



HBF Furniture Products Veneer and Panel Standard

Purpose

This document is intended to act as an aid in the standardization in the selection and use of veneer and its application to substrate materials that are used in the manufacture of furniture products at HBF. To meet the requirements of our customers, this document will also serve as Quality Control criteria during the manufacturing and inspection process.

In addition this document will provide reference specifications, including diagrams, pictures and wood samples and will establish terminology and grading definitions

Grades and Grading

As no two trees are the same, a standardized grading system is necessary to describe the appearance of the veneer to be used by HBF. Industry standards have been developed to meet the general requirements of anyone requiring wood products. To insure consistent quality the Architectural Woodwork Institute (AWI) has generally adopted the established Voluntary Standard of the Hardwood Plywood and Veneer Association (HPVA) in the establishment of grades for wood.

Grade is a designation of the expected appearance for hardwood and veneers used in the manufacture of wood products. This document is intended to define grades and to standardize on the specific and unique requirements of our customers that may either meet or exceed the HPVA Voluntary Standard.

HBF Furniture Products Veneer and Panel Standard (cont.)

Veneer Grades

- Grade AA** The veneer shall be smooth, tight-cut, and full length with narrow heart cathedrals. Split hearts are not allowed. Natural color and grain contrasts should be avoided. Veneer leaves shall be slip and balance matched. Joints between leaves shall be tight with no sign of separation. “Bulls-Eyes” should be minimized and cannot be a predominant feature. Splits in the veneer within a leaf are not allowed. No leaf clip width shall be less than 6” (152 mm) and no more than 12” (304mm). Approximately 25% of each clipped leaf shall be quarter cut balanced equally on outside edges of each leaf.
- Grade A** The veneer shall be smooth, tight-cut and full length. Natural color and grain contrasts should be avoided. Veneer leaves will be slip and balance matched. Joints between leaves shall be tight with no sign of separation. “Bulls-Eyes” should be minimized and cannot be a predominant feature. Splits in the veneer within a leaf are not allowed. No clip width shall be less than 5” (128mm) and no more than 12” (304mm). Approximately 25% of each clipped leaf shall be quarter cut balanced equally on outside edge of each leaf.
- Grade B** The veneer shall be smooth, tight-cut and full length. The veneer does not need to be matched for grain. Natural color and grain variations shall be blended. Some defects are permissible, but the face is free of open defects. Veneer leaves will be slip and balance matched. Quarter sliced veneer is allowed as a substitute for Plain Sliced or Flat Cut on these components as long as entire face is consistent. No leaf clip width shall be less than 3” (76mm).
- Grade S** Sound grade with no open defects. The lowest grade for quality, materials, workmanship, and assembly.
- Grade G** Black Gator Ply

HBF Furniture Products Veneer and Panel Standard (cont.)

Grade Application

Veneer Grade AA

1. Conference Table Top
2. Worksurface

Veneer Grade A

1. Face of drawer front
2. Face of door
3. Outside face of end panel
4. Guest face of modesty panel
5. Outside face of finished back
6. Outside vertical veneered surfaces on occasional tables

Veneer Grade B

1. Inside face of end panel
2. User face of modesty panel
3. Top and bottom of overhead cabinet, bookcase, and storage towers
4. Inside surfaces of all cabinets
5. All shelves
6. Inside of drawer fronts and doors (except AMF/Linea drawer fronts)

Veneer Grade S

1. Outside of overhead cabinet back
2. Underside of conference table tops

Veneer Grade G

1. Underside of worksurface
2. Back of unfinished pedestal
3. Inside of pedestal
4. Bottom of bookcase and hutch
5. Inside of drawer fronts on AMF/Linea products

HBF Furniture Products Veneer and Panel Standard (cont.)

General Panel Specifications

Beyond the specification of the veneer face itself there are several important issues relating to the construction of the panel. These specifications apply to all panels supplied to HBF. Specific detail requirements for any given panel will be listed on the individual Panel Specification Drawing.

Panel Preparation

A clean, precisely smooth and flat surface is required for all HBF Worksurface and Table Top panels. These panels are always specified with at least one face specified as Grade AA. Because this panel is typically used in horizontal plane, the slightest imperfection in the overall flatness of the surface is readily apparent. Due to this condition, it is critical that the core materials used for all panels of this designation are properly surfaced prior to the construction of the panel. Core depressions in these faces cannot be allowed. Also note that unless otherwise specified, all HBF panels are to be 3 ply construction, meaning that the core materials are to be a single ply.

Thickness

Due to the precise construction methods used at HBF it is extremely critical that all panels are manufactured to a consistent, standard thickness. This is especially critical on the 1 3/8" and 3/4" thick panels. See individual panel specification drawings for specific tolerance requirements.

Veneer Application

To maintain an overall pleasing appearance, it is important that all veneer faces are made up of equal sized leaves with parallel splice lines. The assembled face must be applied to the substrate material so that the splice lines are parallel to the outside edge of the core material. The overall color of the veneer should be similar on both faces of any given component.

Sequence Matching

When Sequence Match panels are specified, all leaves on all panels within the set should be from the same flitch. All leaves within the overall set of panels must be the same width. Therefore if the individual panels within the set are the same width, each panel would have the same number of leaves. If the panel width varies, the leaf width should remain constant which may give you an unequal number of leaves but when the set is assembled the leaves appear to be continuous.

Sanding

All HBF veneer faces should be clean sanded per the specifications listed on the individual panel specification drawings.