

CUSTOM PRESSING DOORS/ PANELS – DATA SHEET

In order to achieve the best possible result with custom presses involving customer supplied substrates; doors, panels, etc. The criteria outlined below must be considered and adopted prior to sending substrates to Timberwood Panels. Whilst Timberwood Panels agree to take the upmost care when handling and pressing on foreign substrates, Timberwood will not warrant any products pressed on non-engineered substrates such as stocked Medium Density Fibreboards (MDF), Particleboard and nominated Plywoods. The mentioned substrates meet the specific requirements for pressing and are tried, tested and proven to be the best possible substrates for pressing, having suitable pressing surfaces and meeting the strict tolerances required in thickness variation and heat resistance.

Pressing Criteria



✔	Solid core door blanks.	✘	Hollow core or Semi-Solid core doors.
✔	Oversized substrates of MDF or Particleboard.	✘	Pre-fitted doors or panels (finished size).
✔	MDF Skinned solid build ups.	✘	Primed, Redi-Coat or pre finished doors/ panels.
✔		✘	Doors or Panels containing drill holes, cavities or voids.
✔		✘	Doors or Panels containing hardware or any kind of metal.
✔		✘	MDF or Particleboard panels with solid timber edging (see information below).

Solid Timber Edging on MDF/ Particleboard

Timberwood panels advise against pressing on engineered substrates (MDF, Particleboard, etc) with solid timber edging exposed on the pressing surface. This is primarily due to the different densities of wood and the rate at which they expand and contract with rapid humidity and temperatures changes brought on by hot pressing. There is a strong possibility that the solid timber edge will show through the veneered face after it has been pressed as environmental conditions change.

Trimming & Sanding

All custom pressed doors/ panels are hand trimmed due to the irregular thicknesses and sizes, sanding is typically very light due to the potential of thickness variation which could potentially cause sand throughs on the veneered face. Timberwood will attempt to remove all veneer machine markings, i.e. Glue residue, knife markings and repair tape when sanding doors prior to despatching to customers.

Similar to standard veneer board panels, it is strongly recommended that doors/ panels are sanded either by hand or with an orbital sander in preparation for finishing.

Sizing

The table below outlines the minimum and maximum size door/ panel that can be pressed. Please note the maximum width panel that can be sanded through Timberwood sanding line is 1320mm, whilst it is possible to pressing doors/ panels up to 1520mm wide, these panels will be supplied un sanded to customers

Minimum Door/ Panel Size	Maximum Door/ Panel Size
1800mm long x 700mm wide	3660mm long x 1520mm wide*

**Whilst a 3660mm x 1520mm panels size is achievable, successful pressing of a door/ panel this size is dependant on how flat the door/ panel substrate is to begin with. Timberwood Panels reserve the right to refuse to process panels this size if it is thought that substrates provided are not suitable for pressing.*

Lead-times

Due to the potential variation in custom door and panel sizes for pressing and the inspection process prior to pressing Timberwood Panels recommend working to a 10-12 working day lead-time on all customer pressed door/ panel orders.

Processing Orders

Timberwood Panels are not door manufacturers and whilst we have an extensive knowledge in panel manufacturing our knowledge of the various construction methods used in doors is limited. Our production team can only assume that supplied doors have met the criteria outlined upon receipt, Timberwood Panels cannot be held accountable if supplied materials do not perform as intended due to the substrates not meeting the nominated criteria.

For further information regarding pressing please contact one of our friendly sales staff or refer to "Pressing Guidelines" outlined on Timberwood's website.

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