Veneer Systems Inc.

Shipping
Shipments within the USA and all other countries except Canada are shipped FOB Buffalo, NY. Canadian shipments are shipped FOB Fort Erie, Ontario, are invoiced in Canadian dollars, and are assessed a $17.50 CAD brokerage fee per order, regardless of order value. We accept Master Card, Visa and American Express.

Consultation
Each client has specific objectives for their veneer department; higher quality, increased yield, higher production, labor savings or lowering costs. Our equipment recommendations are presented after we have a thorough understanding of what you are making, how you are making it and what your goals are. For each veneering process we have multiple options depending on your situation.

Installation and Training
Our installation team consists of people who know more than just the machine, they know veneer. It is the transfer of that knowledge that leads to more than just a successful installation, it becomes a change in the fundamental processes of your veneer department.

Spare Parts for Veneering Equipment
We stock a wide variety of parts for Ruckle, Haug, Ompec, Kuper, Casati, Hofer and many other manufacturers; AFN, AFE, FZS crossfeeds and guillotines with glue applicators. We can supply retrofit digital readouts, NC controls, laser lines, replacement platens and safety curtains for your veneer machinery.
Jonting
Veneer Saw
Miracle Veneer Trimmer
Veneer Saw
Guillotine

Splicing
Veneer Tape
Hand Held Zig Zag
Table Top Zig Zag
Solid Glue Line

Gluing and Pressing
Hand Glue Applicator
Glue Spreader
Vacuum Pressing
Hot Pressing

Trade Shows
We exhibit at the following woodworking shows. We invite you to stop by for some hands on veneering. Visit our website www.veneersystems.com for booth numbers, dates and times.

Ontario
Toronto, ON
October 2009

Michigan
Grand Rapids, MI
Fall 2009

Florida
Orlando, FL
December 2009

Washington
Tacoma, WA
November 2008

New Jersey
Trenton, NJ
April 2009

Quebec
Laval, QC
October 2008

Ohio
Columbus, OH
November 2009

Virginia
Fredericksburg, VA
March 2008

Ligna
Hanover, Germany
May 2009

Ontario
Toronto, ON
October 2009

Georgia
Atlanta, GA
August 2008

Connecticut
Hartford, CT
May 2008

North Carolina
Charlotte, NC
January 2009
A Complete Guide to Hardwood Plywood and Face Veneer
Table of Contents
Variations in Hardwood Plywood Face Appearance
Veneer Manufacturing Process
Types of Matching Grades and the Product Standard
Substrates
Hardwood Plywood Manufacturing Process
Meeting Customer Expectations
Trouble Shooting Common Problems

Veneering - A Handbook
Table of Contents
Materials
Tools and Equipment
Preparing veneers Laying veneers Cross banding
Book matching and quartering
Inlaying Parquetry
Finishing and polishing

World Woods in Color
Table of Contents
Alphabetical list of woods with images Examples of exotic grains and burls
Table of uses Indexes of -standard names -vernacular, trade & other names -botanical names -family names

HPVA Veneer Species Guide
A guide to the commercially available veneer species with color plates of each species. Common names, Latin names, source, color, pattern and characteristics are given for each species.

Simple Marquetry
Table of Contents
Marquetry, How to -Wood veneer -Cutting and taping -Substrates -Adhesives -Methods of bonding -Finishing Marquetry gallery Marquetry projects Project patterns

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Multimedia

Working with Veneer - focuses on the basic skills of veneering. From raw veneer to a completed 4 way matched walnut burl table top. Topics include: tools and jigs, flattening buckled veneer, matching & sequencing, different types of glues, jointing, taping and gluing techniques. If you've wanted to try your hand at veneering but lack the technical knowledge to try, this video will give you the confidence to move forward and make something beautiful. Available on VHS and DVD Made in USA

Working in a Vacuum - for those comfortable with veneering basics who want to learn advanced techniques, this video explores curved and shaped work. This video covers: constructing curved forms, creating curved panels, veneering a cylinder and bull nose shelf using two step gluing techniques, applying veneer to moldings, laminating an arched jam and spiral staircase stringer - as well as a section on pump and bag maintenance. If you want to maximize vacuum's potential in your shop "Working in a Vacuum" will advance your veneering skill. Available on VHS and DVD Made in USA

Marquetry Vol. 2 - a 133 minute video. A continuation of Decorative Veneering this is a project oriented study, complete with instructions for creating a 16 piece radial match and a floral marquetry panel from start to finish. It also covers the history of marquetry, new hand and machining techniques, marquetry design, sand shading, time saving tips, trouble shooting solutions, edging details as well as information on supplies and tools. Comes with a companion booklet for quick reference. Available on VHS and DVD. Made in USA

Decorative Veneering - an 80 minute video. Learn to sharpen your tools properly, cut your own inlay, recess bandings into a face, make your own inlay strips, develop the look of a four way match, adhesive selection and finishing.

The companion booklet includes additional information on design theory, detailed instructions, illustrations, and an extensive glossary, resource list . Available on VHS and DVD. Made in USA

From the Bark to the Heart - How do you make veneer and plywood? This 20 minute educational presentation by the Canadian Hardwood Plywood Veneer Association shows you how.

An excellent tool for employees and clients on wood veneer manufacturing and secondary processing. Available on DVD. Made in Canada
Veneer Tape

Our veneer tape is made with acid free kraft paper or cellulose. Vegetable based adhesives provide a superb bond and easy removal.

Weights and Styles
34 gram white, 40 gram brown and white
Plain (no hole), 1, 2, 3 hole perforations

Widths Roll Lengths Styles
3/8, 1/2, 5/8, 3/4, 1 inch 650 and 1300 feet
10, 12, 15, 20, 25 mm 200 and 400 meter

We stock over 70 different types of tape.

Should I use plain or perforated veneer tape?
Plain tape is more easily removed as it does not tear at the perforations. Three hole, with the larger center perforation, allows you to see the splice line and be sure the joint is tight yet takes a little more effort to remove.

How do I remove veneer tape?
Use a damp sponge or cloth to lightly moisten the tape and then scrape off as much as possible before sanding off the balance.

After I remove the tape I can see where it was?
Several species are subject to tone changes with exposure to UV light. Keep the faces covered or upside down. You may have hard water and mineral deposits that can be seen. If you suspect this, try using distilled water. Excess water can cause grain deformation.

Stik Gum
In high humidity conditions or cold environments Stik gum increases the “stickiness” of veneer tape.
Add one package to five gallons of water and use in your veneer tape applicators and dispensers.
Tape Dispensers

Bench Top Pull & Tear

Bench Top Pull & Tear - Does not scrape off the adhesive as with brush type applicators. You can have several styles of veneer tape readily available for different applications. The cloth applicator roller applies a measured amount of water, ensuring a secure bond without saturating the tape or the veneer.

<table>
<thead>
<tr>
<th>Item</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Krolf 40</td>
<td>1-1/2 inch throat</td>
</tr>
<tr>
<td>Krolf 80</td>
<td>3 inch throat</td>
</tr>
</tbody>
</table>

Hand Held Taper

Hand Held Taper - Excellent for larger panel tape layups. Also used behind cross feed splicers for quick joint repair and end taping. A moist sponge is located in the handle. You apply pressure with your fingers as you are rolling along the joint. Max. tape size - 1in W x 650 ft L

Item: FUA-1

The Grip

The Grip - A masking tape applicator for quick and easy end taping. The applicator has a rubber pressure roller to ensure a good bond of tape to veneer. Use with masking tape product number HR1255
Adhesives

MPA II - A precatalyzed PVA cross link emulsion best suited for RF and hot press veneers. Provides excellent bonds and high shear strength on hardwoods.

Exceeds Type II water resistance criteria (ANSI/HPMA 1983). Available in 1 gallon jugs and 5 gallon pails.

FSV / Flexible Sheet Veneer - is a fast tack PVA formulated for paper backed veneers. Its bond is formed by using a veneer hammer or veneer scraper for pressure. Perfect where fast tack and quick set with minimum pressure is required. Available in 1 gallon jugs and 5 gallon pails.

MPA Veneer - is a PVA with a moderate set speed and good heat resistance. The high solid content provides for excellent pore and check filling, which minimizes bleed through. Meets ASTM D 4317-86 Type III Specification. Available in 1 gallon jugs and 5 gallon pails.

MPA Fast - A PVA with a fast set time making it ideal for doweling and general assembly where a short assembly time is required. Available in 1 gallon jugs and 5 gallon pails.

MPA Slow - A PVA with a slow set speed, very high heat resistance and long open time. Formulated for bonding when a slower set time and long assembly time is desired. Available in 1 gallon jugs and 5 gallon pails.

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<table>
<thead>
<tr>
<th>Viscosity CPS</th>
<th>MPA Veneer</th>
<th>MPA Slow</th>
<th>MPA Fast</th>
<th>FSV</th>
<th>MPAII</th>
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<tbody>
<tr>
<td></td>
<td>8000</td>
<td>4500</td>
<td>5000</td>
<td>8000</td>
<td>4000</td>
</tr>
<tr>
<td>Veneer spread</td>
<td>4 - 7 mils</td>
<td>4 - 7 mils</td>
<td>6-9 mils</td>
<td>4 - 7 mils</td>
<td>6 - 9 mils</td>
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<tr>
<td>Open time Minutes</td>
<td>5-10</td>
<td>15 - 45</td>
<td>5</td>
<td>4</td>
<td>5</td>
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<tr>
<td>Percent Solids</td>
<td>45 - 47</td>
<td>43 - 45</td>
<td>56</td>
<td>52 - 58</td>
<td>50</td>
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<tr>
<td>Min. use temp F</td>
<td>35</td>
<td>45</td>
<td>53</td>
<td>55</td>
<td>50</td>
</tr>
<tr>
<td>Storage at 70F</td>
<td>6+ months</td>
<td>6+ months</td>
<td>6+ months</td>
<td>6 months</td>
<td>6 months</td>
</tr>
<tr>
<td>Color</td>
<td>Tan</td>
<td>Yellow</td>
<td>White (dries clear)</td>
<td>Lt. Pink</td>
<td>White</td>
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</tbody>
</table>
PPR - Urea Resin adhesive is a precatalyzed powder. Glue line characteristics include high strength, minimal to no spring back, thermoset, Type II water resistance and excellent heat resistance. PPR may be hot pressed, cold pressed or RF cured.

The mix ratio is 100 parts water to 50% to 65% powder. PPR has an approximate pot life of four hours at 70 degrees fahrenheit. Ideal moisture content for the veneer is 8% to 10%. Available in 1 gallon pails, 5 gallon pails and drums.

Resorcinol is a two part liquid resin which provides waterproof bonds down to -40 degrees F. Pot life is 3 hours at 75 degrees F. Available in a one gallon kit.

Unibond 800 resin and catalyst C800 hardener create a modified urea formaldehyde adhesive. The distinctive properties include a rigid glue line, excellent gap filling, high water resistance, check resistant bond, mixes easily, adjustable set time and low shrinkage.

Unibond 800 blends easily with the C800. The catalysts are available in three tones light, medium and dark. Available in one gallon jugs.

RPA - Reactive Polyurethane Adhesive is a one part, moisture curing adhesive that is highly resistant to water and heat. Available in 16 oz. bottles and 1 gallon jugs.

Melamine is a vinyl acrylic emulsion with a fast set speed and low minimum use temperature with excellent bonding characteristics to dissimilar substrates. Available in 1 gallon jugs and 5 gallon pails.

<table>
<thead>
<tr>
<th></th>
<th>PPR</th>
<th>Unibond 800</th>
<th>RPA</th>
<th>Melamine</th>
<th>Resorcinol</th>
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<tr>
<td>Viscosity CPS</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Veneer spread</td>
<td>5 - 7 mils</td>
<td>5 - 7 mils</td>
<td></td>
<td>3700</td>
<td>n/a</td>
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<tr>
<td>Open time Minutes</td>
<td>40</td>
<td>30 min @ 70F</td>
<td>n/a</td>
<td>10</td>
<td>various</td>
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<tr>
<td>Percent Solids</td>
<td></td>
<td></td>
<td></td>
<td>55</td>
<td>n/a</td>
</tr>
<tr>
<td>Min. use temp F</td>
<td>70</td>
<td>65</td>
<td>40</td>
<td>35</td>
<td>70</td>
</tr>
<tr>
<td>Storage at 70F</td>
<td>1 Year</td>
<td>5 months</td>
<td>1 Year</td>
<td>6+ months</td>
<td>1 year</td>
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<tr>
<td>Color</td>
<td>Tan</td>
<td>Catalyst specific</td>
<td>Amber</td>
<td>White</td>
<td>Purple / Brown</td>
</tr>
</tbody>
</table>
Veneer Treatments

**Veneer Softener** - treat crotch or burl to minimize / eliminate checking.

- Mix the softener with an equal amount of water before use.
- Apply the solution by dipping, brushing or spraying. Be sure the veneer is completely covered with the solution.
- Allow veneer to stand until the surface appears dry, approx. 20 minutes.
- After they appear dry, stack overnight under pressure for use the next day.

The effect lasts about 24 to 48 hours so it is not advisable to prepare stock well in advance of use. One year shelf life at 70 degrees F / 21C, cleans up with warm water. Available in 1 gallon jugs, 5 gallon pails and 55 gallon drums.

**Glu Siz** - a resin emulsion formulated to seal the pores of wood for subsequent gluing and finishing operations. It retards moisture movement in and out of wood and composite wood materials. It sands well and seals end grain prior to gluing or finishing. One year shelf life at 70 degrees F / 21C.

Glu Siz may be used full strength as received or diluted up to a 1:1 ratio of water by weight. Maximum effect is achieved with lower water dilution. Available in 1 gallon jugs and 5 gallon pails.

### Measurement

**Moisture Meter** - The MiniLigno-E is the most popular moisture meter on the market. Perfect for checking the MC of veneer, as well as lumber, fiberboard and other materials.

**Cordix Thickness Gauge**
Features a locking pressure bar, adjustable lower pad and galvanized components.
Calibrations 1/10mm, Range 0 to 1 inch
Throat 1.25 inches, Pad - 3/4 inch diameter

**Mil Thickness Gauge**
A two inch by three inch gauge for determining proper glue density.

Graduations:
- 1 mil to 12 mil by 1's
- 14 mil to 30 mil by 2's
- 35 mil to 80 mil by 5's
Pfohl Glue Spreaders - provide a consistent coating of adhesive on flat and curved surfaces. Ideal for core coating, block board and bent laminations. Adhesive roll out is regulated by opening and closing the dam with no overflow. Sponge rollers are for PVA's and Gray rollers are for PVA's and Ureas. Specify roller type.

<table>
<thead>
<tr>
<th>Item</th>
<th>Width</th>
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<tbody>
<tr>
<td>Pfohl 45</td>
<td>1 1/2 inch / 45mm</td>
</tr>
<tr>
<td>Pfohl 75</td>
<td>3 inch / 75mm</td>
</tr>
<tr>
<td>Pfohl 150</td>
<td>6 inch / 150mm</td>
</tr>
</tbody>
</table>

Pizzi Glue Dispenser - PVA glue is stored in the tank under pressure. The operator squeezes the handle to allow the flow of glue. Glue is released through the nozzle on demand, providing an even, consistent and continuous adhesive coating to the workpiece. Easy cleanup of nozzles with faucet adapter.

Package includes:
Tank, 12 foot hose, universal nozzle and faucet adapter

<table>
<thead>
<tr>
<th>Item</th>
<th>Capacity</th>
<th>Ports</th>
<th>Material</th>
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</thead>
<tbody>
<tr>
<td>9001</td>
<td>2 Gallon</td>
<td>Two</td>
<td>Brass &amp; Steel</td>
</tr>
<tr>
<td>9012</td>
<td>3 Gallon</td>
<td>Three</td>
<td>Stainless steel</td>
</tr>
<tr>
<td>9021</td>
<td>5 Gallon</td>
<td>Three</td>
<td>Stainless steel</td>
</tr>
</tbody>
</table>

Additional Nozzles
Biscuits, Finger joint, Mortise and Tenon, Five different brushes, Double and triple dowel and many others.
Hand Tools

**Ulmia Hand Veneer Jointer**
Features a European Beech handle, stable 2mm thick jointing blade and steel sole plate. Make two or three passes along a straight edge to make crisp, clean joint lines with no tear out.
VSI 744 Complete tool
VSI 782 Jointing blade
VSI 780 Inlay blades

**Kunz Veneer Hammer**
The traditional tool for hammer veneering with hide or FSV glue.
VSI 799

**Ulmia Edge Trimmer**
The blade has an angle of cut which eases into the veneer and is guided along the substrate by the fence.
The handle is European Beech
VSI 740 Complete tool
VSI 784 Spare blade

**Radzi Edge Trimmer**
The blade is aligned to the core by placing the guide against the substrate. The tool is drawn along the veneer to trim it flush to core. The alignment guide can be adjusted for trimming the veneer against a beveled substrate (as shown on right).
VSI 747 Complete tool
VSI 749 Spare blade
Veneer Saw
The traditional tool for jointing veneer
VSI 727  Complete tool
VSI 731  Spare blade

**VSI Veneer Defect Punches**
The irregular shape of the punch aids in camouflaging the repair section. The punch cuts on the inside with a spring loaded knockout and solid hardwood or brass handle. Heat treated to hold cutting edge longer.

Sizes: Irregular 13, 18, 20, 25, 32, 45 and 62mm
Made in USA

**Straight Edge** - A 26” brass flat and plywood straight edge for straight line cutting.
VSI Straight Edge

**Tongs** - For precision handling of veneer and inlay. The tips are precision ground to easily scoop, pick up or handle small objects.
VSI V-Tongs
Made in USA

**Veneer Tape Scraper**
This specially sharpened and honed flexible putty knife facilitates the clean and efficient removal of gum tape after the face has been pressed onto core.
VSI 712
Made in USA
Guillotine Supplies

Knives
For all guillotines. We are able to provide knives for all makes and models of guillotine. Knives are manufactured to your specifications. Provide us with a drawing of the knife to receive a custom quote. Include thickness, height, length, bolt hole pattern and grinding angle specifications.

Cutting Plates
Rigid plastic plates and polyurethane mats are available for all makes and models of double knife guillotines. All plates are ordered to your specification.

Double Sided Tape
Wide format, high strength double sided tape for securing your double knife cutting plates.

Cutting Sticks
For all guillotines. These durable, self healing sticks are designed to extend the life of your knife. All cutting sticks are ordered based on your size specifications. Provide us with the thickness, depth and length of your stick for a custom quote.

Zig Zag Supplies

Glue Thread
For all makes and models of zig zag splicers, end taping machines and composers.

Standard Heat    Air Heat    Hand Helds
910 and 911       921           H11

Trenmittel
Release agent for all makes and models of zig zag splicer. 5 liters.

Hot Press Supplies

Mylar
Temperature resistant, 10 mil
Stock widths: 65 inch
Special Order Master Rolls
525 ft long x Specified width

Press Pads
Press pads compensate for irregular pressing surfaces caused by uneven veneer thickness or poor press platen tolerance. The pads increase the coverage density thereby improving the bond. Also used as a cure cushion when pressing laminates.

Release Agent
Release agents available for PVA and UF glues. Coat your platens to prevent glue build up. Sizes: 1 Liter, 1 Gallon, 5 Gallon and Drums

Splicing Supplies

Inline Splicer Glue
Precatalyzed urea resin with modifiers for solid glue line splicers with inline glue applicators. This adhesive is designed for use with all inline solid glue line splicers. Light tan 45lb bag

Spray on / Roll On Splicer Glues
Urea Formaldehyde and PVA based splicing glues. UF in a tan powder with available tinting agent for lightening the glue line. PVA's dry clear. Light tan color. 1 Gallon, 5 Gallon and Drums

Release Agent
Splicers / Edge banders
Release agents available for PVA and UF glues. Coat your heater bars to reduce glue buildup. Sizes: 1 Liter, 1 Gallon, 5 Gallon and Drums
Famowood
Water based wood filler - No mixing, spreads smoothly into large holes, cracks and defects in unfinished wood. Fast dry time, ready to sand, saw, stain, nail, paint or plane within minutes without cracking or crumbling.
High solid content takes stains like real wood. Stronger than the wood it replaces with little to no shrinkage. Available in 1/4 pints, pints, quarts, gallons and 5 gallons
Colors: Birch, Walnut, Oak, Red Oak, Golden Oak, White Pine, Cherry / Dark Mahogany and Fir / Maple

Busse Heater Bars
Recommended for bonding veneer and plastic edgebands. Manufactured from aluminium profiles, anodized silver, constant surface temperature. They have a cross section of 2.5 x 1.8 inches and heat on all four sides.
Standard lengths are 43, 63, 82, 102, 122, 141 and 161 inches, maximum temperature 392°F 200°C., 220 single phase electric.

Bessey- K Body Clamps
Superior strength, heavy duty components. Sustains clamping pressure throughout pad surface. Durable plastic clamping pads, spinele, steel rail, and internal parts are all replaceable. Clamping area of 3 1/2" x 1 3/4". Clamping pressure of up to 1000 lbs.
Sizes: 12, 24, 31, 40, 50, 60, 82 and 98"

Bessey Edge Clamps
Heavy-duty galvanized steel threaded spindle, aluminum die-cast body and pivoting pads provide for a wide variety of edge clamping needs. Clamping pressure up to 500 lbs.
Material thickness range: EKT 55 - 1/4" to 2-1/8"

Busse Custom Heating Platens
Ever thought about making your own hot press? Not every woodworker needs a 4x8 hot press. We can provide you with electrically heated platens as small as 12 inches by 12 inches and a temperature controller.
Provide us with your desired platen dimensions, and number of platens and we will provide you with the heating platen(s) and a temperature controller. You source the press frame and pressure system and you'll have a press designed and made to your specifications.
Jointing

**Miracle Veneer Trimmer**
Turn an existing shop tool into a precision veneer jointer.

**MVT**
A pressure system of opposing wedges clamps the veneer firmly under pressure. A tool steel bar which fits exactly in the slot or your table gives a precise cut. A 90 degree guide allows for precision cross cuts of veneers up to 20” wide. Available in 48” and 96” lengths for a sliding table saw, table saw or circular saw. Threaded inserts premounted for future option bolt ins.
Made in USA

**Hofer Veneer and Panel Saw - FSP** For cutting veneers, core, wood, lumber, plexiglass and light metals.

**Precision Guidance**
The saw and milling units travel on linear guide rails. The linear guide rails ensure zero tilt and cutting accuracy.

**Saw / Milling Head Adjustment**
The milling unit is adjusted pneumatically on linear guide rails. Saw blade axis adjustment. Both units can be used independently or simultaneously.

**Rear Support Table**
A hand wheel provides for fine adjustments of the fence and the fence can be pneumatically locked into position for repeat cuts.

Standard width range is .6” to 24.4” (15mm to 620mm). Custom fence depths are available. Another option pneumatically lowers the fence fingers into the table which allows clear pass of materials from the back of the machine.
Hofer Veneer and Panel Saw - FSP Automatic
For cutting veneers, wood, lumber, core, plexiglass and light metals.

Standard Equipment
- 180mm saw blade
- 4 x 1.2 x 2” Milling cutter
- Pneumatic saw blade adjustment
- Automatic cutting tool feed
- Rear support table

90 degree reference
- Dust extraction channel
- Tool kit
- Automatic cutting tool feed
- Five operating modes
- Gear rack balance

Casati SNC Hydraulic Veneer
Guillotine Model TSO
Ideal for custom manufacturers, cabinet shops and mid volume veneer operations.

- Single 5.5 HP hydraulic motor
- Swing arm knife motion
- Gear rack torsion bar
- Full automatic cut cycle
- Cross cut and miter cut guide
- Motor driven rear register
- Full safety systems
- Sizes: 104 and 122”

Casati SNC Hydraulic Veneer
Guillotine Model TOP
Industrial production manufacturers

- Independent hydraulic motors
- Swing arm knife motion
- Gear rack torsion bar
- Automatic cut cycle
- Cross cut and miter cut guide
- Motor driven rear feed
- Full safety systems
- Sizes: 104, 126, 141, 157, 177”

The console controls
- Cutting size
- Five operating modes
- Cutting speed adjustment
- Power switches
- Emergency stop
Splicing

Hand Held Zig Zag

VSI ZZ - Hand Held Splicer
Tired of spending your time applying & removing veneer tape? Use our hand held splicer to get the job done. Take your layup from the press and go immediately to finish sanding. The glue thread gets buried in the glue line against the core material.

This hand held splicer is used to splice straight and free hand joints. Can also be used to reinforce end grain. You can start and stop the splice at any time. The front drive wheels are slightly knurled and angled to pull the joint together nice & tight just prior to the thread application.

Ideal for custom shops, one off piece work, prototype departments and more. The light, compact design weighs only 4 pounds, heats up in 3 or 4 minutes and you are ready to splice. No threaders or nozzles are required. Uses H11 glue thread.

Made in USA

Table Top Zig Zag

VSI Zig Zag 27
Veneer is placed on the table face up, against the alignment guide and forward against the infeed rollers. By pressing the foot pedal, the veneer is fed forward and glue thread is applied, it passes through compression rollers and the process is complete. Uses 911 and 910 glue thread.

Features / Benefits
Eliminates the time intensive steps of taping and tape removal. Standard heat system, no threaders, nozzles or heater tubes are required. Automatic independent compensation for veneer thickness variations.

Specifications
Throat depth 27.5 inches, Feed Speed 20 feet per minute, thickness range 1/10 to 1/50, 220 single phase
Made in USA

Glue Thread Repair Units

Kuper KHL-1 and KHL-2 Hand Held Repair Units
Straight line glue thread applicators for repair and end taping.

KHL-1 single spool unit
KHL-2 double spool unit
Furniertechnik LQM - LA
Solid Glue Line Splicer with inline glue applicator

The feed speed and glue application system are synchronized through the use of a single frequency inverter. The results are a near invisible splice line, less sanding and less adhesive usage.

Advantages:
• Reduces labor cost
• Improves quality control
• Eliminates the spray on station

Throat Sizes: 39, 48, 55 inches

Specifications
Minimum veneer width 1 1/2 inches
Minimum veneer length 12 inches
Throat Depth - Customer specific
Temperature range up to 446°F / 230°C
Veneer thickness range 1/10 in to 1/64 inch
Controls: pressure, temperature & feed speed
Variable speed range 33 fpm to 131 fpm
Heating zone is 39 inches long
Compressed air required 84 psi, 1cfm
Dimensions 75”L x 7’W x 75”H

Casati SNC Hydraulic Cross Cut Clipper
Model TSI
Heavy main frame
Movable control unit for easy positioning
Front and back work tables
Lexan guard allows view and protection
Cutting edge light

Casati SNC Veneer Waste Chipper
Model TSM-800

Designed to chop veneer waste into small chips to reduce veneer waste volume. One cross cut knife with ten knives set perpendicular to it. Easy jam cleanup by reversing the feed belt. Capacity 25” x 3.5” cutting with 56 knife strokes/min. Feed speed 2 - 11 fpm.
Vacuum Pressing

Common Features
Self-adjusting oil-less rotary vane vacuum pump with thermal overload protection.
Maximum vacuum of 27" HG / automatic shutoff at 25" HG (1774 lbs. per sq. foot).
Easy access, see-through filter jar for dust removal, quick disconnect between pump
and bag, adjustable micro-pressure switch maintains consistent vacuum level, vacuum
gauge and lighted on/off switch for monitoring. 110 volt standard, 220 single phase
available via special order. Manual with instructions on pressing veneers, curved work,
and adhesives. One-year limited warranty.
Made in USA

Industrial Polyurethane Bags:
All poly bags have heat-welded seams and clampless, airtight vacuum hose attachments. Bags for the Hi-Flo
model have two extraction ports.

Sizes: (Sizes represent actual pressing capacity.)
30 mil industrial poly: 49" x 49", 49" x 97", 49" x 121,
49" x 145", 61" x 121", and 61" x 145"
Made in USA

The FlipTop System - Complete vacuum press kit
with instructions on assembly and making your own
table or with RTA base assembly

Features:
1 1/4" anodized aluminum extrusion for a light but
strong frame, assembled with special connectors, tough
30 mil polyurethane membrane with six inch pleats.
Barbed insert strip locks membrane into the extrusion
for a solid connection, multi-ribbed neoprene gasket for
airtight seal, pneumatic cylinders opens frame for con-
venient loading and unloading (base and frame kit).
Gas springs supplied with flip top frame kit.
Comprehensive step by step instruction manual for
easy assembly.

Sizes: 49" x 97", 49" x 121", 61" x 97" and 61" x 121"
Made in USA
Hot Pressing

**Hofer Four Post Hot Press**
- Twelve minutes to 194 degrees F
- Economy heat mode to minimize electric demand
- Heavy duty gear rack balance
- Maintenance free submersible pump
- Automatic or manual opening selection
- Automatic low to high pressure

**Heating Mediums**
- Electric, Hot Water, Thermal Oil, Steam

**Hydraulics**
- Teflon bronze cylinder guides
- 3.5 inch diameter cylinders, 16 inch stroke

**Safety**
- Limit switches and perimeter safety line

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**Hofer Glue Spreader - Knife Coater**
There is one top and one lower roller. The mil thickness of your adhesive is determined by the distance between the edge of the glue reservoir and the applicator roller.
- Stock Sizes: 51 and 63 inches

**Hofer Glue Spreader - Double Roller**
There is an applicator roller and doctor roller on the top and on the bottom. The mil thickness of the adhesive is determined by the gap setting between the rollers.
- Standard Sizes: 51 and 63 inches

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**Hofer Minimum Contact Table**
- Adjustable working height
- Working height 28 to 38 inches
- Stainless steel disc rollers
- Disc diameter 4.6 inches
- Galvanized water tank
- On center distance 4 inch / staggered
Case Clamps

**Hofer** Koptronik Case Clamp
**Features**
Standard working size 98.5in x 55in x 27.5in, Intercombing pressure walls, joystick control for eight movements, independent, pneumatically adjustable wall pressure.

**Options**
Custom working size, front layout tables, discharge rollerways with roller on all sides, builtin rollerway with air jets, combination discharge rollerway and uprighting station

**Hofer** KP 1500 Case Clamp
**Features**
Standard working size 98.5in x 55in x 27.5in, Intercombing pressure walls, joystick control for eight movements, independent adjustable wall pressure.

**Manual Operation**
The joystick control’s single or multi axis closing at the operators discretion.

**Koptronik Case Clamp**
**Operation Modes**

**Manual Mode**
Joystick to control single or multi axis closing at the operators discretion

**Automatic Modes**

**Equal pressure**
The beams both close to .5 inches from the case. Then both beams close simultaneously and apply equal pressure.

**Automatic Squaring**
The horizontal beam closes to .5 inches from the case. The vertical beam closes all the way to square up the cases against the back stop. The vertical beam then retracts to .5 inches from the case and then both beams close simultaneously with equal pressure.

**Automatic Driving**
The vertical beam closes to .5 inches from the case. The horizontal beam closes and opens three times, providing the pressure to properly seat the joinery and obtain deep glue penetration. After the third opening, both beams close simultaneously.
**Flexer**

Veneer Flexer / Tenderizer

A quality machine available in single head or double head configuration. Requires fewer operators, less floor space and the veneer is automatically flipped over.

After processing the paper backed veneer is supple and pliable. This provides high quality veneer for postforming and profile wrapping. The veneer can easily be wrapped around tight bends without breaking. Maximum veneer thickness: 2 mm

**Stroke Sanders**

**Stroke Sander BSM IIIR**

Welded stress relieved steel construction
- Diameter of belt drive roller 150 mm
- Depth of throat on right side 900 x 300 mm
- Speed of sanding belt 22m/sec
- Dimensions of sanding pad 300 x 145 mm
- Dimensions of sanding table 2500 x 800 mm
- Dimensions of sanding belt 6400 x 150 mm
- Table stroke 300 mm
- Exhaust connection diameter 160 mm

**Stroke Sander BSM II**

Cast iron construction
- Depth of throat on right side 1000 x 320 mm
- Speed of sanding belt 22m/sec
- Dimensions of sanding table 2500 x 1000 mm
- Dimensions of sanding pad 300 x 150 mm
- Dimensions of sanding belt 6800 x 150 mm
- Table stroke 320 mm
- Exhaust connection diameter 180 mm