

 Pollmeier

STANDARD RIPPED-TO-WIDTH

to reduce material cost

Pollmeier
Beech SUP 3
200

Pollmeier
Beech C81 26 2.45
100 100 100

Pollmeier
Beech C81 26 2.45
100 100 100

Pollmeier
Beech C81 26 2.45
100 100 100



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 m³) and quarter (0.7 - 1 m³) 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

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 2.45m
 - $\geq 2.40\text{m}$ at 3.05m
 - $\geq 2.70\text{m}$ at 3.35m
- Small percentage in short and medium cutting lengths without discolouration



Usable Wood (Ø 96%)

— cutting 



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 2.45m
 - $\geq 2.40\text{m}$ at 3.05m
 - $\geq 2.70\text{m}$ at 3.35m
- Small percentage in short and medium cutting lengths





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 2.45m
 - $\geq 2.40\text{m}$ at 3.05m
 - $\geq 2.70\text{m}$ at 3.35m
- Small percentage in short and medium cutting lengths





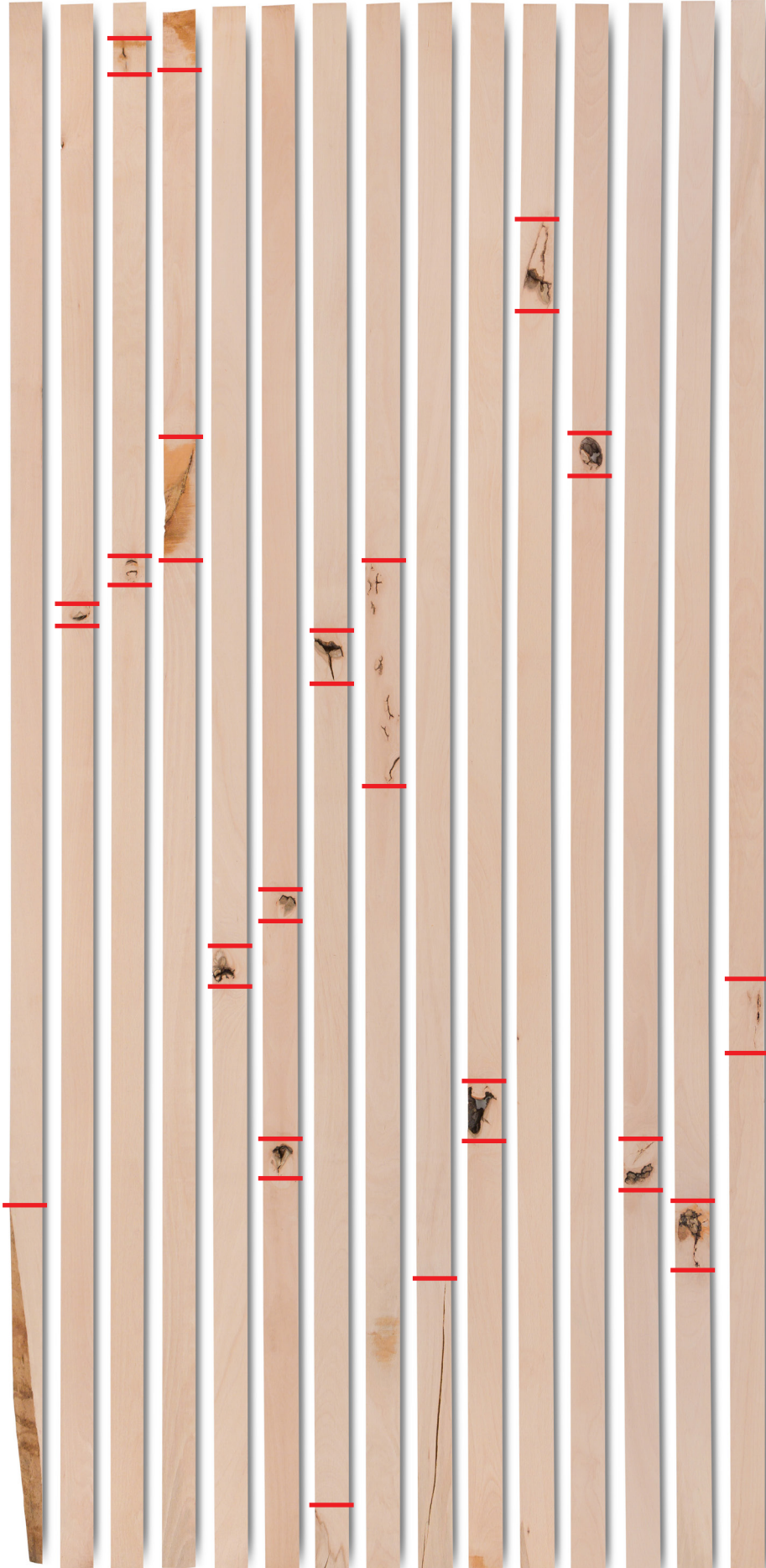
Cabinet
FRONT


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



Usable Wood (Ø 91%)

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



— cutting 

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





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 (m³) raw material | Price raw material (€/m³) (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) | Thick-ness (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 | 400 | 54 | 26 | 0.000562 | 655 | 80% | 818.75 € | 0.46 € | 1.84 € |
| Total Cost | | | | | | | | | | | | | 8.39 € |
| | | | | | | | | | | | | | |
| | | | | | | | | | | | | | |
| | | | | | | | | | | | | | |
| | | | | | | | | | | | | | |
| | | | | | | | | | | | | | |

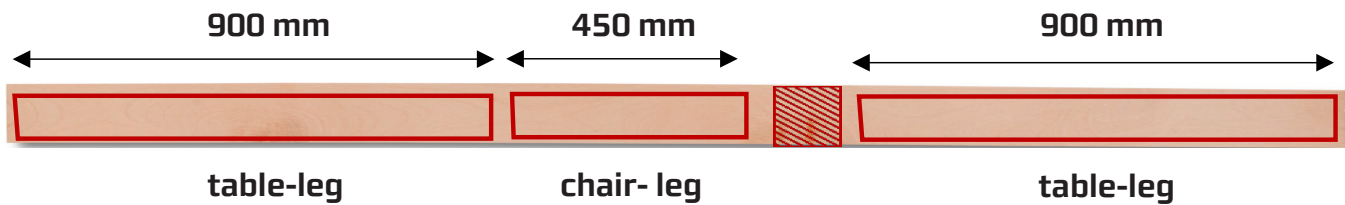
| | | |
|--------------------------|--|--|
| Other raw material costs | | |
| Raw material costs of PM | | |
| Other sales price | | |



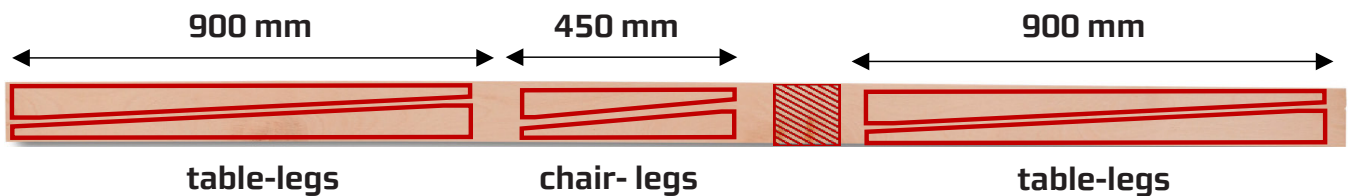
General advice on the use of RTW:

- 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



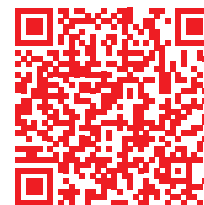
Please note: The most powerful advantage of RTW is the high flexibility in length cutting.

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:



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.

sales@pollmeier.com
+49 36926 945 163

Our products are certified according to PEFC.

