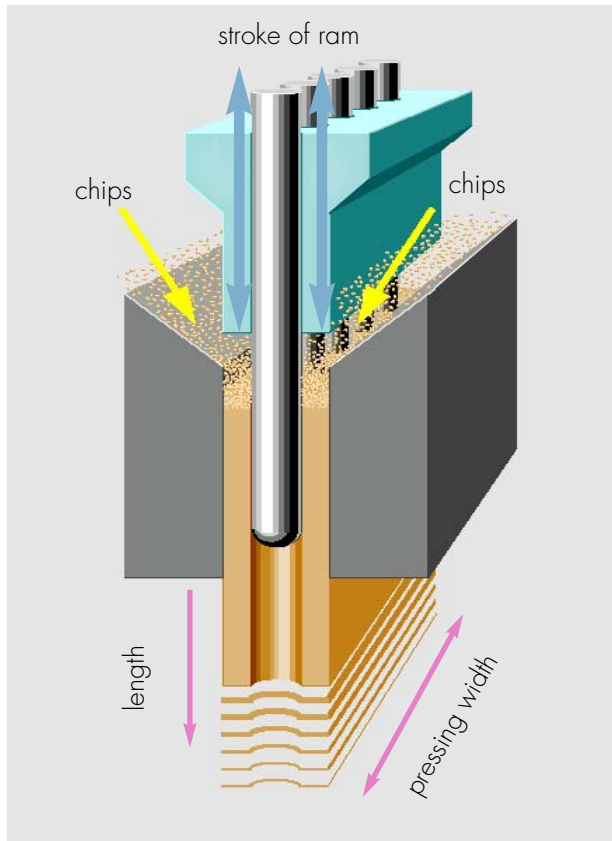


Extrusion Method

Process of Manufacture



- Chips of wood residues are dried and mixed with synthetic resin.
- An excenter puts the ram into a rhythmic vertical motion.
- The glued chips are guided through a channel under the ram between the heating plates of approximately 190°C.
- Every stroke of the continuously working ram compresses the chips and pushes downwards the endless stream of board in vertical direction.
- The exact thickness and density is produced by the friction between the board and the plates and adjusted by pressure and tension screws.
- The glued chips are cured under pressure and heat.
- Depending on the type of board the extrusion speed is 500 to 1200 mm/min.
- For the production of tube boards heated double-walled tubes are hanging through the ram into the press channel.

SAUERLAND BOARD :

- a single-layer solid or tube board with chip faces mainly positioned rectangularly to the pressing direction and the plane surface.
- production by the continuous extrusion method

Width :

- width of the extrusion stream
- 2 types of presses :
 - width up to 2100mm : according to door height
 - width up to 1270mm : according to the international 4'-size

Length :

- length of the pressing stream
- tube direction
- usually : width of the door
- possible : wide presses up to 1200 mm
narrow presses up to 3000 mm