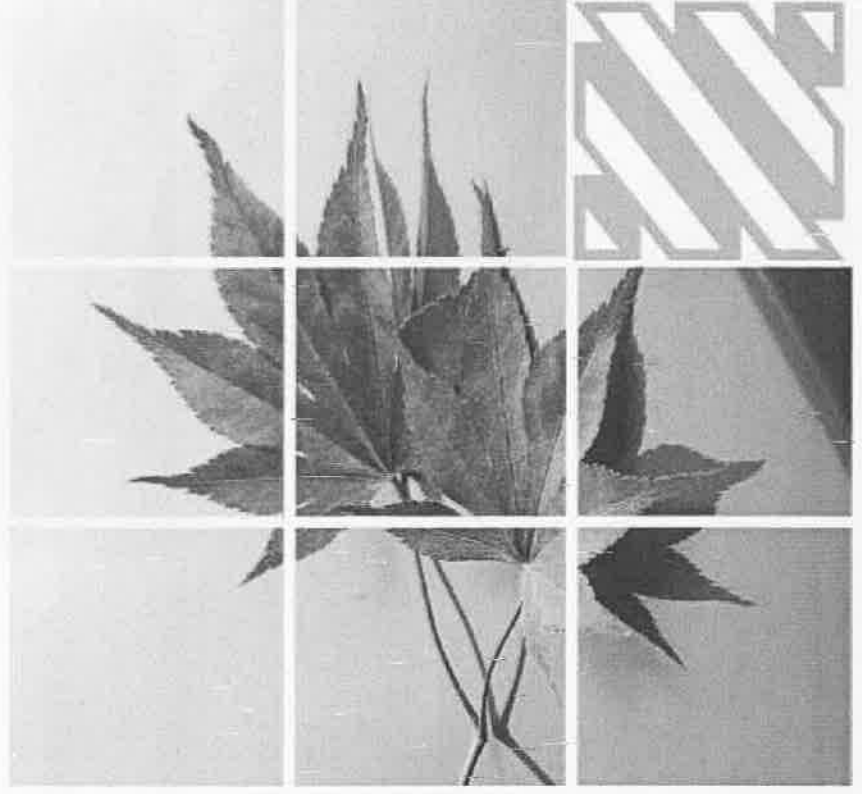


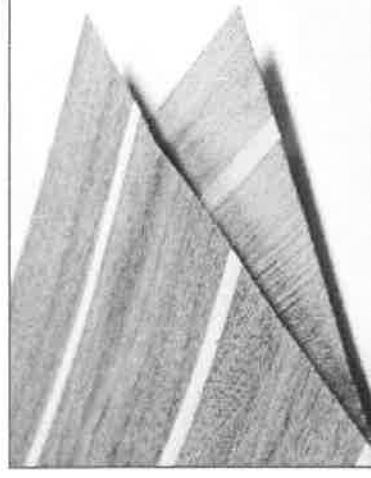
Training course Sanding - basic level



The main processes

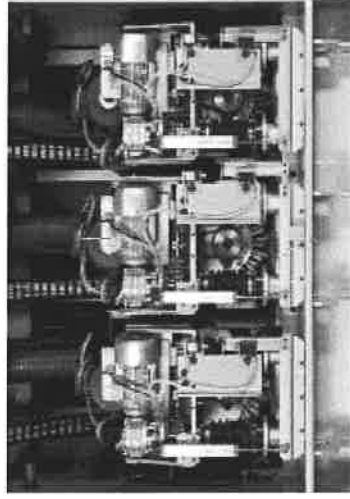
- There are many terms used by industry experts, which identify specific processes for surface treatment of manufactured
- list of the main processes related to the wood and composite materials:

- ✓ **Calibrating**
- ✓ **Presanding**
- ✓ **Sanding**
- ✓ Planing
- ✓ Enhancement of the pore
- ✓ Structuring
- ✓ Scratching
- ✓ Antiquing
- ✓ Brushing
- ✓ Trimming
- ✓ Polishing

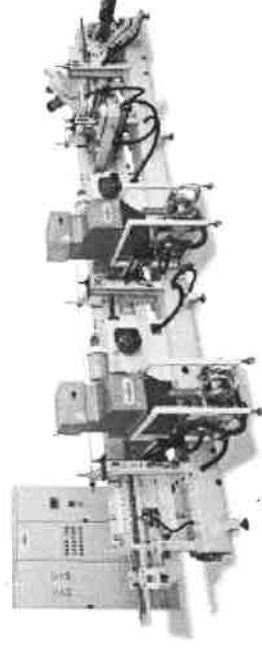
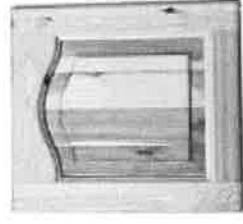


Machines

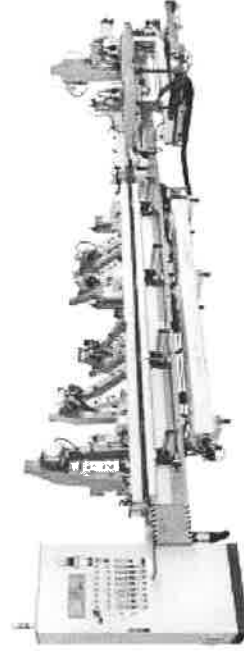
WOOD DIVISION



- ✓ Special machines with roller with flexible abrasive for processing of flat panels with bas-reliefs



- ✓ Automatic machine for sanding the edges of panels



- ✓ Automatic machines for sanding the surface profiles



Calibration

- Calibration is the process which enables a uniform thickness of a raw panel in its raw state, removing the portion of the excess material with abrasion, regardless of the starting thickness.

The operation of calibrating is performed mainly on:

- SUPPORT FOR THE COATING
 - with sheets of veneer, paper phenolic, melamine, or otherwise, by hot pressing, such as:
 - ✓ chipboard, MDF plywood, hardboard etc.. (components of furniture and furnishings);
 - ✓ honeycomb panels with chipboard, plywood, hardboard, MDF, hardboard etc.. (doors, furniture components and furnishings).

Note: In this case, calibration is always independent to the second phase of sanding which will occur after the coating

- SOLID WOOD PANELS
 - assembled or individual elements, such as:
 - ✓ windows, solid wood doors, kitchen cabinet doors, furniture elements and solid wood furnishings;
 - ✓ elements of chairs and tables, trims, moldings, ornaments etc..

Note: in this case calibration is mostly followed by sanding

Presanding

■ Presanding is a medium superficial abrasion of the artifact which would reduce the depth of the grooves produced by a previous calibration or trimming the grain in order to improve the results of the subsequent sanding

The operation of presanding is performed mainly on:

- SUPPORT FOR THE COATING
with sheets of veneer, paper phenolic, melamine, or otherwise, by hot pressing, such as:
 - ✓ chipboard, MDF plywood, hardboard etc.. (components of furniture and furnishings);
 - ✓ honeycomb panels with chipboard, plywood, hardboard, MDF, hardboard etc.. (doors, furniture components and furnishings).

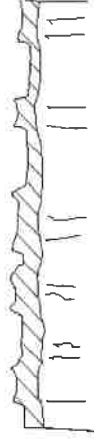
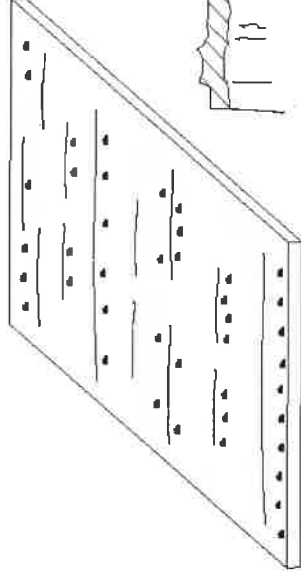
Note: In this case, calibration is always independent to the second phase of sanding which will occur after the coating

- SOLID WOOD PANELS
assembled or individual elements, such as:
 - ✓ windows, solid wood doors, kitchen cabinet doors, furniture elements and solid wood furnishings;
 - ✓ elements of chairs and tables, trims, moldings, ornaments etc..

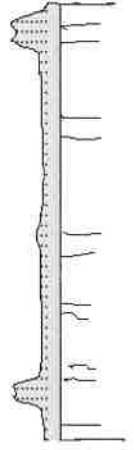
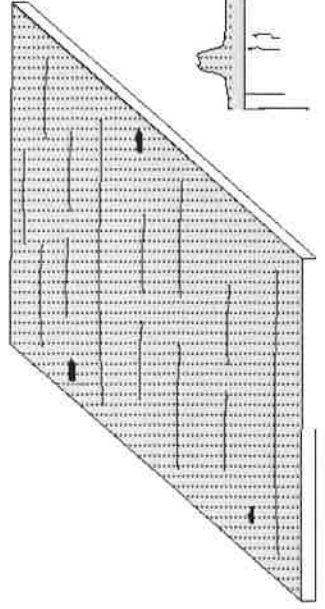
Note: in this case calibration is mostly followed by sanding

Presanding

- ❑ LACQUERED PANELS to flatten the superficial waviness of a consistent paint film caused by its drying phases (ex. polyurethane and close-pore polyester paints).



- ❑ LACQUERED PANELS WITH PARAFFIN to flatten the superficial waviness of a consistent paint film caused by its drying phases, and to remove surface paraffine residuals (paraffined polyester paints with closed-pore).



Sanding

■ Sanding is a slight surface abrasion that smooths and improves the finish (roughness) on the surface of the piece before painting and / or between an application and the other of lacquer, regardless of the thickness

The operation of sanding is performed mainly on:

- THE SANDING OF SOLID WOOD WORKPIECES OR RAW VENEERD PANELS
To remove completely surface imperfections or defects of manipulations (scratching)
To make the panel rough with abrasive belt of fine-grained to allow the correct and uniform absorption of the dye, with good adhesion of the sealers.
Limit the lifting of the wood fibers in the subsequent coating operation
- MDF OR CHIPBOARD WORKPIECES intended for coating with paint or plastic film
To roughen the surface of the panel and allow the grip of the basecoat.
To reduce the signs of the abrasive belt used in the previous phase of the processing cycle
- LACQUERED WORKPIECES
To achieve a uniform appearance and a surface roughness (effect "satin")
To allow a correct and uniform adhesion of the subsequent coat of paint or finish
To remove scratches manipulation