

# Why use Veneer

- Curved Surface Objects
  - Easier & more practical to make than with solid wood
- Beauty
  - Usually the best grade & most figured logs go to the veneer mill
  - Veneer is the answer for a highly figured face
- Wood Movement
  - Not a major consideration as with solid wood

# Why Use Veneer – Cost

- Desk Top 3' X 5' = 15 SqFt
- Curly Cherry solid wood
  - At \$14/BF, the Desk Top = \$210
- Curly Cherry Veneer
  - At \$3/SqFt, the Veneer = \$45
  - Substrate = \$15
  - Total Desk Top = \$60
- A Ratio of 3.5 to 1

# Cost Trends

- The average log to the mill is 9-10 ft long X 17in diameter, yielding about 106 BF of 4/4 lumber
- The same log will yield about 4,200 SqFt of Veneer
- The average price of select & better Cherry is \$7/BF yielding a value of \$742 for the log as solid wood
- The average price of select & better Cherry Veneer is \$1.80/SqFt yielding a value of \$7,560 for the log as Veneer

**At over 10 times the value yield,  
which way do you think the wood market  
is headed???**

# Why use a Vacuum Press

## Advantages

- Strength
  - The vacuum action sucks the glue into the air pockets of the veneer and substrate bonding the two together as a single unit and when epoxy is used as a glue, the unit seems to become plasticized into a unit of exceptional strength
- Uniform Pressure & Quality of Glue Joint
  - Every single square millimeter of area is subjected to the same pressure, resulting in a better glue joint – something not possible with clamps
- Eliminates a host of clamps
- Less Worktime than Clamping
- Enormous saving in labor when using Flex-ply in lieu of Bricklaying pieces of solid wood for making curved drawer fronts

# Why use a Vacuum Press Disadvantages

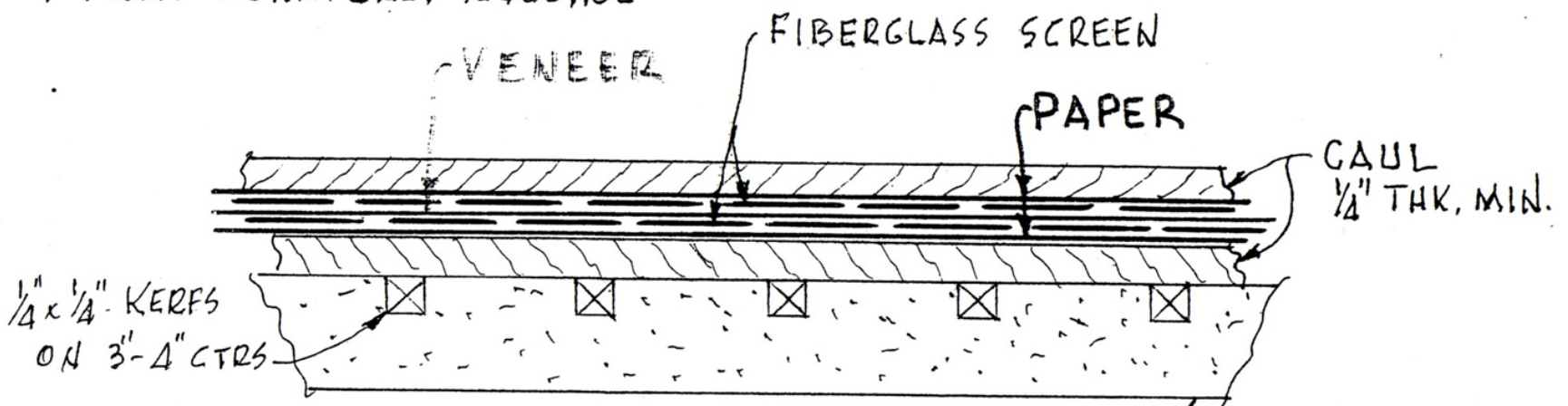
I have not found any as yet!

Try it – I guarantee you will like it!!!



# FORMULA

- 2 PARTS WHITE OR YELLOW GLUE
- 3 PARTS WATER
- 1 PART GLYCERIN
- 1 PART DENATURED ALCOHOL



NOTE: THE WHITE OR YELLOW GLUE IS FOR A SIZEING TO PREVENT GLUE BLEED THRU ON FACE VENEER WHEN GLUEING TO SUBSTRATE.

GLYCERINE IS TO SOFTEN VENEER

ALCOHOL ENHANCES PENETRATION

SCREENING PREVENTS PAPER FROM STICKING TO VENEER DUE TO GLUE IN MIXTURE.

- NEWS PAPER, 3 LAYERS
- - - SCREEN
- VENEER

## VENEER FLATTENING METHOD

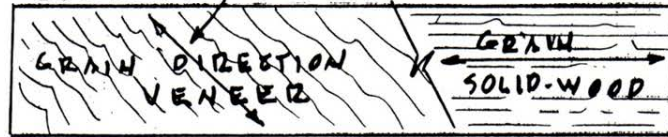
# VENEER ORIENTATION ON SOLID WOOD SUBSTRATE

SEASONAL MOVEMENT OF SOLID WOOD  
SUBSTRATE

1. CORRECT - SAME GRAIN DIRECTION



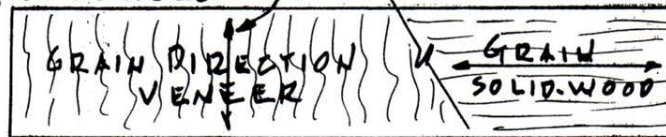
2. CORRECT - 45° OR LESS TO SOLID WOOD



3. INCORRECT - GREATER THAN 45° TO SOLID WOOD



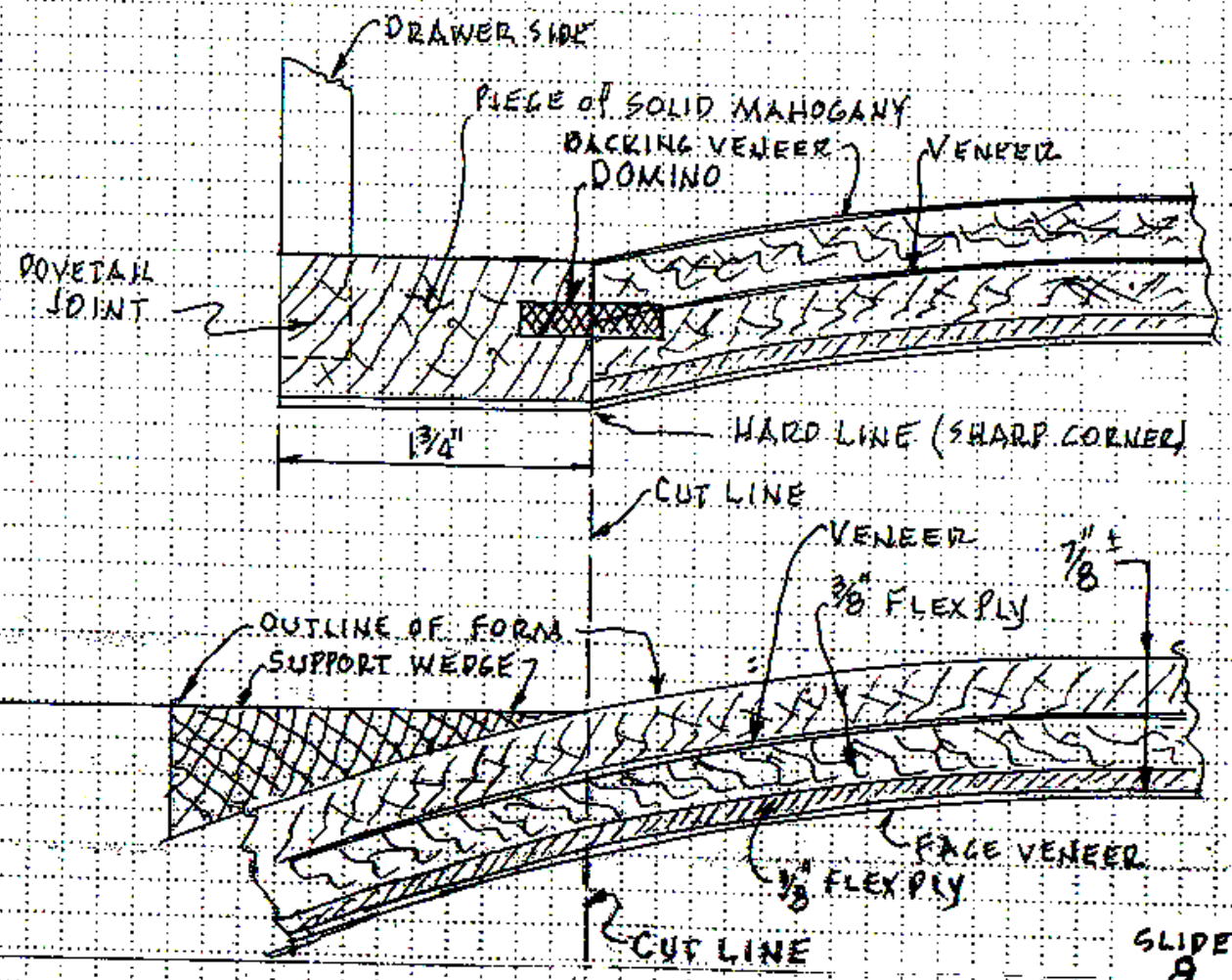
4. INCORRECT - 90° TO SOLID WOOD



VENEER WILL NOT REMAIN STUCK TO SOLID WOOD IF APPLIED AS SHOWN IN EXAMPLES 3 & 4 BECAUSE SEASONAL MOVEMENT OF SOLID WOOD IS IN OPPOSITION TO SEASONAL MOVEMENT OF VENEER.

SLIDE

# FLEX-PLYWOOD METHOD - CURVED DRAWERS



From the workshop of:  
 Date 10-5-47

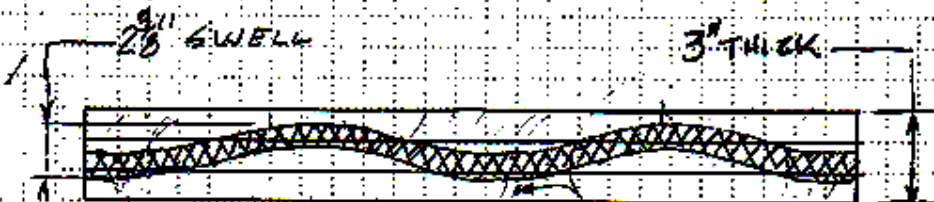


Date:

Project:

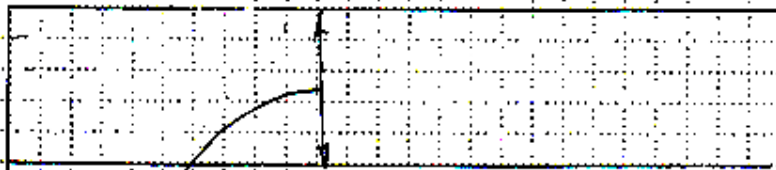
4

### BRICK LAYING METHOD



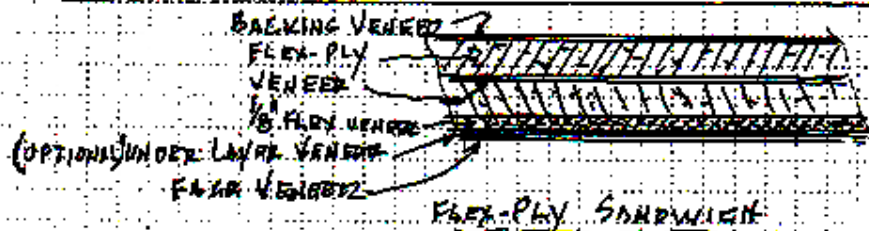
SECTION

3/16" MARGIN



FRONT VIEW - "A" DRAWER PIECES

DRAWER DEPTH 3"-10"



FLEX-PLY SANDWICH



BUREAU  
WITH BLOCKED ENDS  
HT: 32" Wd: 38" Dp 20"  
SAPELE