

feature

# Jeld-Wen Races Ahead

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**J**eld-Wen has invested well in excess of £1 million in new equipment to develop and improve the finishing capability and overall quality of wood veneer doors at the John Carr manufacturing plant in Melton Mowbray.

Already the largest manufacturer of windows, doors and stairs in the UK, with major brands such as John Carr and Boulton & Paul, the company can now lay claim to producing some of the best quality lacquered doors in the UK industry. This follows the installation of state-of-the-art GIARDINA pre-finishing and finishing line from the U.K. Agent GMD-Giardina Limited.

The new wet finishing line replaces and upgrades a previously GMD-installed line that has done proud service for 16 years. This gave Jeld-Wen the opportunity to work with GMD-Giardina and materials suppliers Becker Acroma the opportunity to reach a totally new and state-of-the-art specification.

The equipment applies an Acrylic UV (ultra-violet curable) lacquer, supplied by Becker Acroma, to both faces of the internal flush veneer doors, leaving a smoother, blemish-free superior finish.



GMD-Giardina MD. Gerry Doran alongside part of the new finishing line at Jeld-Wen

Improvements to the evenness of the coating, consistency of the gloss and enhancement in natural colours of the veneers, are readily detectable.

Critically, doors are pre-finished in the machine shop

on six GMD-supplied Tagliabue wide belt top and bottom sanders, which prepare surfaces for the exact finish required for the wet finishing process. This ensures that when the doors are presented to the line they are in optimum condition for the line to achieve the exacting final quality required. Once the doors are transported to the UV Giardina roller coating line, they receive further fine sanding on a Tagliabue machine, brush and air cleaning as well as de-ionising before receiving three base coats of lacquer with intermediate gel coats. They are then cured in a UV tunnel. An intermediate stage is the denibbing process in an in-line Tagliabue sander before the final two top coats are applied in a wet-on-wet process. Final UV curing takes place in the unique Giardina tunnel equipped with a three-lamp patented GST system with unique parabolic reflectors to enable accurate distribution of UV radiation.

The doors are then automatically turned through 90 degrees on a Giardina Windmill Turn-Over Device System and the reverse surface is finished using a replica process of the first line.

Ian Purkis, Technical Manager of Jeld-Wen, said: "It is our belief that investments of this magnitude are necessary to remain competitive and lead the market with top quality prod-

ucts and design choices.

"The equipment also improves our quality performance internally by reducing the amount of waste and rejects produced."

Melton Mowbray factory Director John Davies explains that the whole issue of materials and process quality control has been modernised by the line which is designed to finish (and is achieving) an output volume of 6 doors per minute. He says that the entire supply market was intensely researched before making the decision to remain with GMD-Giardina as a preferred supplier: "Both their international lead in this technology plus the fact that the local suppliers, GMD, have a first rate track record in hands-on expertise and proven back-up and support were all factors in the final decision."

Gerry Doran, Managing Director of GMD-Giardina, said: "Jeld-Wen required a complete new installation for the high quality, fit-for-purpose and compliant finish of their veneer doors.

"The lacquer line we installed gives a final finish of the highest possible quality from both a tactile, visual and durability point of view."

David McCulley, Sales Director of Becker Acroma, said: "By working in partnership our commit-



The Giardina Windmill Turnover Device System is situated between the two identical finishing lines

ment to excellence was to provide Jeld-Wen with the next generation of U/V coatings to enhance wood's natural beauty in the most cost effective and environmentally responsible way."

The finish on the doors complies with the various performance standards and the process with instant UV curing fully complies with all EPA regulations. There is no effluent or solvent emission. The efficiency of the line is crucial and works manager Colin Wheatley says that the operators are all now confident and familiar with it. He is achieving a materials wastage figure of less than 5% as the recycling system operates to maximum efficiency.

Jeld-Wen has seen an increased demand for veneer doors, especially in some of the more unusual commercially available veneers such as cherry, teak, beech and ash, and Jeld-Wen stocks one of the widest range in the UK, including 12 standard sizes, fire door rated and special options such as rebating for pairs and glazed or unglazed apertures.

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