

HOW TO MAKE THE PLYWOOD?

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Plywood has more widely market in the future. It is used in building, packing, decorating, furniture and industry etc.

How to make the plywood? Follow the 11 steps will help you to know the technology of manufacture.

Step 1. The logs cutting

The logs are cut into the size length you need.
 The logs normally stored under water.

Machine need: Log cut off saw with logs conveyer or movable chain saw.



Step 2. The logs heating

In order to have best veneer, the logs need to heat under the water. The temperature is 80-90 degree. The time will be adjust by logs diameter.

Machine need: Steam chamber or hot water pool.

Step 3. Logs debarking

The log skin need to move by hand or by log debarking machine. Now many plant use debarking machine. It can peel the skin and round the log.

Machine need: Debarking machine



Step 4. Veneer peeling

The round logs without skin convey to the veneer peeling machine. For the large logs, The log charger center machine send it to the veneer peeling machine. Veneer peeling machines have more type: double spindle, single spindle, CNC spindless.



Machine need: Double spindle/single spindle veneer peeling machine, CNC spindleless veneer peeling machine.

Step 5. Veneers clipping, Veneer stacking

The veneer is very long from the peeling machine. So Veneer clipper cut into pieces of required sizes. The clipper has two types: CNC rotary veneer clipper and CNC pneumatic clipper.

More pieces of veneer pick up by hand or by stacking machine.

Machine need: CNC Veneer clipper, Veneer auto stacking machine



Step 6. Veneer dryer

The wet veneer must be dried and maintain the moisture. This is very important for the good quality plywood. The moisture content is about 10%-12%. The sunlight can not control the moisture and need more time. Veneer dryer machine will be used. It is easy to control the moisture and increase the production.

Machine need: Veneer dryer machine



Step 7. Dryer veneer mending

Some veneers need to mend for the defect. This needs patching machine. It also needs clipping machine to cut the veneer. Some small veneers also need to splice. This need core veneer splicer, face veneer slicer.

Machine need: Patching machine, veneer clipper, core veneer splicer and face veneer splicer.

Step 8. Glue making, spreading and assembly

Glue and glue spreader is very important in making plywood. Some materials put into the mixture machine and make the glue. This needs glue mixture to finish.

Glue spreading machine spread the glue to the veneer uniformly.

The veneers are assembled together with perpendicularly by hand.

Machine need: Glue mixture, glue spreading machine



Step 9. Cold pressing and hot pressing

The more assembled veneer layers are transferred into the hydraulic cold press. Cold press pressures them and ensures the veneer stick together.

After pre-press, then put the blank flat to the hydraulic hot press one by one. By the temperature and pressure, glue solidifies and plywood is finished.

Machine need: Cold press, Hot press



Step 10. Trimming and face sanding

The blank plywood need to require size. Four side trimming saw can cut the required size. Then put the plywood into the sanding machine. Sanding and polishing the face of plywood.

Machine need: Trimming machine, Sanding machine



Step 11. Inspection, labeling and storage

Inspection and labeling is a very important part. The plywood will be classified by the standards and packing. At last all plywood will be put in storage and for sale.



This is plywood manufacture process and relative machines. Maybe some steps change because of the purpose of plywood. Welcome to share on different technology. Please feel free to comment and [contact](mailto:bsy plywood@126.com) Mr. Song and send email: bsy plywood@126.com.