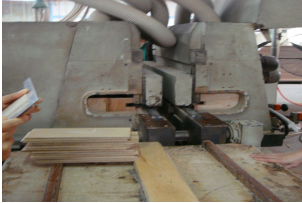


Engineered Flooring Production Procedure

<http://www.greenvills.com>

Logs Steaming	Remarks: First putting the logs into tank to soak under the water temperature 90℃ around. Generally 3 days is a must for ordinary wood species such as oak,sapele,maple,etc.to soak. Except those high hardness & density,low stiffness of wood species like jatoba,ipe,etc. should be soaked for 15 days. Then cooled them about 3 days.		
Sawing	Remarks: Peeling the logs and machining them into regular cubes.		
Slicing	Remarks:The log cubes are sliced into thin(3mm,4mm,6mm) veneer pieces.		
Drying	Remarks:The function of steam drier is to gradually alter the moisture content of the wood within the range 6%-8%.		
Cooling	Remarks: Cooling down naturally in order to balance the internal stress of the wood and prevent cracking and distortion.(Generally 7 days around).		
Dimensioning	Remarks:The veneers are cut into customized sizes after drying.		
Veneer gluing	Remarks: Top veneer pieces are glued together onto the plywood sheet.This process can be done manually or by machine.		

Pressing	Remarks:Putting the veneered planks to pass through press machine,first cold pressing then hot pressing.Sometimes it can be cold pressed solely to achieve higher stability and strength.		
Cooling, cutting and sanding	Remarks:1.In order to prevent distortion,planks should be cooled again after hot-pressing(Usually 7-10days) .2.Cutting to strips.3.Sanding.		
Double-end-tenoner	Remarks:Widthwise tongue and groove.		
Matcher (bottom)	Remarks:Bottom tongue and groove.		
Matcher (lengthwise)	Remarks:Lengthwise tongue and groove.		
Surface treatment	Remarks:Brushed.		
Surface treatment	Remarks:Handscraped.		

Painting	Remarks:1.Priming paint 2.Drying 3.Sanding 4.Coloring	 
Selecting & Packing	Remarks: Sorting out and amend the defectd planks and packing into boxes.	 