

PRESSING & COATING & FABRICATION

Matching the veneer leaves

To avoid the striped “paling-fence” or “barber-pole” effect, we recommend that Quarter-cut Woodstock, ecoligna and Tabu veneers be Slip-matched unless the pattern indicates otherwise. Crown-cut should generally be Book-matched. Large wall and ceiling areas may best be Random-matched and Colour-blended.

Joining the veneer leaves (“Jointing & Splicing”)

Veneer leaves must be straight-cut on a veneer guillotine (“jointing”), edge-glued and spliced in the required matching pattern to make layons (sheets of veneer). Stitching veneer leaves should generally be avoided if possible as the thread marks may show through over time.

Substrates

Suitable substrates are MDF or particle board. Plywood (AA face grade) may also be used, but to prevent cracking, veneer should be laid at right angles (across) the direction of the face veneer of the plywood. Substrates should be of uniform thickness, clean, free of oil, grease and other foreign materials. Veneers should not be applied directly to plasterboard, concrete, brick or timber.

Pressing/Gluing onto substrate

Veneers should be glued (“laminated” or “pressed”) onto the substrate using a plywood or veneering hot-press, using cross linking veneering-glues such as PVA or Urea-formaldehyde, applied and pressed according the glue manufacturer’s recommendations. Vacuum and other presses may also be suitable. Note that veneer pressing is a skilled job best undertaken by experience panel layers. Hand lamination is generally not recommended except by those experienced in this, nor are contact adhesives recommended as these tend to cause the veneer to peel off - especially if a solvent based coating is applied. To prevent warping and bowing, a balancing veneer in the same grain-direction as the face veneer, and same thickness, moisture content and general type/tensile strength of veneer should always be used on the back of veneered panels.

Trimming & Sanding

It is preferable for veneered boards to be coated immediately after sanding, because raw wood exposed to air may oxidise and discolour.

Edging

Veneered panels should be edged with veneer edge-strips or some other sealing process. This is important to prevent moisture ingress, to protect the edges of the panel and also for appearance.

Change in appearance over time

Veneered panels should never be used in the raw state but must always be finished with a suitable coating or sealer. These veneers may change colour over time, and with exposure to natural/artificial/UV light, air and excessive heat, just as timber will. This is due to the intrinsic nature of lignin (which comprises about 30% of wood) undergoing natural oxidation. Also, the dyes may fade or discolour (like other dyed products).

Minimising colour change and Coating recommendation

Colour change can be reduced (but not necessarily eliminated) by:

- Coating all panels immediately after sanding
- Not using these veneers in situations where there is very bright light
- Never placing or using veneer or using veneered panels in direct sunlight
- Using UV filter-film and curtains/blinds on all windows, especially north facing and/or large windows.
- **Finishing the veneered panel with high quality non-yellowing 2-pack acrylic urethane designed for use with wood veneer for sealer and top coats, with manufacturer approved UV inhibitors added in the maximum amount recommended by the coating manufacturer. Sealer and coating film thickness to be as recommended by the coating manufacturer. Do not use water-based coatings.**
- Note that the wrong coating and/or sealer can cause rapid discolouration. Briggs Veneers takes no responsibility in cases where the wrong coating or sealers have been used.
- For best consistency of appearance, the same coating type and gloss should be used across the entire project by all contractors.

Download [Use of Veneer in humid conditions](#)

Download [Timber Veneer Association Manual](#)

This information is presented as a guideline only - expert advice should be sought with regards to coatings – please contact your coating supplier. As it is not possible to cover all associated manufacturing materials, conditions, products and methods, the end-user is responsible for carrying out the necessary tests and trials to check that the veneer, coating type, fabrication methods, associated materials and cleaning products/methods are suitable for the application.