



Pollmeier

# STANDARD RIPPED-TO-WIDTH

to reduce material cost

Pollmeier  
Beech SUP 3  
200  
FSC C0C0C0  
1 200

Pollmeier  
Beech C01 26 2 45  
80 102

Pollmeier  
Beech C01 26 2 45  
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Beech C01 26 2 45  
80 102

STANDARD RIPPED-TO-WIDTH to reduce cost



## STANDARD RIPPED-TO-WIDTH to reduce cost

Hardwood material is an important cost factor in producing furniture. Most industries – like steel / aluminum profiles, screws, etc. - have developed standards in order to reduce cost for the customers and make handling easier. Pollmeier is following the same path and introducing standards to make the use of sustainable hardwood more affordable for future furniture customers.

### STANDARD RTW:

- Reduces waste by 20 % because there is no need for ripping
- Reduces cost by 20 % because of having no ripping waste
- Eliminates workload because of no ripping and having less dust in the factory
- Reduces waste handling
- Easy to calculate and predictable
- Superior S-Quality guarantees at least a 2100 mm defect-free length in boards with total length of 2450 mm

RTW is available in half (1.4 - 1.9 m<sup>3</sup>) and quarter (0.7 - 1 m<sup>3</sup>) packages, which allows our customers to have the right size available by having small inventory.

### Overview – STANDARD RIPPED-TO-WIDTH (RTW) – Grades & Dimensions

Length: 2.45 m; 3.05 m; 3.35 m (plus 2 - 3 cm, occasional trimms allowed (approx. 10%))

Grade	Thickness* mm	Width mm										
		42	48	49	50	54	68	80	100	125	150	
Superior	26 (23.8 presanded)	x				x	x	x	x			
	32 (29.5 presanded)	x				x	x	x	x			
	38 (36.0 presanded)	x				x	x	x	x			
	52 (48.5 presanded)			x			x	x	x**	x**	x**	
Superior Colour	26 (23.8 presanded)	x				x	x	x	x			
	32 (29.5 presanded)	x				x	x	x	x			
	38 (36.0 presanded)	x				x	x	x	x			
	52 (48.5 presanded)			x			x	x	x**	x**	x**	
Superior Colour Redheart	26 (23.8 presanded)	x				x	x	x				
Cabinet	26 (23.8 presanded)	x				x	x	x				
	32 (29.5 presanded)	x				x	x	x	***			
	38 (36.0 presanded)	x				x	x	x	***			
	52 (48.5 presanded)			x			x	x	***			
Cabinet Colour	26 (23.8 presanded)	x				x	x	x				
	32 (29.5 presanded)	x				x	x	x	***			
	38 (36.0 presanded)	x				x	x	x	***			
	52 (48.5 presanded)			x			x	x	***			
Prime Frame	26 (23.8 presanded)		x		x							

\* Tolerance ± 0.3 mm

\*\* SUP / SCL thickness 52 mm - width from 100 mm: Backside #1 Com

\*\*\* CAB 100 mm - only stockvolumes available

### Pollmeier Standard

- Lightly steamed
- Carefully kiln-dried to 7 – 9 % moisture content
- Conditioned
- Pre-sanded on both faces

**STANDARD RIPPED-TO-WIDTH**

**Superior**  
**FRONT**

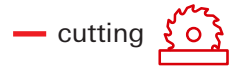
- for dimensions see page 3
- nearly defect-free product
- defect-free cuttings on both sides
- Exceptional high yield in long cutting lengths without discolouration
  - $\geq 2.10\text{m}$  at  $2.45\text{m}$
  - $\geq 2.40\text{m}$  at  $3.05\text{m}$
  - $\geq 2.70\text{m}$  at  $3.35\text{m}$
- Small percentage in short and medium cutting lengths without discolouration



Subject to typographical or printing errors. Photos of samples for the visualisation of sorting requirements. Print and photo-related colour deviations (from the original) possible.

Usable Wood (Ø 96%)

89% 100% 100% 92% 97% 100% 100% 100% 96% 94% 94%



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Superior Colour  
FRONT

- for dimensions see page 3
- colour no defect
- nearly defect-free product
- defect-free cuttings on both sides
- Exceptional high yield in long cutting lengths
  - $\geq 2.10\text{m}$  at  $2.45\text{m}$
  - $\geq 2.40\text{m}$  at  $3.05\text{m}$
  - $\geq 2.70\text{m}$  at  $3.35\text{m}$
- Small percentage in short and medium cutting lengths



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**STANDARD RIPPED-TO-WIDTH**

Superior Colour Redheart  
FRONT

- for dimensions see page 3
- colour/redheart no defect
- nearly defect-free product
- defect-free cuttings on both sides
- Exceptional high yield in long cutting lengths
  - $\geq 2.10\text{m}$  at  $2.45\text{m}$
  - $\geq 2.40\text{m}$  at  $3.05\text{m}$
  - $\geq 2.70\text{m}$  at  $3.35\text{m}$
- Small percentage in short and medium cutting lengths



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Cabinet  
FRONT

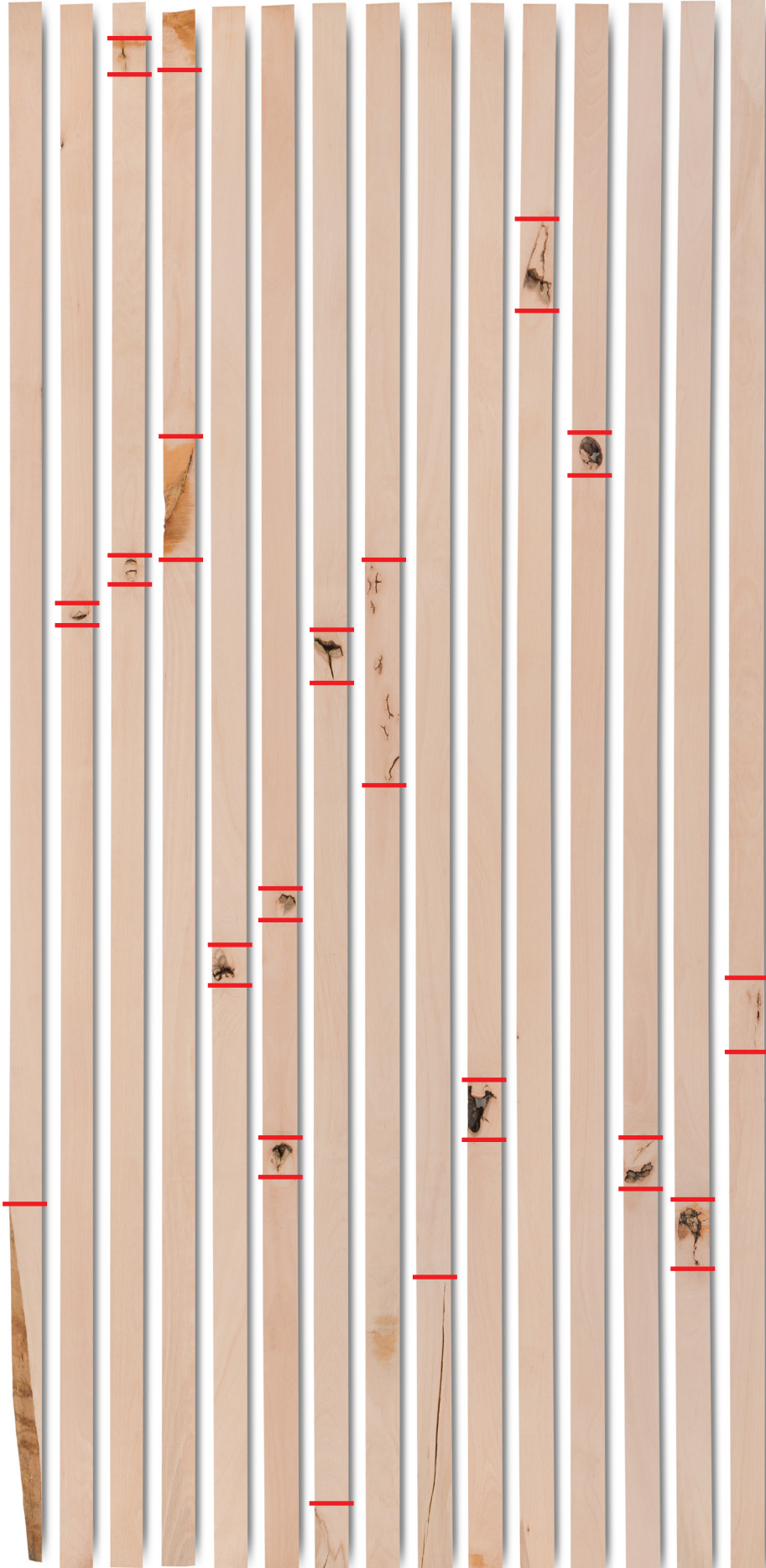
- for dimensions see page 3
- minimum yield 75% for short and medium cutting lengths of 600 mm or more




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Usable Wood (Ø 91%)

77% 99% 94% 89% 97% 82% 93% 85% 81% 97% 94% 97% 97% 96% 96%



— cutting 

Subject to typographical or printing errors. Photos of samples for the visualisation of sorting requirements. Print and photo-related colour deviations (from the original) possible.

**STANDARD RIPPED-TO-WIDTH**

**Cabinet Colour**  
**FRONT**

- for dimensions see page 3
- minimum yield 75% for short and medium cutting lengths of 600 mm or more
- colour no defect



Subject to typographical or printing errors. Photos of samples for the visualisation of sorting requirements. Print and photo-related colour deviations (from the original) possible.

**STANDARD RIPPED-TO-WIDTH**

Cabinet Colour

BACK

Subject to typographical or printing errors. Photos of samples for the visualisation of sorting requirements. Print and photo-related colour deviations (from the original) possible.

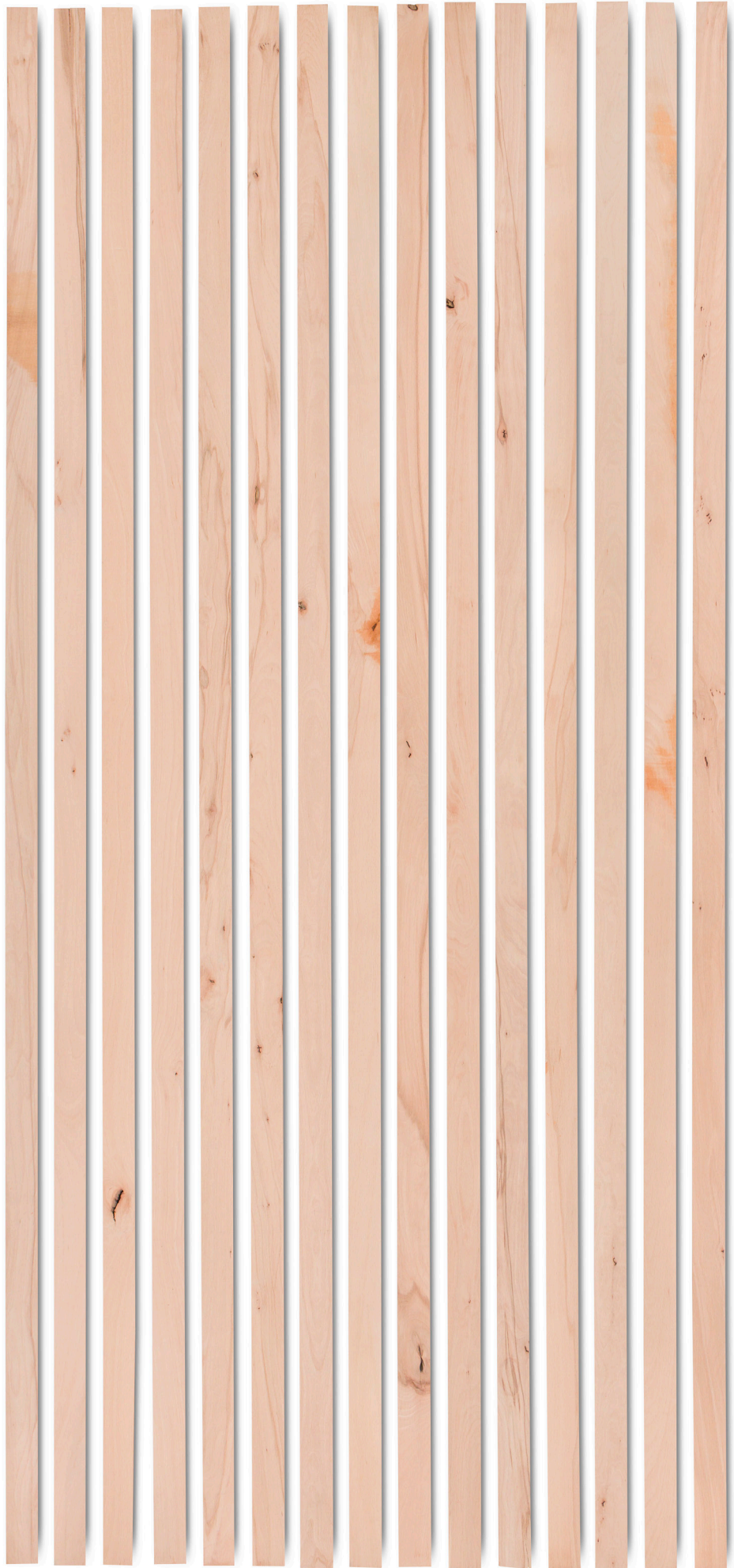


**STANDARD RIPPED-TO-WIDTH**

**Prime Frame**

**FRONT**

- for dimensions see page 3
- contains predominantly smaller defects
- designed to use at high yield in upholstery frames



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**COST PER READY TO USE COMPONENT IF RTW IS BEING USED.**

Grade	RTW price	Yield	Final price	Comments
Superior				
Superior Colour				
Cabinet				
Cabinet Colour				

**EXEMPLARY BEECH MATERIAL COST CALCULATION FOR A PIECE OF FURNITURE.**

Pieces of a chair	Quantity	Final dimensions			Raw material dimensions (invoiced)			Volume (m <sup>3</sup> ) raw material	Price raw material (€/m <sup>3</sup> ) (RTW)	Yield (%)	Net raw material costs based on dimensions	Materialcost of a single piece using RTW or CTS	Total materialcosts of pieces using RTW or CTS
		Length (mm)	Width (mm)	Thickness (mm)	Length (mm)	Width (mm)	Thickness (mm)						
Front legs	2	490	46	46	500	48	52	0.001248	745	80%	931.25 €	1.16 €	2.32 €
Rear legs	2	900	46	46	910	48	52	0.002271	745	80%	931.25 €	2.12 €	4.23 €
Frame piece	4	490	52	22	500	54	26	0.000562	655	80%	818.75 €	0.46 €	1.84 €
<b>Total Cost</b>												<b>8.39 €</b>	

<b>Other raw material costs</b>	
<b>Raw material costs of PM</b>	
<b>Other sales price</b>	

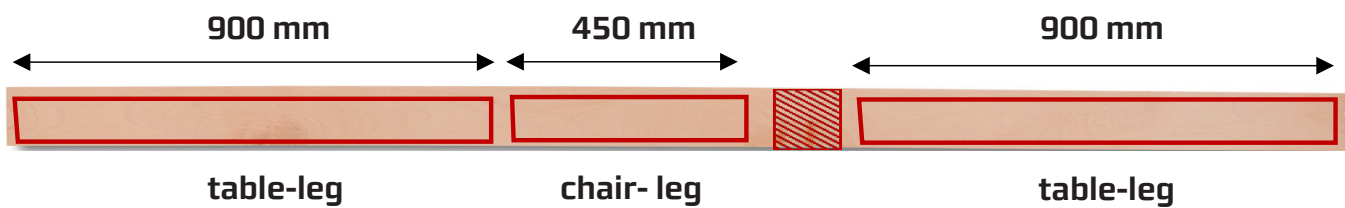




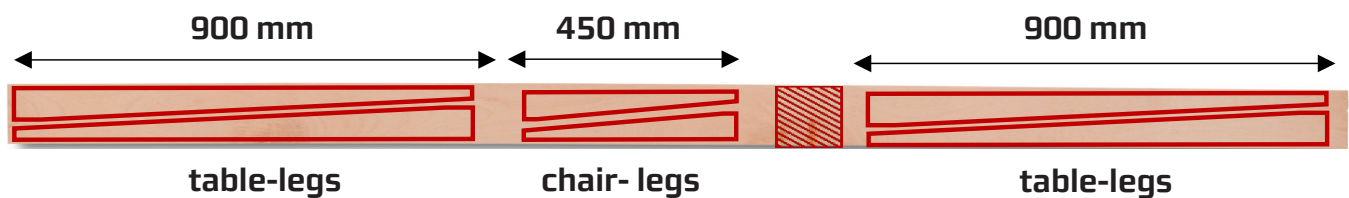
### General advice on the use of RTW:

- Especially when designing new furniture models it is important to have a look what standard sizes are available and work with the new standards as efficient as possible to reduce waste and limit inventory. Smart use of the new standards leads to significant cost savings during the lifetime of the new furniture model.
- Use as few Ripped-to-Width dimensions as possible to ensure:
  - minimum waste and maximum yield
  - low inventory
  - good usage of the wood by having short pieces in each Ripped-to-Width dimension.

Example picture:



- Position conical parts opposite each other for more efficiency



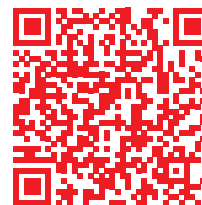
**Please note:** The most powerful advantage of RTW is the high flexibility in length cutting.

If the customer has a high variety in lengths or processes small volumes per length, RTW is often the better alternative compared to COMPONENTS.

If the customer can use CTS one pallet one size, our COMPONENTS dimensions fit, CTS is costwise most often the best alternative.

### Machining examples on the use of RTW

- How to machine-cut RTW to length:





Comments

A series of horizontal dotted lines intended for writing comments.

**Pollmeier STANDARD Ripped-To-Width**  
**Beech. One Wood. So many possibilities.**



The production site in Aschaffenburg is Europe's largest solid wood cutting plant.

**Please contact us.**  
**We are happy to support you in reducing your material costs.**

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+49 36926 945 163

Our products are certified according to PEFC.



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