

## BauBuche Panel

Reference projects  
and instructions for the surface treatment



Sheet **CONTENTS**

- 2 10.1 Hussl bar stool and bar table
- 3 10.2 Tailor-made office furnishings
- 4 10.3 LEVO dining table and benches
- 5 10.4 Library made of BauBuche
- 6 10.5 "Fratelli Cuore" restaurant fittings
- 7 10.6 Benches for club "Berghain" in Berlin
- 8 10.7 Stairs and and timber ceiling
- 9 10.8 Internal door
- 10 10.9 General processing instructions
  - 10.10 Processing instructions for varnished surfaces
    - Surface treatment
    - Varnish application
- 11 10.11 Processing instructions for oiled surfaces
  - Surface treatment
  - Application of hard wax oil
- 10.12 Systems from Remmers Baustofftechnik GmbH
  - System: Oil-based finish for stairs and furniture
  - System: Varnish finish for stairs and furniture
- 12 10.13 Panel Product Overview
  - BauBuche Paneel

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**Design and realisation**  
Hussl Sitzmöbel, Terfens

#### 10.1 Hussl bar stool and bar table

The table and bar stool set has been specially designed and developed by the company Hussl Sitzmöbel. The combination of BauBuche Panel and a black-painted surface results in a striking and extremely versatile piece of furniture which optimally highlights the veneer layers.







### 10.2 Tailor-made office furnishings

BauBuche Panel was used for the office furniture in the new Pollmeier sales office in Munich. A solid BauBuche beam was incorporated into the counter. The surfaces have been treated with hard wax oil (for processing instructions see page 11).

It is only at second glance that the sliding doors of the cupboards reveal themselves as white-glazed panel surfaces which allow the veneer layers to shine through. BauBuche creates a striking impression in the bright office spaces and ensures a pleasant environment for both working and socialising.

Design and realisation Ziegler Design, Offenberg





**Design** Moritz Putzier  
**Realisation** Tischlerei Steinkämper

### 10.3 LEVO dining table and benches

With the "LEVO" design, a bench with matching dining table, Moritz Putzier is really building on BauBuche's strengths: exceptional stability with economical use of materials.

The focus of this design is on the table top and the seatings which are made from BauBuche Panel. The veneers which are perpendicular to the surface create a particularly elegant and vital look. And even the table-top thickness is immediately noticeable: with tapering at the sides and a maximum thickness of 26 mm in the centre, it looks as though the table-top is almost too thin for its purpose. But its high load-bearing capacity makes BauBuche sturdy and resilient despite its slender dimensions.

The table legs are made from beechwood with opaque varnishing. Filigree metal elements in contrasting colours act as connecting pieces between the legs and the table top. They are so discreet that the table top seems to be floating. Indeed, this is where the name of the design comes from: the Latin word "LEVO" means "I float".





#### 10.4 Library made of BauBuche

The interior fittings of the Wood Biology & Wood Products department library at the University of Göttingen have been completed. On an area of 62.2m<sup>2</sup>, space was created for over 7000 books, magazines and anthologies.

On the front of the rectangular room there is the window façade. On the opposite side a screen was installed which can be used for lectures and presentations. On the long sides of the room there's space for 3-metre-high bookshelves which were produced using BauBuche Panel at the request of Prof. Dr. Holger Militz, head of the department. "BauBuche just has a really special look and aesthetics..." says Militz explaining his decision. Not only the shelves were made of BauBuche Panel but also the large conference table and additional library work stations.

Design Martin Seelinger

Realisation Tischlerei Freis GbR







**Design** Prof. Giuseppe Centauro, Studio Centauro, Prato  
**Realisation** Falegnameria Becherucci, Bagno a Ripoli

#### 10.5 "Fratelli Cuore" restaurant fittings

Florence's main railway station gained one more attraction in September 2015: the old ticket office from the 1930s, which is situated outside the station building has been converted into a restaurant with integrated bar.

When it came to fitting out the restaurant, the owners placed great importance on creating a coherent overall concept. The main material, BauBuche, creates a visual link between the large bar and the restaurant's dining and seating area. The counter that connects the bar area to the food display and the pizza-making station is made from BauBuche Panel in two different shades. While the natural beech tone was retained in the pedestal, the counter was stained dark in a way that the elegant veneer layers are still clearly visible. The different shades create a contrast that is dispersed again by the uniform surface appearance of the veneers.

The tables and chairs in the interior were also made from stained BauBuche Panel, which in combination with the anthracite-coloured stone floor and red accents on the walls creates a cosy atmosphere.





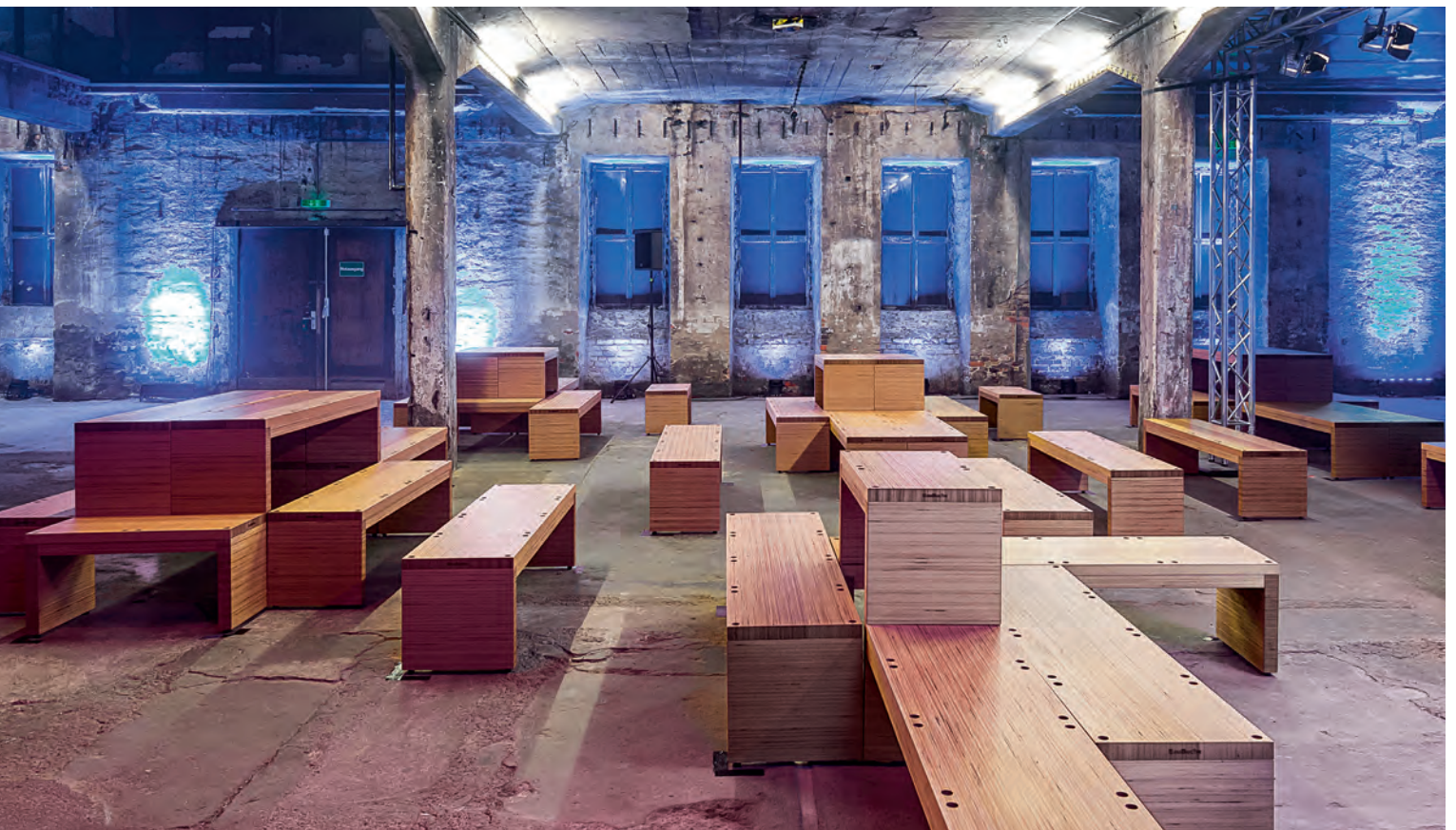
Design Studio Karhard Realisation Plan B

### 10.6 Benches for club "Berghain" in Berlin

BauBuche has been a part of Berghain since August 2015. The occasion was the three-day "Pop-Kultur" festival, which attracted over 10,000 people with its concerts, DJ sets, lectures and panel discussions. Berghain presented the ideal location for the festival – the only thing missing was practical and variable seating.

Heike Bischofberger, Berlin-born master joiner at PlanB, was impressed from the outset: "BauBuche is extremely good to work with – it's very stable, doesn't warp, and is therefore perfect for creating furniture that needs to be particularly resilient. And that may well be the case at Berghain."

A total of 48 large and small benches were produced for the festival, which can be easily stacked in a space-saving manner by means of a connector system. The design combines functionality with an elegant appearance: despite the solid construction of the furniture, the sleek veneer layers break up the compact shapes and give the benches a sophisticated, elegant look. This creates an exciting contrast to the chilly interior of the Berghain which is dominated by concrete.







#### 10.7 Stairs and and timber ceiling

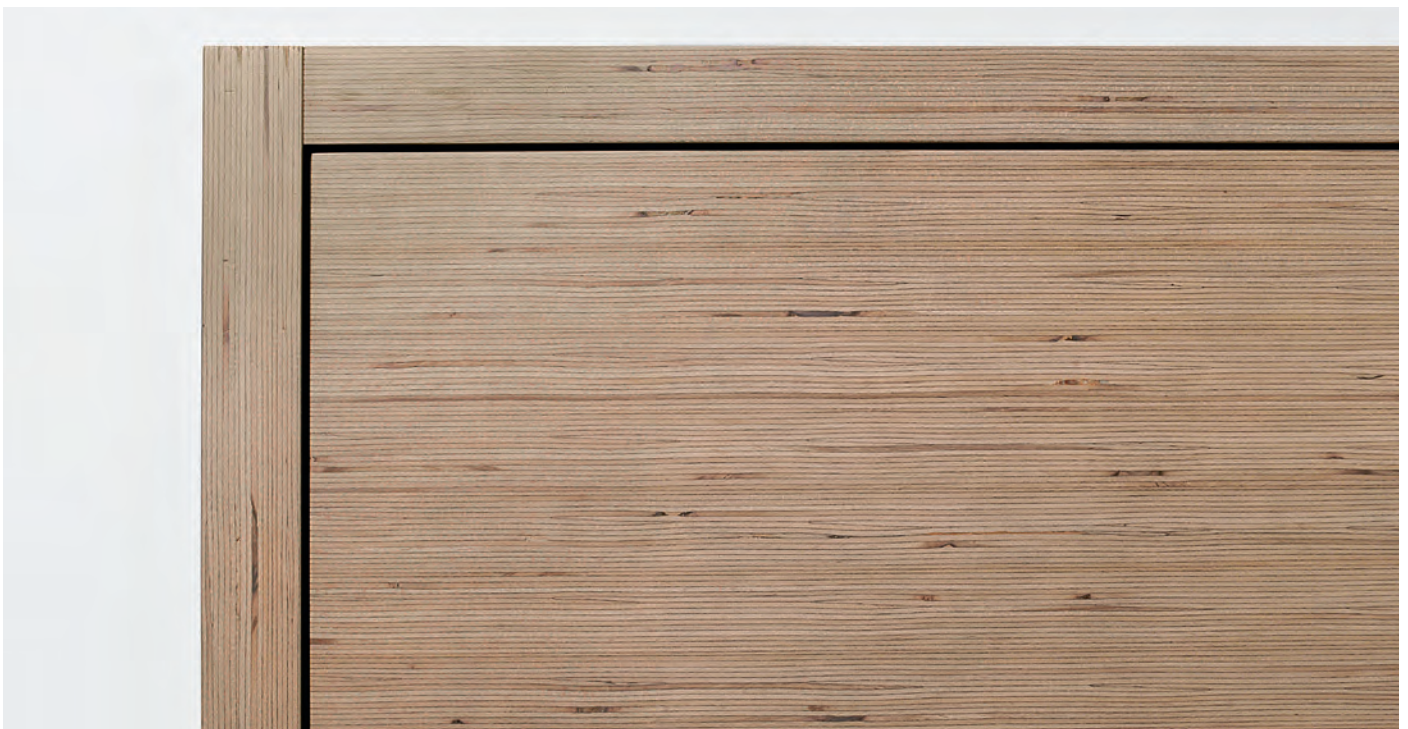
The joinery company Reim from Anzing, Bavaria, was on the lookout for a versatile and aesthetically pleasing material. Alexander Ehrmüller, Technical Manager at the joinery company, is convinced by the benefits offered by BauBuche Panel: "Even though we had to perform a little remedial work on the top layers, BauBuche is really eye-catching for our customers. We had no problems during processing, and would definitely recommend BauBuche!"

Design and realization Schreinerei Reim, Anzing



#### 10.8 Internal door

Wooden door without any glass can seem rather big and bulky, especially in darker tones. The frame of this door is made from solid BauBuche Panel. The door leaf is covered on both sides with transverse BauBuche Panel, while the edges are made of solid beechwood. The BauBuche Panel was stained concrete grey, allowing the individual veneer layers to remain visible. The surface of this exclusive interior door element plays with the light and perfectly fits into the room concept.



Design and realisation Fa. Bernhard Nießing, Borken



### 10.9 General processing instructions

**All drilling, cutting and edge finishing should be completed before the surface treatment.**

BauBuche Panel behaves in a similar way to solid wood boards. After transport it is necessary to ensure that the material can adjust slowly to the workshop climate. This means that, after cutting to size, stickers (spacing sticks) should be placed between the individual boards.

Longitudinal edges particularly with lengths of more than 2 m, do often not run exactly parallel to the laminations, so even after careful cutting (or parallel cutting) the glued joints become visible. If necessary, a solid wooden edge (e.g., made of Pollmeier beech sawn timber) can be glued on. If this is done with an automatic edging machine, it must be ensured that the glued surfaces of the edges have not been planed, but have a sanding pattern with a grit size of 40 or 60. The edges should be treated with an adhesive primer (e.g., Dorus ND 183/1). Even better results will be achieved through the use of a PVAC glue (D3 or D4).

In general, the technical guidelines for processing solid wood and solid wood boards apply to BauBuche Panel. Fine joints between the veneers are characteristic of the material, and are inherent to the production method. They can remain visible even after varnishing. The surface treatment is the responsibility of the contractor. We recommend that the surface quality is agreed with the client on the basis of samples.

### 10.10 Processing instructions for varnished surfaces



The photo shows the result of the following processing steps.

#### Surface treatment

- \_ Sand on a cylinder sanding machine (grit size 80/100) for the first pass.
- \_ Depending on the cutting quality of the abrasive, set the machine to "Calibrate".
- \_ Sand with 120/150 grit in the sanding machine using a spring mounted table or compressed air sanding shoe, depending on the type of machine.
- \_ Then thoroughly blow-clean the surfaces with compressed air to remove dust and loose fragments.
- \_ Level out any voids that have occurred with filler (solvent mixed with sanding dust, e.g., Pallmann Fugenkitt-Lösung (joint filler solution) No. 39 948).
- \_ Using precisely working sanding machines, the surface can be machine-sanded (grit size 150/180) after filling.

#### Varnish application

- \_ Priming: Applied quantity approx. 200 g/m<sup>2</sup>, sprayed crosswise and lengthwise. The subsequent intermediate sanding is ideally done after drying overnight in a temperature-controlled drying room.
- \_ Sand in sanding machine using varnish sandpaper, grit size 220, or with orbital sanders.
- \_ 2nd varnish coat at least 170–190 g/m<sup>2</sup>.
- \_ The edges have to be varnished several times in order to avoid varnish runs.
- \_ After an adequate drying time of at least 1.5 to 2 days at a constant temperature of between 18°C and 20°C, the boards can be stacked with wide intermediate supports. If these supports are too narrow or too hard, they will cause pressure points, due to the weight of the boards.

### 10.11 Processing instructions for oiled surfaces



The photo shows the result of the following processing steps. The surface was treated with a hard wax oil from Osmo.

#### Surface treatment

- \_ Cut to size on horizontal panel saw.
- \_ Gluing of edge veneer using an edge banding machine with integrated edge grinder.
- \_ Carcass connections, drilling and milling for the fittings.
- \_ Plugging of flaws using wood filler, colour tone walnut.
- \_ Surface grinding with wide belt sanding machine, grain 150.
- \_ Controlling and plugging of flaws if necessary.
- \_ Surface grinding with wide belt sanding machine, grain 150.

#### Application of hard wax oil

- \_ 1<sup>st</sup> application of hard wax oil
- \_ Wiping off excess oil with cloth
- \_ Drying time
- \_ Intermediate grinding, grain 240
- \_ 2<sup>nd</sup> application of hard wax oil
- \_ Wiping off excess oil with cloth
- \_ Drying time
- \_ Bonding and final assembly at carcass line

### 10.13 Systems from Remmers Baustofftechnik GmbH

#### System: Oil-based finish for stairs and furniture

- \_ Sand surface (P120)
- \_ Apply OB-008 oil-based stain, leave for 1 minute and wipe off excess stain
- \_ Let dry over night
- \_ Apply HWS 112 (hard wax seal) or HSO 117 (high solid oil)
- \_ Let dry according to instructions in technical instruction sheet
- \_ Sand surface
- \_ Apply HWS 112 (hard wax seal) or HSO 117 (high solid oil)

#### System: Varnish finish for stairs and furniture

- \_ Sand surface (P120)
- \_ Apply Aqua KB 004 compact stain (brush or spray) and distribute evenly
- \_ Let dry for minimum 2 hours
- \_ Apply Aqua TL 412/20 stair varnish
- \_ Let dry according to instructions in technical instruction sheet
- \_ Sand surface
- \_ Apply Aqua TL 412/20 stair varnish

For stairs and floors, we recommend 3 coats of HWS, HSO 117 or TL 412/20.

For more information on the application and safety of the products, refer to the technical documents published by the manufacturer ([www.remmers.de](http://www.remmers.de)).



### 10.13 Panel Product Overview



#### BauBuche Panel

<b>Dimensions</b>	<b>Thicknesses</b> 20, 35, 45 mm
	<b>Width</b> 640, 1080 mm
	<b>Lengths</b> 2250, 3000, 3600 mm
	Differing dimensions, lead times and minimum order volumes on request
<b>Tolerances</b>	Thickness $\pm 1$ mm, length $\pm 5$ mm, width $\pm 1\%$
<b>Durability</b>	Utilisation classes: 1 and 2 as per EN 1995-1-2
<b>Fire behaviour</b>	Class E as per DIN EN 13501-1 (corresponds to fire class: B2 as per DIN 4102)
<b>Proof of origin</b>	Certified according to PEFC