 - 3
Workpiece feed	m/min	14	14
Pre-milling motor power	Nos/HP	2 x 2	n/a
Trimming motor power	Nos/HP	2 x 1	2 x 1
Buffing motor power	Nos/HP	2 x 0.5	2 x 0.5
Working temperature range	°C	180-200	180-200
Air pressure required	kg/cm2	6 - 7	6 - 7
Glue pot capacity	kg	1.5	1.5
Total power	HP	11.5	7.5



The **J-4700.in** is an auto edge bander precision machine at lower investment and operational cost, which improves production, quality and profitability.

Salient Features:

- Sturdy built heavy-duty machine to suit Indian working condition for precise application of edge banding material.
- Robust feed chain-and-conveyor system with German gear box (with long life synthetics lubricant) for effective pressure on panels.

- High performance machine with feeding speed of 14 m/min gives more production.
- Innovative pre-melting glue tank system consumes less than 50% glue compared to other edge banders, which results in increase in profits.
- Three edge banding pressure rollers actuated by pneumatic cylinders and gas spring, gives adequate pressure on edge for effective banding.
- High frequency compact Italian motors sliding on prismatic guide ways for perfect finishing with trouble free performance.
- All electronic and pneumatic parts are from well known international brands such as Schneider and Pneumax.
- Very easy to operate and nominal setting required during operation.
- Also available J-4700P.in model with pre-milling unit.

Specification	Unit	J-4700.in	J-4700P.in
Work piece thickness range	mm	10 - 50	10 - 50
Min. work piece width	mm	100	100
Min. work piece Length	mm	120	120
Edge banding thickness for rolled edges	mm	0.4 - 3.0	0.4 - 3.0
Workpiece feed	m/min	14	14
Pre-milling motor power	No/HP	n/a	2x2
End cutting motor power	No/HP	2 x 0.5	2 x 0.5
Trimming motor power	No/HP	2 x 1	2 x 1
Buffing motor power	Nos/HP	2 x 0.5	2 x 0.5
Air pressure required	kg/cm2	6 - 7	6 - 7
Working temperature range	°C	180-200	180-200
Glue pot capacity	kg	1.5	1.5
Total power	HP	7.25	11.25

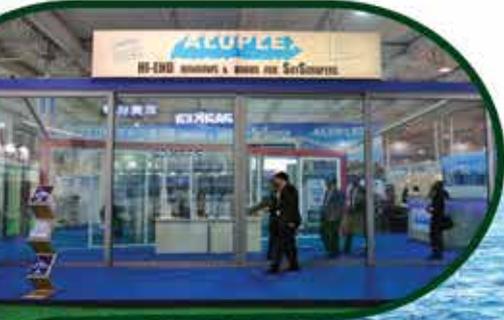


WOODNEWS

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Felder promise: edges without compromise



The new Felder G-360 with 8-metres-per-minute feed rate.

Its thousand-fold proven pre-milling unit in particular makes the G-360 stand out in the compact class. Felder's edge banding machine comes with two independent high-frequency motors with a speed of 12,000 RPM, equipped with diamond cutters.

These allow an unprecedented edge processing quality. Tear-free, industrial quality glue joints become the new standard with the G-360.

Flexibility is another strong point of the new machine concept: although the model requires only 2.3 square metres of floor space, thanks to its compact design, the G-360 offers two individually equipped with open spaces.



The new Felder G-480.



The Teflon-laminated glue pot has a capacity of 1.2 kg.



Unique in the compact class is the twin-engine, pre-milling unit.

The proven Felder Quick-Set system once again guarantees exact changeovers and quickest material changes with the latest Felder edge banding machine.

Two counter-rotating, usage-controlled pre-

milling units with diamond-tipped spiral jointing cutters make for perfect edge processing before the gluing of the edges. Using the pre-milling unit, manufacturers achieve absolutely tear-free edges with laminated work pieces.

The chain conveyor with adjustable pressure beam and a feed speed of 8 metres per minute ensures a perfect hold, maximum quietness and optimum pressure transfer.

'Quick-Set' ensures the highest repeat accuracy in retrofitting work without time-consuming re-adjustment of the aggregates. The wear-resistant and high-precision linear guides of the end trimming saw unit make for superior cutting



Proven for years: Felder's Quick-Set system.

results. The flush trimming unit allows a quick and convenient switching between flush trimming, chamfering and radius milling work.

All adjustments and settings can be

efficiently and centrally administered using the centralised LCD control panel: glue temperature adjustment, automatic temperature reduction, activation of the aggregates, an odometer for total running metres of material used, maintenance information and plain text error messages, all ensure excellent operating comfort and increased productivity.

Edge material with a thickness of 0.4-3 mm is glued precisely and cleanly on work pieces that are at least 70 mm wide, 210 mm long and 10-45 mm thick. The cleanly working surface scraping unit or polishing unit for ABS and PVC edging material ensure a perfect finish.

The G-480

The new Felder G-480 is its top model of compact-class edge banding machines. Even with its standard equipment, the G-480 comes with a joint trimming unit with diamond cutters as well as an ultra-modern corner rounding unit for tip edge processing.

A further highlight is the serially fitted Quick-Set system, which still ensures the most accurate and fastest form of manual edge change without any readjustment. The G-480 offers full flexibility in the universal use of ABS, PVC and thick veneer roll material with a thickness of 0.4-3 mm and a work piece height of 45 mm.

The pressing unit with two pressing rollers for constant contact pressure is mechanically pre-stressed and adjusted quickly and accurately for the respective edge material via Quick-Set.

All adjustments and settings can be efficiently and centrally administered using the user-friendly and pivot-mounted LCD control panel. The pre-milling unit, the corner rounding unit and the two individually flexible finishing spaces make manual edge reworking superfluous.

The Austrian Felder Group is one of the leading worldwide suppliers of woodworking machines for hobby, business and industrial use. For more information visit www.felder-india.com.

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Tiomos takes Grass beyond glass and mirror



The Tiomos M9 also combines sensibility and strength, but has an extremely shallow cup depth.

With the launch of the movement innovations Tiomos M9 and Tiomos Mirro in 2013, the product developers of the German-Austrian brand manufacturer Grass have already demonstrated their instinct for trends.

Since then both hinges have been providing the high-tech Tiomos functionality for very demanding door applications. At Interzum 2015, Grass extended the Tiomos family by another new member that was designed especially for thin, heavy materials such as stone panels, Corian or aluminium.

The demands for lightweight solutions and increasingly slimmer surfaces, with special focus on materials such as glass that blend unobtrusively into all contemporary interior designs, dictated the development of the Tiomos M0 and features three different versions for ambitious door applications.

The complex interior of the hinge arm, with its purist design that conceals the integrated damping technology, with its tool-free adjustment and physically optimised kinematics for extremely easy opening of furniture doors had already won design awards.

New member

The Tiomos M0 moves thin, heavy materials such as stone panels, Corian or aluminium smoothly and with ease.

This new member of the family is simply screwed on without a cup hole and is, therefore, ideal for materials with a thickness of 6 mm to 10 mm.

The tool-free damper adjustment ensures a smooth closing movement irrespective of the door size and weight. This perfect motion guarantees permanent stability in all positions.

The processors in this new member of the Tiomos family are not only able to move very thin, light and sensitive materials smoothly and easily, but also their equally slim but much heavier counterparts.



At Interzum 2015 Grass presented the new member of the Tiomos family, the Tiomos M0.

Tiomos Mirro has fully integrated Soft-close damping for the finest glass and mirror doors.

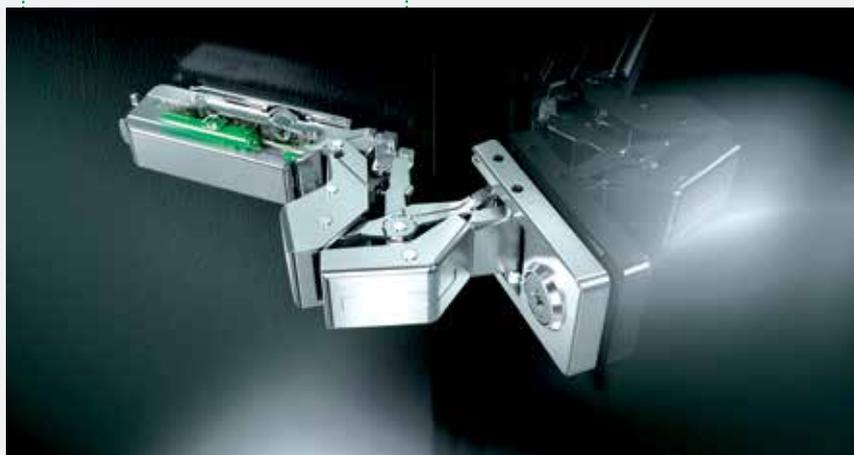
The Tiomos Mirro can also be fastened to existing self-adhesive adapters of the Nexis range with the front connection for high-quality mirror and glass doors. The hinge system is attached with an eccentric screw to a self-adhesive adapter on the door and provides permanent and firm stability for fragile materials, without the need to drill the glass.

Tiomos Mirro also enables the use of track-proven, fully integrated Soft-close damping for the finest glass and mirror doors. The entire damping technology is invisibly integrated into the hinge. With or without Soft-close damping the design of the hinge remains identical.

The Tiomos M9 also combines sensibility and strength. Designed especially for very slim furniture doors and a four-sided mitred application, Tiomos M9 has an extremely shallow cup depth.

Even with a front thickness of only 12 mm, the unique hinge system remains durable, firm and stable in all positions.

Although the applications for the three hinge versions are very specific, they all feature the incomparable Tiomos comfort. In addition to the three-dimensional adjustment and the stepless height adjustment, it includes the outstanding kinematics that makes furniture doors open smoothly and extremely easily.





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Multi-tasking grippers from Fipa

Fipa GmbH of Germany has introduced an alternative for work pieces with holes or gaps in the form of new pneumatically operated, single-acting indoor grippers for parts with different diameters.

According to Mr. Rainer Mehrer, CEO of Fipa, its entire product range of indoor grippers has been completely revised and made even more user-friendly: the same model of indoor gripper can now always be used, regardless of the position of the items to be handled.

Compared to competitor products, separate grippers with upward or downward moving piston are no longer necessary. In order to handle lighter parts with small dimensions, the indoor grippers have been specifically designed for a diameter range of 3 mm to 10 mm.

The gripping heads are made of polyamide, approved by the FDA (the US Food and Drugs Agency), suitable for direct food contact. The new indoor grippers for the diameter range of 8 mm to 85 mm excels thanks to its high holding force, which can be adjusted to the work piece via the operating pressure.

Strong elastomer bellows made of silicone or EPDM clamp down on the work piece's inner contour and ensure low marking while handling. The bellows can be replaced quickly and non-destructively.

The elastomers made of silicone are suitable for contact with food and heat-resistant up to 200°C. The housings for both series are made of high-strength, anodised aluminium and are suitable for the implementation of complex grippers in lightweight construction thanks to their low weight.

A large portfolio of matching fittings and screw connections is available for the integration of the indoor grippers into gripper systems.



Salient Features

- Diameter range of 3 mm to 10 mm
- FDA approved polyamide gripper heads, suitable for direct food contact
- Simple and non-destructive replacement of gripper heads
- Just one model needed for upward and downward moving piston
- Adjustment of gripping force via operating pressure
- Two bellows materials: EPDM and silicone
- Both are heat-resistant up to 200°C
- Elastomer bellows non-destructively replaceable.

(www.fipa.com)



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MADE IN SPAIN

Salice introduces 2 new accessories



Shelf is available in all possible lengths, with advanced closing operations.

Salice has introduced the Shelf, the new runner for pull-out shelves, and adds another product to its wide range of runners.

Shelf belongs to the range of Futura full-extension runners. It is available in all possible lengths, with push-opening or with Smove decelerated closing.

Shelf is fixed at the bottom and has several applications:

- Display cabinets, to allow the pull-out of display shelves;
- Living room furniture with pull-out shelves for home theatre entertainment systems;

- In kitchen cabinets, used for pulling out shelves with small domestic appliances;
- Low drawers for stationary in office furniture.

In case of big width, runners can be added, in order to increase the weight capacity and, at the same time, to allow shelves to be more stable.

Wind is the new lift system introduced by Salice characterized by compactness, style and elegance. Its movement is soft and light; its small dimensions allow maximizing the internal space inside the cabinet.

In the kitchen, for example, Wind has a strong functionality: a small and compact lift system using a minimal amount of internal space. Wind is suitable for other applications also: office furniture, small cabinets, living rooms furniture or bedrooms.

Here the aesthetic value plays an important role and its smart and compact shape helps Wind become a classy lift-system, thus making furniture even more appealing.

Wind is available in several finishes and can be used in every possible location.

Wind is a compact, classy lift-system.



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New dry sharpener technology



The Alpina KE90.

Serra Maschinenbau GmbH, the first manufacturer of mobile sawmilling technology, is celebrating its worldwide success over 25 years. Whether they are cutting Siberian frozen wood or extreme hardwoods in Peru, Serra's sawmills are working under the hardest conditions worldwide in more than 75 countries.

With the new sharpener, Shark 200, the company presents a brand new technology in the area of dry sharpening. A big grinder wheel of 300 mm and an integrated diamond-tipped profiler grant perfect sharpening.

The integrate vacuum for the dangerous sharpening dust and the easy operation of the sharpener itself are other of its advantages. The sharpening of a sawblade with a length of 5700 mm

takes a quarter of the time of what a wet sharpener would require.

At Ligna 2015, Serra also presented the model, Alpina KE90, with 6-metre and 7-metre standard cutting lengths, extendable and hydraulic log handling. The 18.5 kW main engine drives the 80-mm saw blade through the logs with a diameter of up to 90 cm.

All the sawmills are equipped with a computerized positioning system that, depending on the model, have different functions – for example showing the accuracy of the blade, the automatic cutting speed control and the fully

automatic sawing.

The automated systems of this sawmills and their output is always being more and more developed, reaching points that nobody thought about it in the past, specifically in the industrial area.

"We always have the same experience of customers from countries like Sumatra, Dubai or Kenya being amazed of how the Serra saw blades can easily and precise cut hardwoods like Azobe, Okane, Tauari, Zapote and Greenheart, among others," the company said in a press note.

Adjusting screw for controlling the advance and behind the scale for adjusting of the tooth angle.



The Shark 200, with big grinder wheels and integrated extraction, provides a perfect finish.



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EasyWrap is all-in-one unit



The EasyWrap series is for wrapping wooden and plastic window profiles.

Duspohl is one of the world's most innovative companies when it comes to developing profile wrapping technologies, and also laminating and peripheral machines for the wood and plastics processing industries.

The company looks back on a decade-spanning history, beginning in the 1960s. The considerable expertise of the staff in the field of element surface finishing can now be regarded as globally unique. Whether starting up or long-standing professional, classical wrapping with our entry level model or our premium class with unrivalled performance and fully automatic robot technology, customers will find our intelligent machine concepts, with their extremely good investment volume to functionality ratio, very convincing.

Duspohl's customer's technological demands, and their requirements in terms of the degree of automation and performance, result in an optimally designed machine.

Their modular design allows the expansion of existing systems, regardless of the manufacturer; the set-up is fully automatic or with the help of quick-change systems; easy operating via touch-screen is guided and language-independent.

The EasyWrap series is for wrapping wooden and plastic window profiles with decorative materials in roll or sheet form. It comes equipped with a unique all-in-one adhesive application unit, a melter, dosing pump, filter system and slot coater in one unit!

The EasyWrap R series comes with the smart RCS: pre-melter, circulation pump and roll application rolled into one.

Cefla offers unrivalled performance and fully automatic robot technology.



Salient Features:

- Speed-independent dosing control
- Continuously variable slot coater
- Wrapping zone equipped with easy-to-use set-up time
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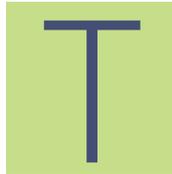
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Many twists & turns to American maple & cherry

British sculptor and furniture designer create an elaborate installation, 'Invisible Store of Happiness'

*Sebastian Cox
and Laura
Ellen Bacon
making The
Invisible Store
of Happiness.*





The Invisible Store of Happiness is a 3-metre-high ode to wood and craftsmanship. The installation involved two of the UK's brightest talents – furniture designer Mr. Sebastian Cox and artist Ms. Laura Ellen Bacon – who took 3 months to craft the structure out of American hardwoods.

Showcased for the Clerkenwell Design Week (CDW) in the archway in front of the historic Museum of the Order of St John in London in May, the dramatic installation was hand-crafted out of American soft maple and cherry and consisted of a mighty steam-bent frame that gave way to thinner, weave-able strips manipulated to twist and flow into a whirlpool of texture and shape.

The American Hardwood Export Council (AHEC) had supported the project to allow experimentation with these timbers and to celebrate their potential. Cox conceived the project and asked Bacon to join him for the project.

“The Invisible Store for me has become a store of many things,” said Cox. “As the project unfolded it became a store of education, ambition, pride, experimentation, unknown quantities, passion, cups of tea... The whole thing has been the biggest thing we’ve ever undertaken!”

The maple and cherry have been crafted into an elliptical-shape frame that showcases fine craftsmanship and impeccable cabinetry on a grand scale, with huge arcs of steam-bent cherry wood, hand-jointed together in mostly glue-less draw-bore mortise and tenon joints.

Through complex machinery the components of this solid frame were effectively shredded into strips and made supple and weave-able from time spent soaking in the River Thames beside Cox’s Woolwich workshop.

The Invisible Store of Happiness has been environmentally profiled and the carbon footprint of the whole structure, on a cradle-to-grave basis, is just 173 kg CO2 equivalent: less than that of an iPad Air2! “I believe the entire design community should be more aware of LCA and dedicate to measuring the environmental impact of the things we design and make,” said Cox.

The challenge for the CDW installation was to raise the profile of maple and cherry, both beautiful yet under-appreciated American hardwoods, and to create a three-dimensional form to communicate the environmental benefits of using them.

AHEC wanted to challenge perceptions of hardwood, both as a material and as a sustainable and growing resource. “This collaboration exploits the qualities of wood. The exterior of the piece speaks of its rigidity, its structural qualities; the interior tells of how this may be rendered flexible, descriptive and expressive,” said Mr. Roderick Wiles, AHEC Director for Africa, West Asia, South Asia and Oceania.

AHEC is a leading international trade association for the US hardwoods industry, representing the committed exporters and all major US hardwood production trade associations.

(www.sebastiancox.co.uk and www.lauraellenbacon.com).



The Invisible Store of Happiness: supple, weaveable maple and cherry.

The magic behind the gloss



Prestige Interio Concepts, a Mumbai-based manufacturer, launched its OpuLux brand of super-high-gloss, scratch-proof thermoplastic-laminated panels in May 2014. *WoodNews* scratched its surface with its Managing Director, **Mr. Pankaj Chandak**, to delve into the chemistry of the popular product.

Just as not all plastic is PVC or acrylic, not all high-gloss panels are scratch-proof. With that preamble Pankaj begins explaining his “special” product in the Indian market. Prestige Interio not only introduced highly specialised ABS-PMMA extruded polymer sheets for furniture, but also continues to be the only factory providing the super-high-gloss, scratch-proof laminated panels on plywood.

But first things first: what is this laminate all about? Both ABS and PMMA are thermoplastics. Acrylonitrile Butadiene Styrene (ABS) provides the strength and flexibility to the film, while Poly Methyl Meth Acrylate (PMMA)

provides it with the high gloss effect in varying colours. In fact, Pankaj informs, ABS is extremely strong and is used in modern automobile manufacturing!

Senosan GmbH of Austria, is Europe’s top manufacturer of thermoformable, scratch-proof and scratch-resistant, co-extruded engineered polymer sheets. The co-extrusion method, incorporating proprietary nano-technology developed by Senosan, results in 1-mm-thick sheet that has five layers comprising of four variants of ABS and PMMA to make up the OpuLux scratch-proof film.

Pankaj then partnered with a Germany based adhesives manufacturer to

employ its PUR hot-melt glues for flat lamination of his OpuLux range of scratch-resistant and scratch-proof panels.



A decorated dining room.



Nano-technology enables gloss level of 85, almost mirror-like.

The flat lamination line to manufacture OpuLux scratch proof high gloss panels was custom-made in Taiwan to suit Indian customer's requirements. The fully computerised flat lamination line occupies 12,000 square feet space in a factory in Vapi, Gujarat. Pankaj sits on plenty of spare space for expansion in the future.

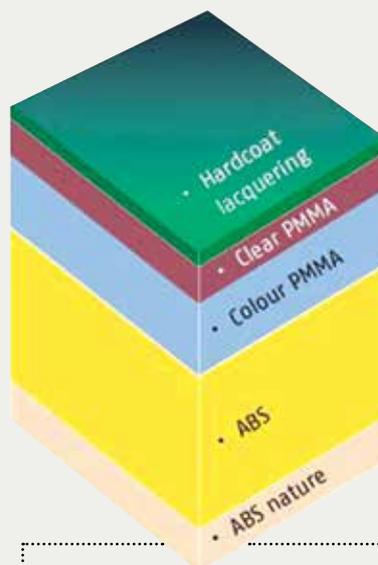
By 2012, Prestige Interio had launched the OpuLux Classic (scratch-resistant) range on plywood, MDF, particle board and PVC. The flat lamination technology for plywood did not come easy. Pankaj – himself a trained, post-graduate engineer from the US – spent nearly 10 months to attain perfection. The persistence with water-proof plywood has a simple explanation: most Indian customers demanded that as the core material!

Best inputs

OpuLux scratch-proof panels are available in 1220-mm x 2440-mm size and 18 mm thickness. Customised sizes can also be manufactured for large quantities. Each board comes with a protective sheet to safeguard the super-high-gloss surface, along with excellent mechanical and optical properties and vibrant colours.

Pankaj imports custom-designed

plywood for his OpuLux scratch-proof panels, to ensure consistency in the substrate – else the true properties of the high-gloss, scratch-proof film would go waste. It is also possible to apply the special film on curved surfaces, and the type and application of adhesives for such products becomes super-critical, he says.



Five-layer product build-up results in increased UV and colour stability, as well as greater chemical resistance.

These boards are resistant to UV light, water and termite, and are borer-proof. What is more, they are completely environment-friendly and can be recycled!

Because of their great heat and moisture resistance, and environment-friendly construction, OpuLux scratch-proof panels are used in a variety of interior furniture applications, among them modular kitchens, bedroom furniture, doors and partitions, hotel and restaurant furniture.

Pankaj's attention to quality, state-of-the-art manufacturing, and service has resulted in wide acceptance of OpuLux scratch-proof panels across all over India. He believes that the potential of high gloss products in India is huge and untapped, and we have not even scratched the surface!

Prestige Interio Concepts also offers high-quality particle boards, plywood, MDF, and pre-laminated boards. Its entire product portfolio runs into more than 5,000 products, ranging from MDF and PVC to HPL, veneer, scratch-proof and stone finishes!

- Dhananjay Sardeshpande

Curbs on farm timber may ease

There is a long tradition of growing commercial timber trees on small farmers in India and such farm forests once were a primary source of raw materials for many domestic mills.

However, this practice has been declining over the past few decades mainly because of unfavourable legislation and overly complicated regulations relating to forestry and agriculture. But this is about to change.

Discussions are underway to unravel the various regulations imposed by multiple agencies such as the state departments of forestry, the land revenue agencies

and others that have imposed regulations on felling and transport of logs.

The sheer complexity of regulations has discouraged the production of timber trees on farms. A new policy will be developed to effect coordination of the various administrations. It has been proposed that the new policy would be implemented through a special forestry mission or board.

In addition, discussion are on-going on ensuring security of land tenure, promoting research and capacity building, felicitating participation of

industry and appropriate incentives to farmers.

The new policy involves a major shift in outlook towards farm forestry. Earlier, farm forestry was viewed as the responsibility of the forestry administration but now the policy views it through the prism of agriculture.

The acceptance that farm plantation timber is an agri-product will enable the Central Empowered Committee to issue more licenses for wood-based industries. – ITTO

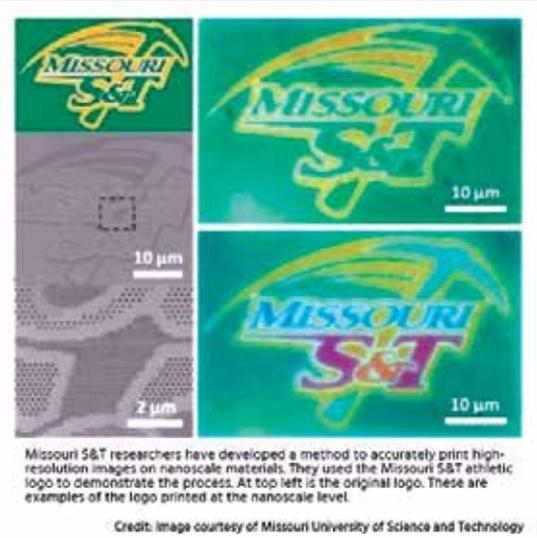
‘No-ink’ colour printing with nano materials

A new technology, the so-called “no-ink” printing method, could jeopardise the business of printing ink manufacturers. Researchers at Missouri University of Science and Technology are giving new meaning to the term “read the fine print” with their demonstration of a colour printing process using nano materials.

In this case, the print features are very fine – visible only with the aid of a high-power electron microscope. The researchers illustrate their “no-ink” printing method by reproducing the Missouri S&T athletic logo on a nanometer-scale surface.

The technique, described in scientific reports, involves the use of thin sandwiches of nanometer-scale metal-dielectric materials known as meta-materials that interact with light in ways not seen in nature. The sandwich-like structures, or plasmonic interfaces, are simple but efficient structural colour printing platforms at the nanometer scale.

The “no-ink” printing method reproduced the Missouri S&T athletic logo on a nanometer-scale surface.



Scientists believe the process holds promise for future applications, including nano-scale visual arts, security marking and information storage. Unlike the printing process of an inkjet or laser jet printer, where mixed colour pigments are used, there is no colour ink used in this structural printing process.

Down to work for Xylexpo 2016

Activity is back in full swing for the next edition of Xylexpo, the biennial international exhibition of woodworking technology and furniture industry supplies to be held at Fieramilano-Rho from May 24 to 28, 2016.

The exhibition is still a key reference in even-numbered years, the most important international event that attracts exhibitors and visitors from all over the world. It is a reference for the

Italian industry of woodworking technology as well as for international manufacturers.

The “comeback” of big groups in the previous edition, their participation again in 2016, the applications coming from the world’s technology leaders (including Barberan and Felder Group) are a promise that the next “Milan May” is not to be missed!

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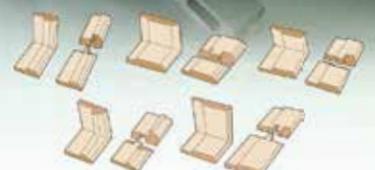
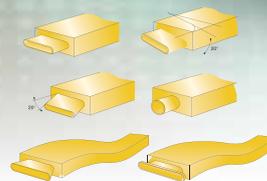
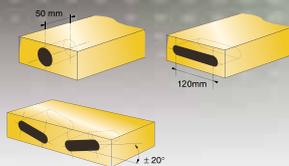
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Mr. Boman Irani (left) is felicitated by Mr. Abhishek Somany (centre), the business partner for the summit, in Bangalore.

platform for industry experts to address concerns, discuss solutions and leverage trends to create the blueprint for a futuristic India.

The summit aims to ensure that senior decision makers are equipped with information to respond to challenges they face. It delved into realizing the Vision 2020 and its relevance to the Indian framework.

It was agreed that if India has to join the league of developed nations, one essential aspect would be planning and creation of global cities, where architects, designers and builders would play a crucial role.

Among the speakers at the two-day summit were Mr. D. Satyamurty, Additional Chief Secretary in the Urban Development Department of the Karnataka government; Mr. Naresh Narasimhan, Principal Architect with Venkataraman Associates; Mr. Boman Irani, Managing Director of the Rustomjee Group; Mr. Bertil De Kleyne, Director for Architecture and Landscape at Atkins Global; and Mr. Alfredo Munoz, Founder of Abiboo Architecture.

A&D Summit discusses broad vision for India

The third edition of Architecture and Design Summit in Bangalore recently saw industry leaders, government officials and international architects coming together to discuss India's

prospects in the realm of architecture.

Bangalore – a confluence of design cultures from Victorian gardens to Moghul-era structures – became a

'Green' PU eliminates isocyanate threat

A "green" polyurethane, which eliminates the use of isocyanates, has won the 2015 Presidential Green Chemistry Challenge Award given by the US Environmental Protection Agency (EPA). Isocyanates are critical components used in conventional polyurethane products such as coatings and foam.

However, exposure to isocyanates is known to cause skin and respiratory problems, and prolonged exposure has been known to cause severe asthma and even death. Isocyanates are also toxic to wildlife.

When burnt, isocyanates form toxic and corrosive fumes, including nitrogen oxides and hydrogen cyanide. Due to these hazards, isocyanates are regulated

by the EPA and other government agencies.

To address the health and environmental hazards associated with conventional polyurethanes, Hybrid Coating Technologies (HCT) has developed a hybrid non-isocyanate polyurethane (HNIPU), also called "green polyurethane". The result is a cross-linked polymer with a different structure.

HCT developed a novel concept for generating new multifunctional modifiers for "cold" cure epoxy-amine compositions, namely hydroxyalkyl urethane modifiers (HUM), and subsequently developed HUMs based on renewable raw materials (vegetable oils), which are now used for SPF and UV-cured acrylic polymer based coatings.



HNIPU is a safer chemical formulation for use in polyurethane and epoxy applications such as coatings and foam. It also has improved mechanical and chemical resistance properties, replaces up to 50% of its epoxy base with renewable resources (vegetable derived) and is cost-competitive compared to other conventional polyurethane and epoxy products. It is expected to be commercially available by end 2016.



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Panish is new sales head for Bosch power tools



Bosch recently named Mr. P.K. Panish as the Regional Sales Director for its power tools division for India and the SAARC (South Asian Association for Regional Cooperation) region. He took over on August 3 from Mr. Vijay Pandey, who was Vice-President (Bosch Power Tools-India) and will now be shifting to Germany to take on a new responsibility within the company.

Panish has an engineering degree from Bangalore University and a post-

graduate degree in management from the Indian Institute of Management-Calcutta. In his new role, Panish will spearhead the company's growth across multiple channels for the entire portfolio of power tools, accessories and services business.

His long-term focus will encompass deeper penetration of the brand through channel expansion and focused sub-dealer programmes in Tier-3 and Tier-4 cities. He will also focus on widening the

power tool accessories product portfolio, besides strengthening the services network.

With brands such as Bosch, Skil and Dremel, the division stands for customer focus and engineering progress. This year, Bosch power tools will again launch more than 100 new products in the German market. In 2014, Bosch applied for some 4,600 patents worldwide.

Hafele mesmerises at IKB show

Hafele participated to display a wide range of its product range in kitchen fittings, appliances and bathroom segments at the three-day (21-23 August) Indian Kitchen and Bath Exhibition at Pragati Maidan, New Delhi.

Hafele introduced its electric touch-opening mechanism for tall units, Power Move by Vauth Sagel. The system allows opening of tall cabinet fronts at the slightest push of the hand, as well as swiveling it to the right/left to gain maximum access to the contents. The HSA rotary unit with the Power Move mechanism (optional feature) provides an enhanced experience of easy opening and complete access.

Among the products on display was Blum's Aventos HK-XS, a compact fitting



for small stay lifts in high and wall cabinets. The condensed design of this new lift system ensures that cabinets with small internal depths can be equipped easily.

The symmetrical lift mechanism can be used on one or both sides. Whether thick wooden fronts or glass fronts with wide or narrow aluminum frames, the fixing position always remains the same, allowing easy integration of different materials and front thicknesses.

Nagold's J-Series, with feather-touch control technology and dozens of other automatic functions, were the flavour of

the show's baking and grilling section of the kitchen segment.

The Liebherr range of wine storage cabinets incorporated innovative, no-heat LED lighting in the wine cooling compartments that can be dimmed to bequeath the insides of the cabinet with a pleasing ambient light.

Its Iconic range of washbasins and bathroom faucets from the Italian house of Webert; the vanity units and accessories from Boing of Spain; and shower systems from Edelbad of Korea were also on display.

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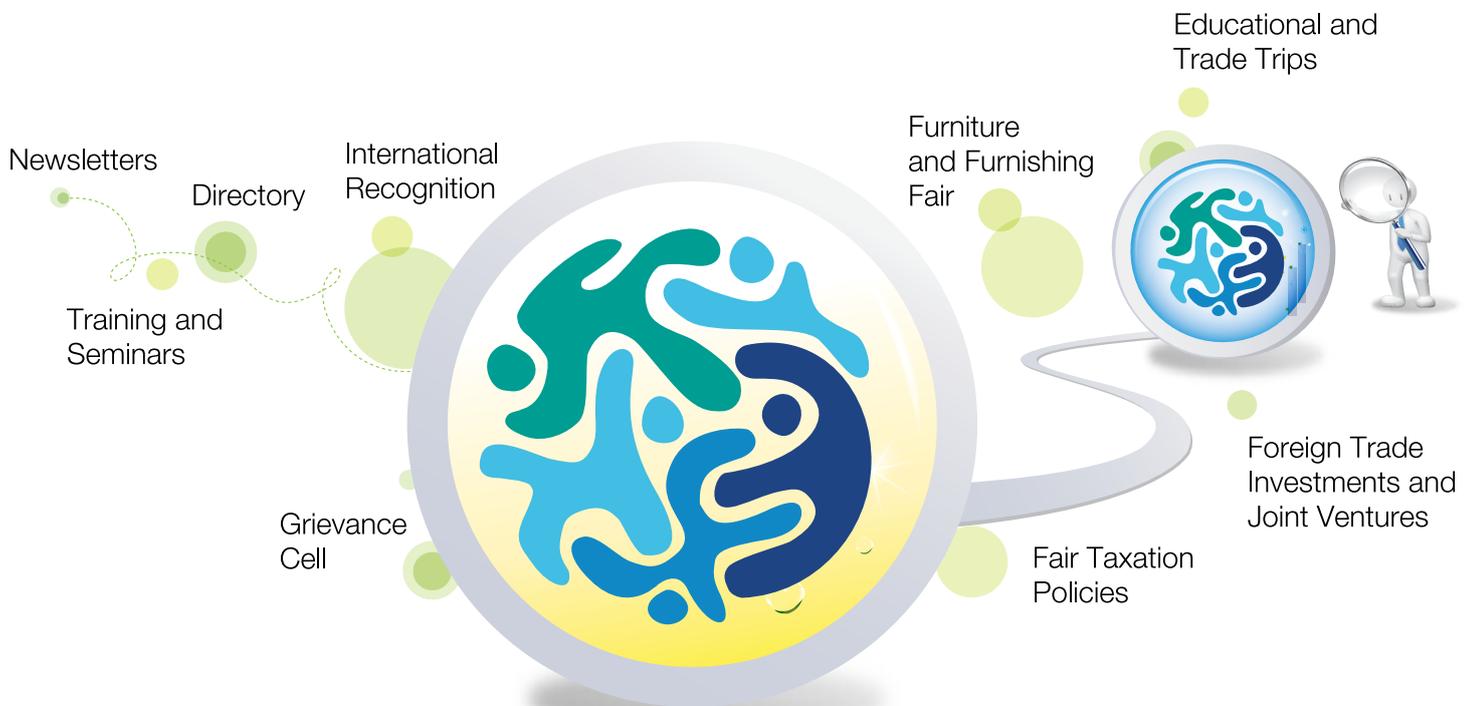


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Official Magazine

WOODNEWS

Henkel expands expertise in surface treatment

Henkel Adhesive Technologies is further driving its innovation capabilities and leadership forward. with its business unit continuously engaging with promising start-up companies. The most recent result is the signing of a joint development agreement with US-based DropWise Technologies Corp.

DropWise, founded in 2014, is headquartered in Cambridge, MA, has developed technology, intellectual property and lab-scale manufacturing knowhow for a novel method of hydrophobic coating applications. The partnership will enable Henkel further expand its leading position in the global

surface treatment business and driving growth with new applications.

The DropWise application process is based on an initiated chemical vapor deposition (iCVD) technique which allows the coating to be applied for OEM or retrofit applications.

Using just a very small amount of polymer precursors, a chemical reaction is carried out that covalently grafts an ultra-thin polymer film to any metal surface, such as stainless steel, titanium, copper, aluminum, and even polymers and ceramics.

Target applications include industrial



Droplet formation on the durable hydrophobic polymer surface.

heat exchangers such as steam condensers in power plants, heating-ventilation and automotive air-conditioning as well as chemical processes.

It allows for reductions in fuel consumption, emissions and coolant water use, particularly for thermal power plants, which are the largest contributors to global emissions and second largest consumers of water.

Acimall records 8.6% rise in production

In 2014, the Italian woodworking machinery and tools industry recorded an 8.6% increase from the previous year, reaching a production value of 1,669 million Euro.

The year under scrutiny closed with moderate satisfaction, as results were definitely more "interesting" in the second half. An excellent trend was recorded both in Italy and in several international markets, with few

exceptions due to the significant shrinkage of important destination markets for 'Made in Italy' like Russia and Brazil.

According to figures released by the Acimall Studies Office, the conglomeration of Italian woodworking and tools manufacturers, production rose 5%, exports rose 7% and the trade balance rose 3% over the last financial year. Importantly, Italy shipped

technology for a total value of 1,255 million Euro all over the world.

In a period of economic "confusion", it was not easy to collect final figures about the trend of machinery and technology for wood and wood-based materials in 2014. Ups and downs during the year caused delays and had an impact on surveys, forcing analysts to extend the period of evaluation.

Fevicol Adhesive Solutions for Woodworking Applications



Fevicol Hotmelt Products

Fevicol's range of edge banding adhesives has several options for manual as well as automatic machine applications. All the products provide good adhesion properties with excellent resistance against heat, cold, moisture and oxidation.

Fevicol Hotmelt AMT Transparent (unfilled) & Fevicol Hotmelt AMT Clear (filled) are ethylene vinyl acetate (EVA) based thermoplastic adhesives recommended for throughfeed edge banders. They can be used with PVC, PP, ABS, veneer, polyester or melamine resin edge bands. Fevicol Hotmelt 382 (filled) Fevicol Hotmelt MNL Clear (filled) & Fevicol Hotmelt MNL Transparen (unfilled) are specially designed for manual edge banding machines. It can be used to apply PVC, HPL, ABS or solid wood onto MDF or particle board.



Fevicol SWR Range

Specially designed for the handicraft industry, this Polyvinyl Acetate based white adhesive meets the DIN EN 204 Stress Group D3 Standard. It is suitable for all types of wood working applications and provides very high water resistance and excellent bonding in lamination with all grades of wood, even in high humidity areas. Fevicol SWR Plus is specially designed for application in cold weather conditions. SWR EQ has even better cold weather performance and can achieve D4 standard by adding 5% isocyanate. SWR LV has very low viscosity. All are non-flammable and non-toxic with REACH Compliance, Low VOC (Volatile Organic Compound) Certification and Free Formaldehyde Certification.

Fevicol PVC Fix

This water/synthetic resin based emulsion adhesive is suitable for lamination of primer coated PVC sheet to MDF. It is also used for manual edge banding of primer coated PVC Strip to MDF, particleboard, ply etc without using any edgbanding machine, making it highly economical. It has excellent bonding compared to solvent based adhesives, as well as high heat resistance, easy applicability and low VOC



Fevicol SH

The classic PVC white glue for wood to wood bonding features unsurpassed bonding strength, good resistance to water and heat, higher coverage and good value for money. It is not only a leading brand in India, but also the most successful brand in the world in this segment, being exported to over 50 countries.



Fevicol SP Range

This range of sprayable, synthetic rubber based solvent borne contact adhesives can permanently bond painted steel, plywood, chipboard, PU foam, muslin, foam rubber, felt, fabric, leather or many other materials. SP-4 is the basic version. SP-5 is specially designed for the automotive industry and is also used to make writing boards using honeycomb cardboard and white laminates. SP-6 also has high heat resistance.

Membrane Press Range

Fevicol Membrane PU is a solvent based polyurethane contact adhesive used to bond PVC foil to MDF, plywood or other materials. It is ideal for door manufacturing, with low activation temperature, fast drying time and good bond strength.



Fevicol Membrane Press Star 2K is a two-component water based synthetic adhesive used to bond PVC film laminate to wood based panels in the modular furniture, modular kitchen and doors industries. It has excellent heat resistance, low activation temperature and high green tack. It is non toxic and non flammable.

Fevicol Membrane Press Adhesive LC.

Fevicol Membrane Press Adhesive LC is a water based adhesive, specially designed for applications in PVC moulded doors. The unique formulation ensures high green tack resulting in strong bonds on difficult substrates. The product does not release any harmful emission and is safe for users with no adverse effect on the environment.



The product can be easily applied using an air compressed spray gun. Its distinctive features ensure effective deposition on the substrate resulting in higher coverage. Since the adhesive is water based the spray gun can be cleaned with tap water. When used with 5% Membrane Press Hardener the heat & water resistance properties improve vastly. This product bonds PVC to most of the wood substrates like MDF, particle board etc. The mixture with hardener has a pot life of 3 to 4 hours. Higher coverage of 6 to 7 doors compared to 4 or 5 doors in solvent based systems. No volatile losses in this water based system.

Anarchitect wins award for 'No.57 Boutique Cafe'



No.57 Boutique Cafe.

Anarchitect, an international architecture and design practice based in Dubai with collaborative studios in London, has won the 'Outstanding use of American Hardwood in the Middle East' award for 'No.57 Boutique Cafe' at the Commercial Interior Design (CID) Awards 2015, which took place in Dubai recently.

The award was sponsored by the American Hardwood Export Council (AHEC), the leading international trade association for the American hardwood industry for the fifth year running.

Anarchitect was praised for its "well presented and completed project". The judges described the design as clear, well explored and effortless in execution. Anarchitect envisaged the restaurant as a natural evolution of the famous dinner club events created and run by their clients for the last couple of years.

The light and airy bistro uses American white oak plank floors, custom made tables with Carrara marble tops and black powder-coated metal details. The bespoke storage wall and kitchen pass was carefully designed to accommodate all types of crockery and bottles.

Material composition was then reversed in the dining area to include marble floors, American white oak table-tops and custom-built joinery and banquets, offering a contemporary elegance for late afternoon and evening dining.

Anarchitect also designed all of the custom joinery pieces and timber wall panelling using American white oak solids and veneers with an open grain.

White oak was preferred for its tone and prominent grain to achieve the desired look for the joinery.

Mr. Jonathan Ashmore, Director of Anarchitect, Mr. Roderick Wiles, AHEC Director for the Middle East and Africa, and co-collaborator on the No.57 project, Mr. Tarik Zaharna, at the award ceremony.





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J-2102 multi-head multi-boring machine



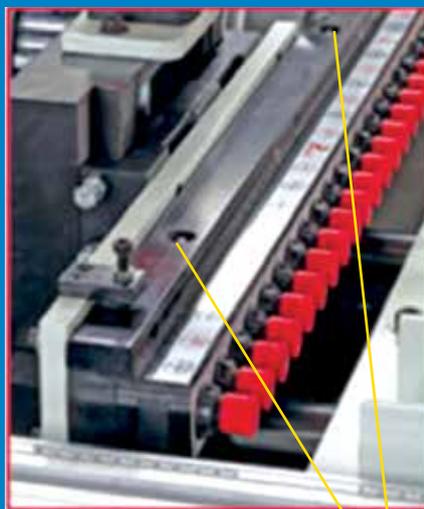
Adequate maintenance is a crucial factor for longer life of the machine, as well as to obtain optimal working condition of the machine itself.

All maintenance operations must be done with the machine turned off and with protective gloves. The machine and working area must be kept clean from working scraps and anything that could hamper the working cycle or access to the machine itself.

The machine must be cleaned every day. Any material not needed by the machine can gather on it, preventing safe operation and causing danger to the operator during the normal working cycle.

Sliding guides, sliding bars and movement screws must be kept clean from working residues; otherwise dirt can become an obstacle to precise movement of the machine and affect its efficiency. However, do not use detergents or lubricants.

Make sure the machine is lubricated regularly. Grease the drilling head through grease nipple A (Fig. 1).



Check the electric system safety with the condition of the electric cables. Make sure there are no signs of wear, scrapes, etc.

Check the clamping of the various mechanical components to make sure there are no unsecured, moving parts that can lead to unwanted vibrations during the machine's operation.

Check the air pressure, air supply must have 6 kg/cm² pressure. Check the lubricant oil level in the air filter until and top up if necessary.



Problems, Causes & Remedies

Problems	Causes	Remedies
Drills do not work	Motor does not work	Push the motor start push button
		Release emergency push button
		Check the fuse
		Check the air pressure
Motor works, but drills does not	Motor burnt	Replace the motor
		Replace them or call technical service staff
Hole not accurate	Possible failure of gears, keys or drive joints	Replace them or call technical service staff
	Improper drill locking	Check locking
	Drill wear	Replace
Drilling head jerking	Work piece blocked working air pressure	Check clamp units, their seals and
	Working residues on sliding rod	Clean sliding rod properly
Hole distance or board thickness hole size not proper	Sliding rods not parallel	Check mounting of sliding rod B (Fig.2)
	Position indicator reading not match due to setting not proper	Adjust the position indicator, as per size (Fig.2)
Drilled pieces are not parallel to the reference bar	Screw/nut thread damage	Replace the screw/nut
	Incorrect parallelism of the drills in relation to the reference stop	Check heads in relation to the stop and the parallelism of the line of head (C) with head 2(D) in vertical position (Fig.3)
Drilling head to raise does not reposition	Air pressure insufficient	Adjust the required air pressure
	Air cylinder limit switch contacts damage.	Replace with new contact
	Limit switch not in position	Make the proper adjustment

Fig.2

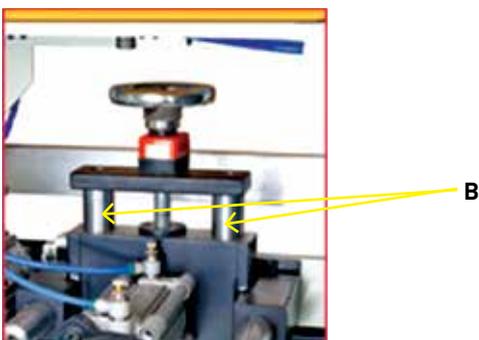
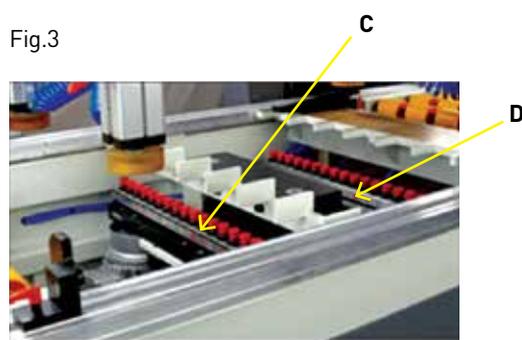


Fig.3



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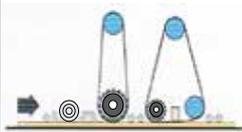
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