

**METHOD FOR MANUFACTURING MULTI-LAMINAR WOOD SHEETS WITH
PRINTED PATTERNS.**

Abstract

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A method for manufacturing multi-laminar wood sheets (S10) by slicing from a flitch (14) of natural and/or laminated wood sheets (10, 12) glued and pre-printed with a basic pattern. According to the method, a basic pattern is printed on one or both faces of wood sheets (10) obtained by rotary cutting or slicing a natural log or a multi-layered flitch (11); the printed sheets (10A-10D) are subsequently used to form a final flitch (14) from which multi-laminar wood sheets are then sliced having a pattern designed to simulate different types of natural or fancy woods. The basic pattern is printed while maintaining process conditions designed to control the penetration into the thickness of the wood sheet (10, 12) and surface diffusion of the colouring agent during printing step. The penetration and diffusion of the colouring agent is controlled by maintaining specific temperature and pH conditions, and by controlling the quantity of colouring agent lay down on the surface of the wood sheets (10, 12) during the printing of the pattern.



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