

THE PROCESS OF MANUFACTURE



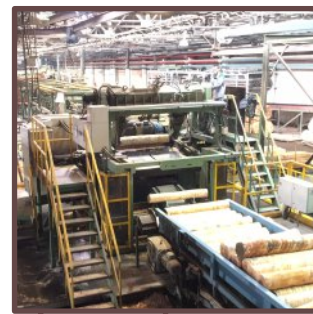
Wood stock



1. Hydro thermal treatment



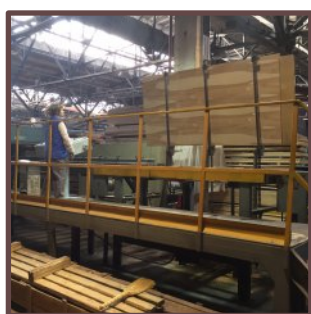
2. Debarking and cutting



3. Peeling



14. Manual repair



13. Grading

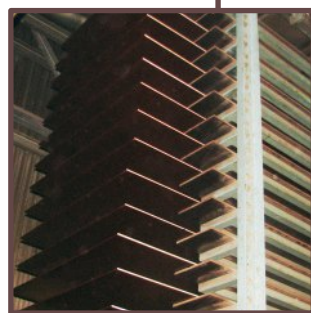


12. Sanding



11. Cutting to size

Birch plywood SyPly™



15. Film-facing



16. Cutting to size and edge profile trimming



17. Grading



18. Edge sealing

Stages 1 to 6

Logs are hydrothermal treated with steam and hot water to improve smoothness and density of veneer. After treatment logs are cut into pieces sized for peeling, debarked and peeled. Veneer which is produced on peeling lines is then cut into sheets, dried and graded

Stage 7

Graded veneer is patched (veneer defects are removed from a veneer sheet and replaced with patches that are made from high-quality veneer), pieces of veneer are joint at splicing lines

Stages 8 to 10

Graded, patched and spliced veneer continues to the composing shop where dry veneer sheets are interlaced with sheets that are covered with glue. Ready batches are then cold pressed. Final gluing is made in hot presses under high pressure and temperature



4. Cutting of veneer sheet



5. Drying



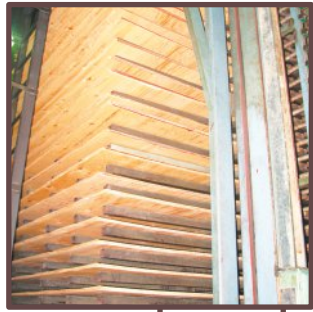
6. Grading



7. Patching and splicing

veneer pieces

full size veneer



10. Hot pressing



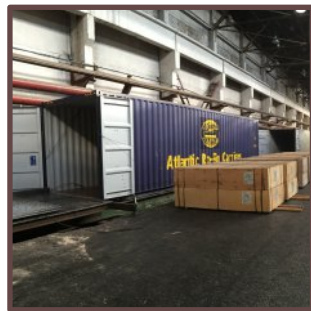
9. Cold pressing (pre-pressing)



8. Composing



19. Packaging



20. Warehousing and shipping

Stages 11 to 14

After pressing plywood sheets are cut to size, sanded to get smooth surface, graded and manually repaired. Graded birch plywood SyPly is packed into bundles after that

Stages 15 to 18

During film-facing plywood is covered with impregnated (soaked with phenolic resin) paper, pressed, cut to size and edge sealed. After grading plywood is packed and transferred to the warehouse

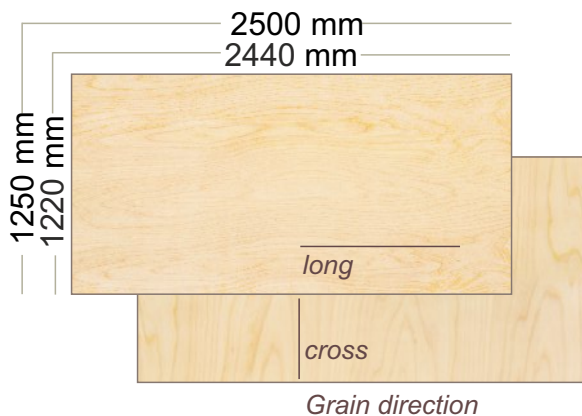
Stages 19 to 20

Plywood sheets are packed into bundles (number of sheets in each bundle depends on a thickness of plywood). Each bundle is tied with plastic bands, marked and transferred to the warehouse. Plywood is shipped with rail transport (wagons and containers) and trucks

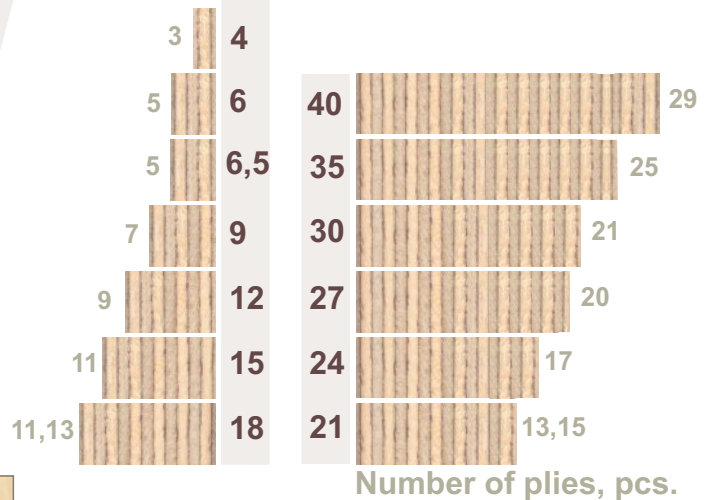


Birch plywood SyPly is a strong and water-resistant material. Birch wood gives its beautiful structure and high physic-mechanical characteristics to plywood. These qualities made it popular in furniture industry, construction, interior and exterior design

FORMATS, mm



THICKNESS, mm



Number of plies, pcs.

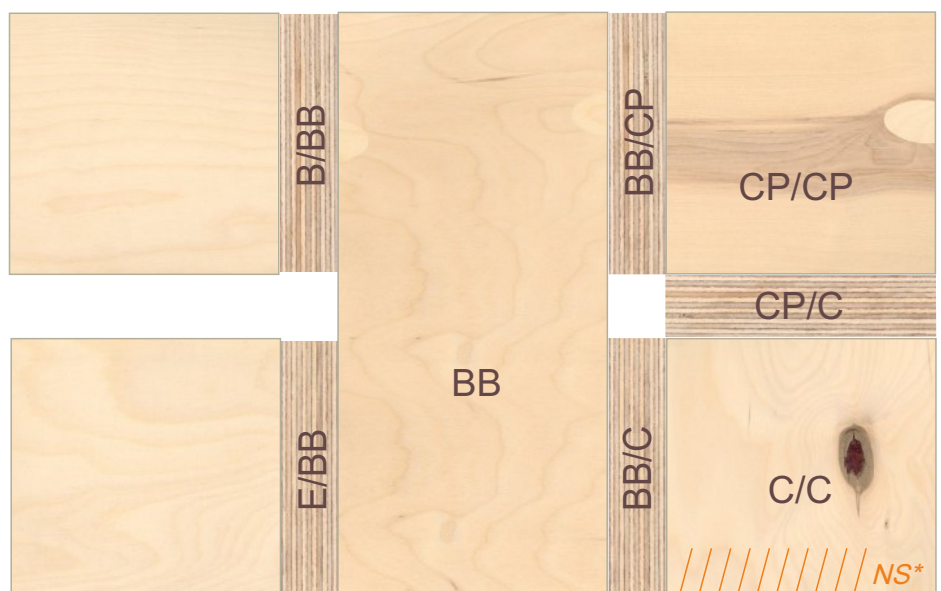
Water resistance	WBP (high), MR (standard)
Class of formaldehyde emission	E1
Humidity	5-10%
Length / width tolerance	+/- 2 mm

PLYWOOD GRADES

There is a difference between grades of plywood and grades of veneer. Grades of plywood depend on the grade of veneer used as for the top ply. For example, plywood panels faced with veneer grade “B” on one side and “BB” on the other side will have “B/BB” grade –the highest grade is indicated in the first place

B/BB
E/BB
BB
BB/CP
BB/C
CP/CP
CP/C
C/C (NS*)

*NS - not sanded



Scheme of plywood composition from different grades of veneer