

# Laminated Veneer Lumber

Beech LVL

Produced with ContiRoll continuous pressing



Pollmeier Massivholz GmbH & Co. KG



# New production building



Pelice, Atlanta March 20-21, 2014

# European beech

Wood species:  
European Beech  
(*fagus sylvatica*)

Average dried weight:  
42-44 lbs/ft<sup>3</sup>  
(670–700 kg/m<sup>3</sup>)



# Raw material specification

Wood species: European beech (*Fagus sylvatica*)

Log diameters: 250 – 400 mm (approx. 10 – 16 inches)

Veneer length: 6 ft and 8 ft

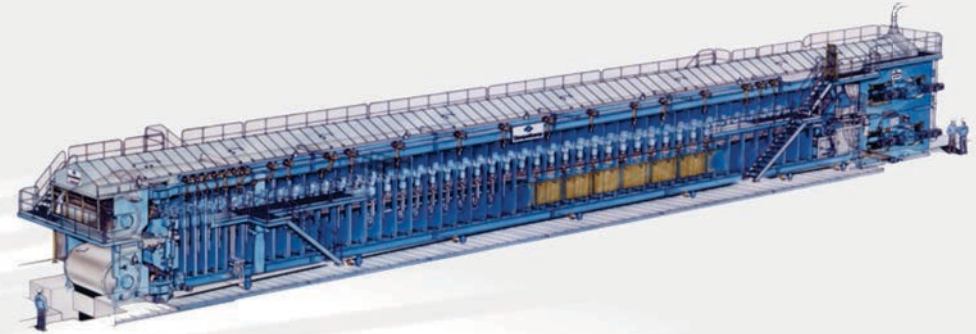
Veneer thickness: 3.7 mm (approx. 0.15 inch)

# Siempelkamp scope of supply

- High rack storage system for dry veneers
- Resin storage and preparation
- ContiRoll continuous press with double diagonal and trim saws
- Buettner energy system



# ContiRoll press - Main data



Press length: 60.3 m (198ft)

Hotplatten width: 2050 mm (6.7 ft)

Number of press frames: 73

Design speed: max. 200 mm/s (39 ft/min)

Design pressure: 500 N/cm<sup>2</sup> (725 psi) for 2/3<sup>rd</sup> of press length

200 N/cm<sup>2</sup> (290 psi) for last 1/3<sup>rd</sup> of press length

Number of heating zones: 6

# ContiRoll press - Main data



Billet width: 1950 mm (6.4 ft)

Billet thickness: 20 mm – 85 mm (approx.  $\frac{3}{4}$  inch – 3  $\frac{1}{2}$  inch)

Billet density: 730 – 900 kg/m<sup>3</sup> (approx. 45 – 56 lbs/ft<sup>3</sup>)

Master billet length: 7 m – 20 m (approx. 23 ft – 66 ft)

Standard lengths: 13.5 and 18 m (approx. 44 ft and 59 ft)

Design capacity @ 40 mm (approx. 1.5 inch) thickness:

100,000 m<sup>3</sup>/year (3.5 MMcuft) without microwave pre-heating

250,000 m<sup>3</sup>/year (8.8 MMcuft) with microwave pre-heating





**Siempelkamp**

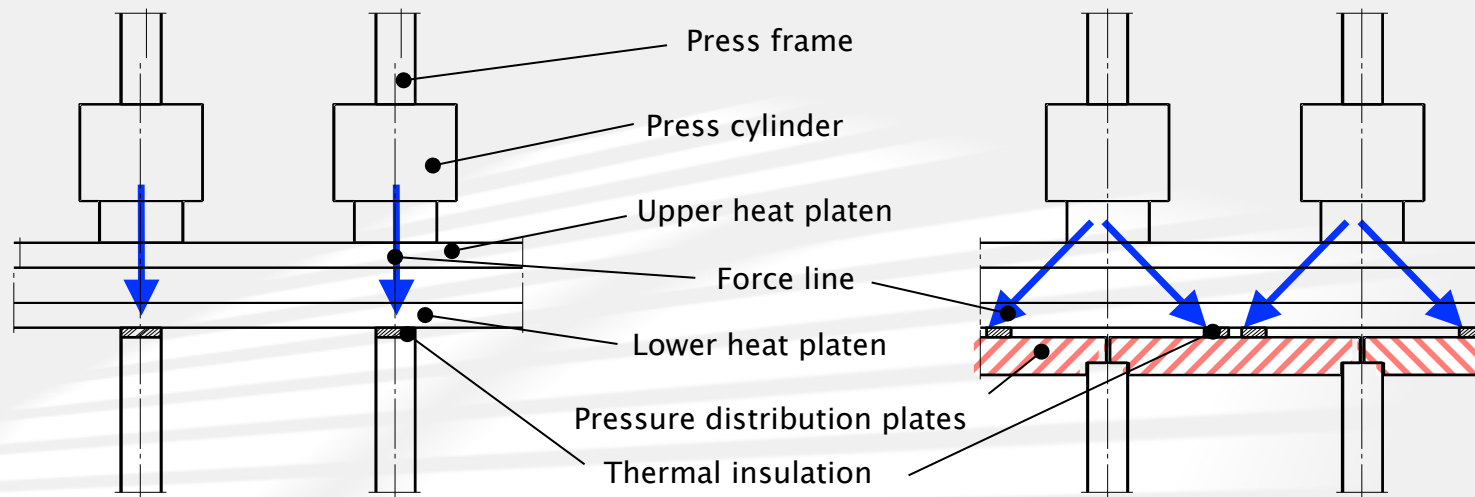
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# ContiRoll<sup>®</sup> generation 8

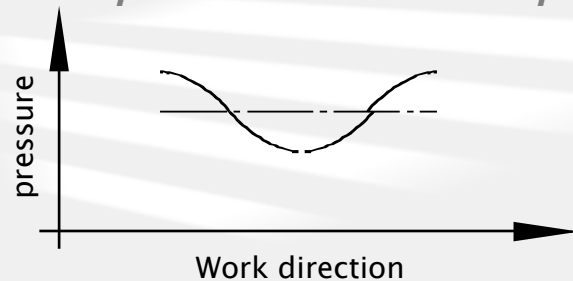


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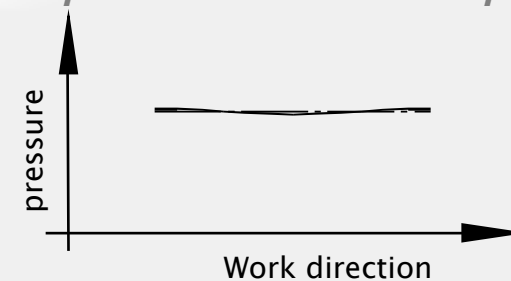
# Pressure distribution plates



*Generation 6++  
without pressure distribution plates*



*Generation 8  
with pressure distribution plates*





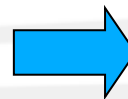
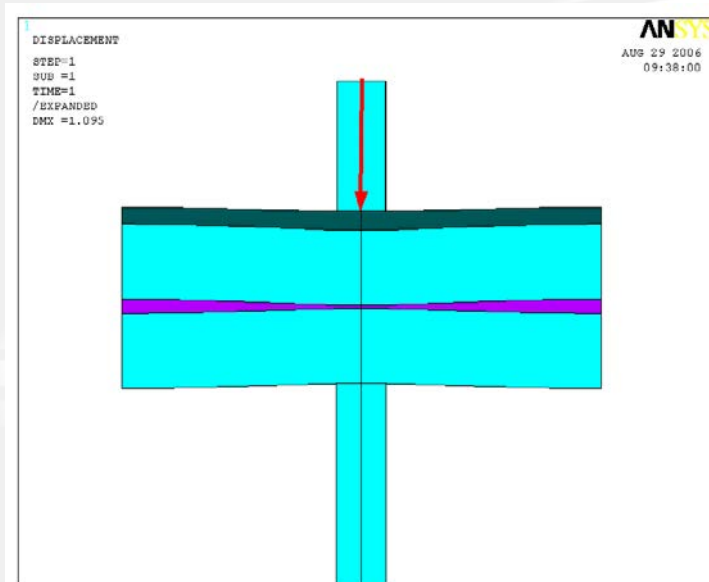
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# Pressure distribution plates

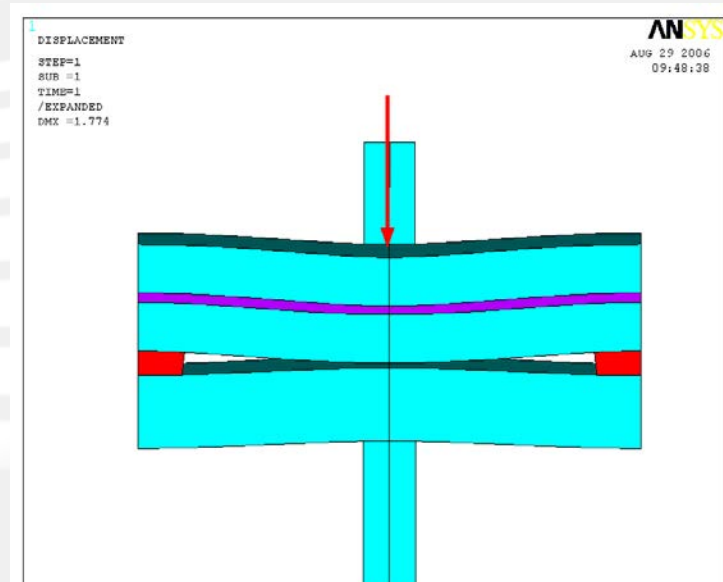
## standard principle

Hot-platen field deformation: 0.2mm  
with 830mm frame distance



## ecocalibrator principle

Hot-platen field deformation: 0.02mm  
with 830mm frame distance





**Siempelkamp**

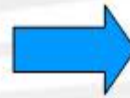
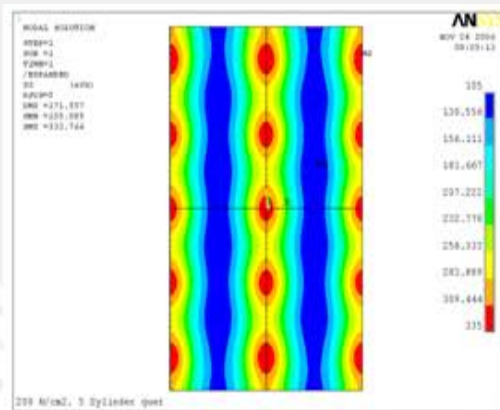
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# Pressure distribution plates

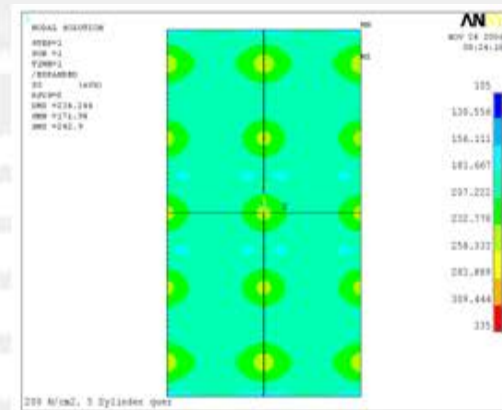
## ecocalibrator principle

Improved pressure distribution in longitudinal and cross direction

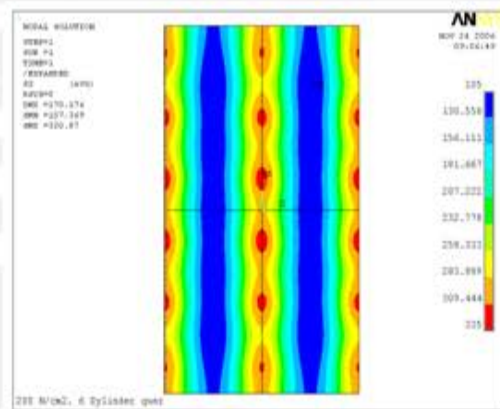
pressure  
distribution  
standard  
5 cylinders



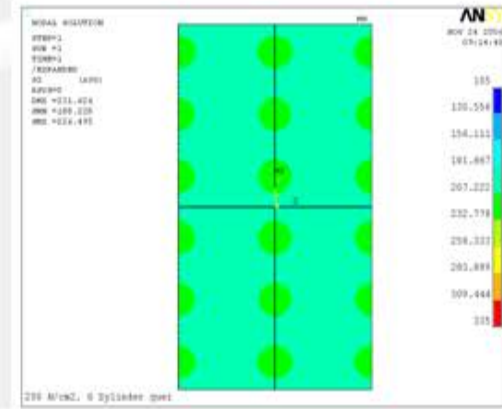
pressure distribution  
with pressure  
distribution plate 5  
cylinders



pressure  
distribution  
standard  
6 cylinders



pressure distribution  
with pressure  
distribution plate 6  
cylinders





# ContiRoll press under installation



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# ContiRoll



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# Veneer package before entering press



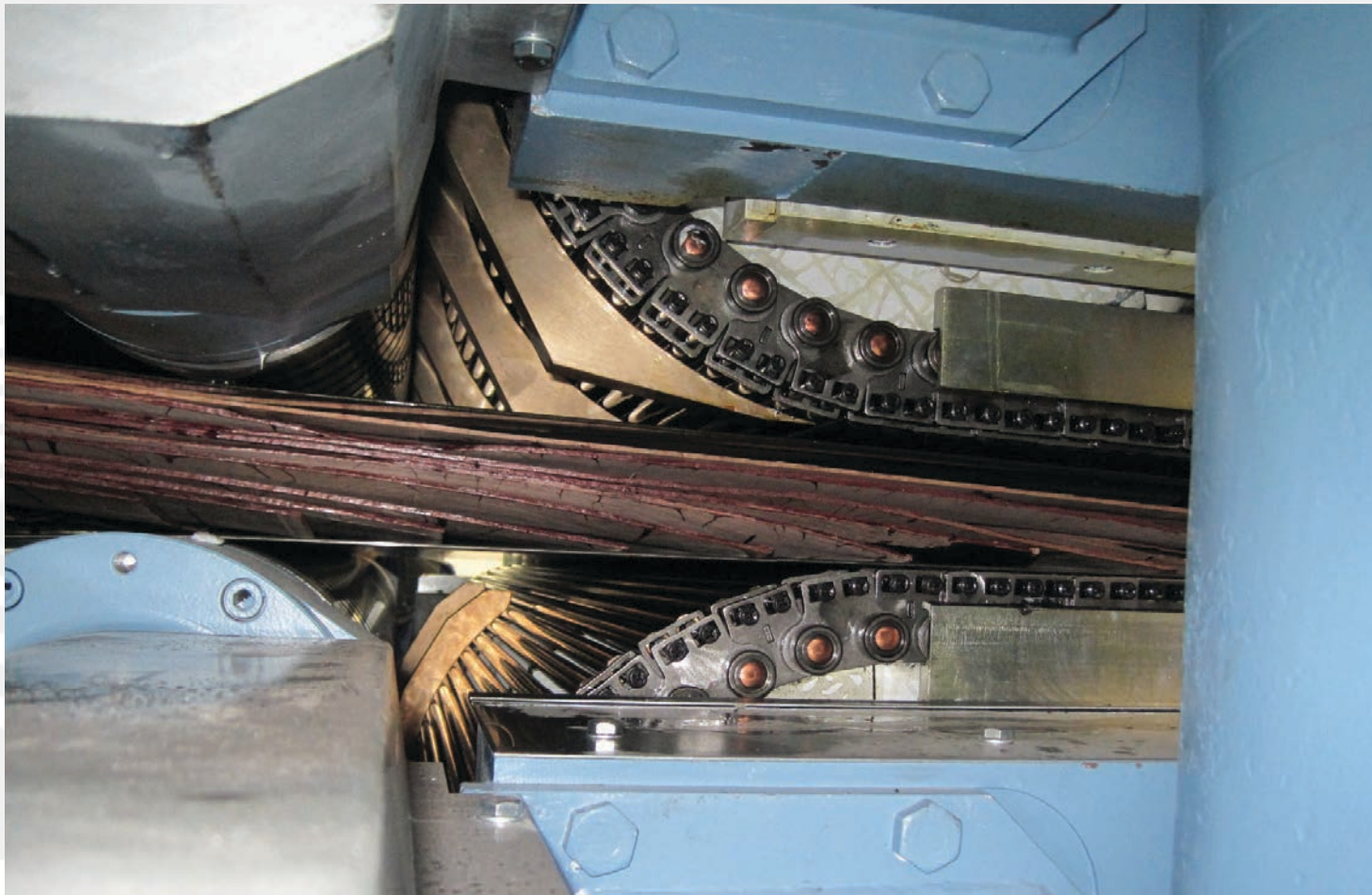
**Siempelkamp**

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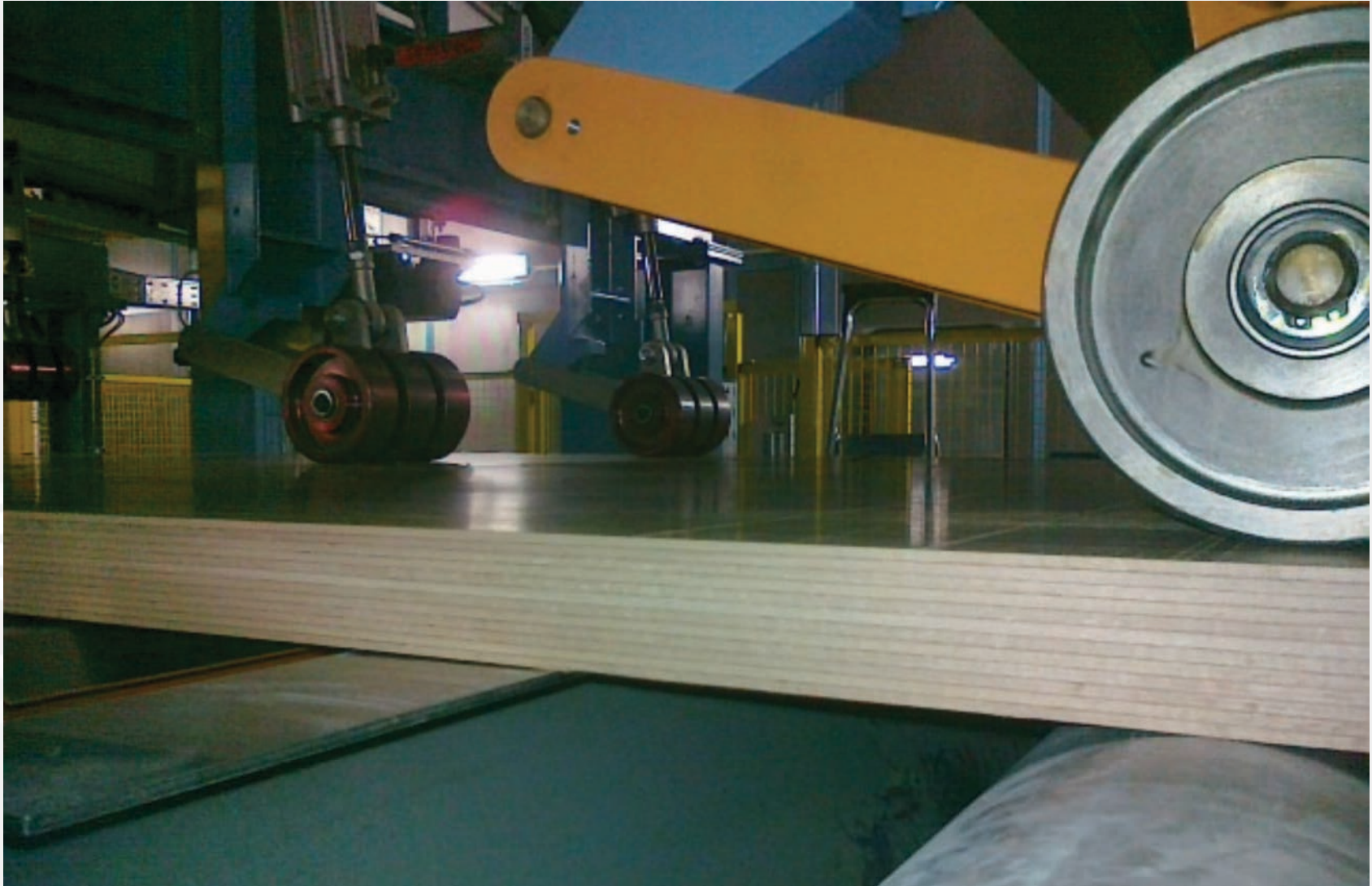
# Press infeed



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# Billet after trim saw



# First billet exiting saw enclosure





# Energy System



Capacity: 13 MW

Fuel: – bark  
– billet trim  
– saw dust  
– billet cut-offs





# Energy System



Heats thermal oil  
for:

- Veneer dryer
- ContiRoll press
- Steaming vats



# BauBuche Products

thickness: 80 – 1350 mm (3" – 53")  
width: 80 – 300 mm (3" – 12")  
length: up to 18 m (60 ft)

thickness: 20 – 85 mm (3/4" – 3 1/2")  
width: 100 – 1850 mm (4" – 6 ft)  
length: up to 18 m (60 ft)

thickness: 20 – 300 mm (3/4" – 12")  
width: 100 – 600 mm (4" – 24")  
length: up to 16 m (52 ft)



Board S and Board Q

S-board beams

Beams made of bonded lamellas

Panel



**Siempelkamp**

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**thank you  
for your  
attention**