










Veneer specification Dalian
Offer for potential
suppliers

Requirements for delivery goods Quality




1、General Requirement




NO.	Key control point	Standard	Judgement		Illustration
			Clear lacquer	Stain	
1	MC	Inner veneer: 6%~10% Surface veneer: 10%~16%	All MC deviation can't be accept	All MC deviation can't be accept	
2	Dimension	Tolerance for length and width: 0~10mm Tolerance for thickness: $\pm 0.05\text{mm}$ Tolerance for the length of two diagonal: $\pm 20\text{mm}$	All dimension deviation can't be accept	All dimension deviation can't be accept	

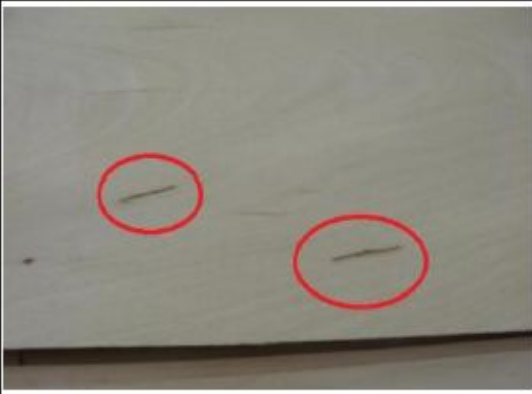


3	Width jointing	The width of surface veneer is joint by two pieces or no jointing. Rotary and slice joint into one is unaccept.	All deviation can't be accept	All deviation can't be accept	
4	Decay	Refused	Refused	Refused	
5	Mould	Refused	Refused	Refused	



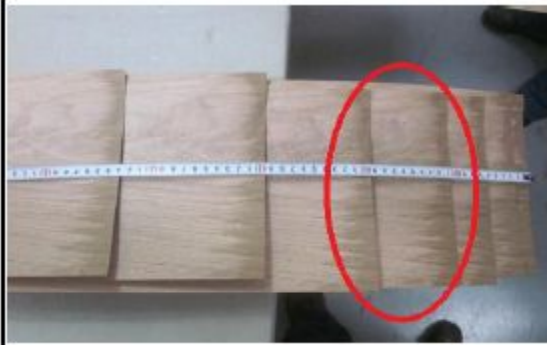

6	Broken	Refused	Refused	Refused	
7	Damaged by worms	Refused	Refused	Refused	



Veneer standard for surface veneer

NO.	Key control point	Standard	Judgement		Illustration
			Clear lacquer	Stain	
1	Right surface	1. Right surface and the opposite must be marked, 2. Width jointing-The surface of two pieces veneer must be the same, and marked it.	All deviation can't be accept	All deviation can't be accept	
2	Knot	Died knot and missing knot are refused. Living knot: $\varnothing \leq 5\text{mm}$, Amount $\leq 10\text{pcs}/\text{m}^2$, and only in one end of veneer.	All deviation can't be accept	For 9# & 25# stain: The amount of living knot $\leq 15\text{pcs}/\text{m}^2$.	
3	Inside crack	Refused	Refused	Refused	

4	Crack on opposite side	Sanding off the crack surface 0.1mm, and then bend veneer, the crack is invisible, it is ok. If the crack is visible, it is not ok.	Judgement after sanding	Judgement after sanding	
5	Thickness deviation	Look surface, no light through veneer, it is ok. If you can find light through veneer, it is not ok.	Judgement base on quality	Judgement base on quality	
6	Fibre missing	Refused	Refused	Refused	

7	Mineral line	On one end, and only happened within 1/3 of the total length of veneer(Color must be light, not concentrated, length of single mineral line≤20mm).	Judgement base on quality	Any positions on 25# and 9# articles(Mineral line must be covered by stain).	
8	Red heart	On one end, and only happened within 1/3 of the total length of veneer(Color must be light, length≤200mm).	Refused	Any positions on 25# and 9# articles(Red heart must be covered by stain).	
9	Bark inside	Amounts≤3pcs, Ø≤5mm Armrest: On one end, and only happened within 1/3 of the total length of veneer. Other components: Refused.	Judgement base on quality	Any positions on 25# and 9# articles(Bark inside must be covered by stain).	

10	Serious grain of oak	Refused	Refused	Refused	
11	Peeling mark	Armrest: On one end, and only happened within 1/3 of the total length of veneer. Other components:Refused.	Judgement base on quality	Judgement base on quality	
12	Discolor	Only on the end of veneer, light color, length≤20mm.	Judgement base on quality	Any positions on 25# and 9# articles(Must be covered by stain).	
13	Different colour	Comply with IKEA colour samples	Judgement base on quality	Any positions on 25# and 9# articles(Must be covered by stain).	

14	Distortion	Put one piece veneer on top of flat table, no gap, it is ok. If between veneer and take have visible gap, it is not ok.	Judgement base on quality	Judgement base on quality	
15	End crack	No gap for crack, length ≤ 100 mm, and repaired with paper adhesive tape, it is ok. Opposite, not ok.	Judgement base on quality	Judgement base on quality	

Remark:

1. The total defects rate must be $\leq 15\%$ in total incoming veneer.
2. Birch veneer apply on stain, should comply with standard.

Sizes

- **Birch surface veneer**

Size, m			<u>Appr.</u> %
1.7	0.29	0.00055	35.55%
1.65	0.29	0.00055	3.28%
1.2	0.29	0.00055	4.58%
1.38	0.28	0.00055	28.59%
1.1	0.28	0.00055	19.94%
1.6	0.29	0.00055	3.95%
1.25	0.29	0.00055	4.11%

- **Birch inner veneer**

Size, m			<u>Appr.</u> %
1.7	0.56	0.0015	38.42%
1.65	0.56	0.0015	2.01%
1.2	0.56	0.0015	6.64%
1.38	0.54	0.0015	26.24%
1.1	0.54	0.0015	11.20%
1.6	0.56	0.0015	8.70%
1.25	0.56	0.0015	6.80%

Length

Width

Thickness

Requirement the packages quantity

- Width 430-440: 2100 pics /pallet
- Width 540-560: 1400 pics/pallet