



# Edge and Surface

Finishing instructions for structured boards



**HOLZ IN FORM**

## The Options

### Flat structures with shallow pattern:

2201 Wave	2417 Stone-S
2252 Schilf	2343 Mosaik
2261 Sisal	2390 Delta
2308 Seetang	2395 Python
2432 Groove	2422 Schilfgeflecht

### Deep and narrow pattern:

2451 Split
2420 Stone-T
2468 Spalt
2430 Gneis

### Deep and wide pattern:

2344 Ocean
2369 Flame
2306 Dune
2450 Pluto

Our Options in structures:  
shallow structures,  
deep and narrow structures,  
deep and wide structures.

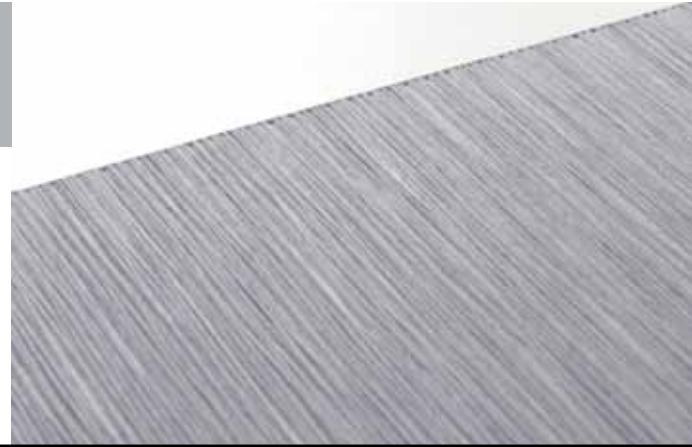
With standardised edge and surface treatment, we offer  
different structural characteristics.

We would like to provide some additional information for optimal results.

Please visit [www.holz-in-form.info](http://www.holz-in-form.info) icon English - Products -  
or - Processing for references, data sheets, drawings and videos.

## Edge construction of flat structures with shallow pattern:

Using conventional edge banding machines leave sufficient excess to allow further refinement.



Remove the edge banding excess with a router. To avoid damage to the edges it is advised to move against the grain at a 45° chamfer.



Primarily use small tool profiles for bevels or radius such as millers for 45° bevels or for 1.5 to 3mm radius.



Sand/finish the edge subsequently parallel to structure path with a sanding pad (approx. grain 100).



Finally clean the surface structure with a fine copper wire brush following the grain of pattern.



## Edge construction on deep and narrow structures

Using conventional edge banding machines leave sufficient excess to allow further refinement.



Refinish the excess length with a profile cutter. Primarily use small tool profiles. A ball bearing guide ensures a smooth tool guidance.



Use an appropriate sanding block to help with sanding in the narrow surface structures.



Sand/finish the edge subsequently parallel to structure path with a sanding pad (approx. grain 100).



Finally clean the surface structure with a fine copper wire brush.

## Edge construction on deep and wide structures

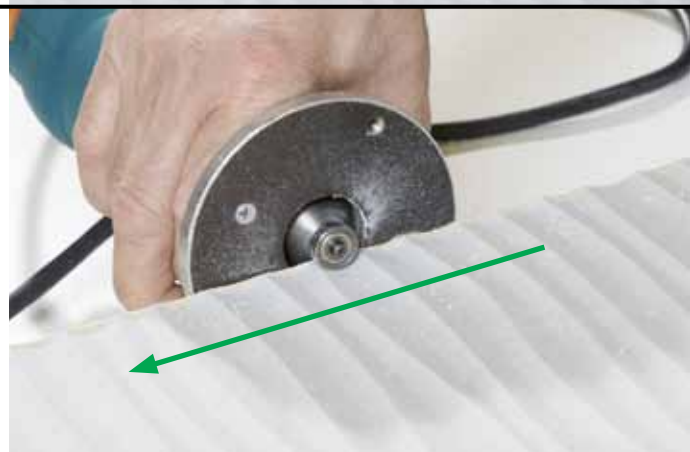
Using conventional edge banding machines leave sufficient excess to allow further refinement.



Refinish the excess length with a profile cutter. Primarily use small tool profiles. A ball bearing guide ensures a smooth tool guidance.



To avoid damages of the surface chamfer against your tools rolling direction.



Finish the edge with a craft knife in a 90° angle to the surface structure.



Finally clean surface structure with a sanding pad (approx. grain 100).



## Edge construction of Spalt linear and Spalt fiddleback



Spalt linear boards do not need edge banding however it is possible if required (see page 4). After cutting, trimming and crushing the edge - here is how we do it:

Mount 10 to 15 layers of sanding paper back to back separated by washers on a threaded rod and secure it with a nut at the end. Powered by a drill or cordless screwdriver this tool simplifies your finishing of our Spalt surfaces.



Finally clean surface structure with a sanding pad (approx. grain 100).

### Surface.

Before lacquering the whole surface needs to be sanded using pads or abrasive wool (approx. grain 100).

We recommend solvent based one or two-component lacquer (clear and coloured). The drying time should not be reduced by the addition of solvents as this could lead to weak integration with the substrate and a possibility of the lacquer not bonding to the surface correctly.












Subsequently, too much lacquer may result in uneven coverage on the surface structure and different hardening times could lead to bubbles and/or cracks. During the lacquering process, the large sheets need to be supported and stored correctly to avoid deformation due to the weight of the boards.

## Lacquering of veneered boards

Do not use water-based paint.  
 We do not recommend to stain Alpi-Veneers.  
 Colored pigments can be added to the clear lacquer to change the color of the veneer.  
 Please follow the lacquer supplier guidelines.

## Lacquering of boards coated with foil

Use water-based paint only in consultation with the technician of Holz in Form.

Surface: dull	Surface: high gloss	Surface: dull	Surface: high gloss
Prime coat 	Prime coat 	Prime coat with slight prime filler 	Prime coat with thick prime filler 
↓	↓	↓	↓
Sanding in between 	↓	Sanding in between 	Sanding in between 
↓	↓	↓	↓
Finishing clear Lacquer 	Finishing 2 times with sanding in between coverage 	Finishing 	Finishing 2 times with sanding in between coverage. Allow 24 hours for hardening 

You will find additional information on the different structures at [www.holz-in-form.info](http://www.holz-in-form.info) icon English - Products - or - Processing, data sheets, drawings and videos.

Please follow the lacquer manufacturers finishing guidelines.



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Pictures: Patrick Pantze Images

Conceptual design: M. Lange-Gandyra

