VM Maksymiv, PhD
OB Franz, ZP Kopynets, Ph.D.
OO Franz, a graduate student
National Forestry University of Ukraine

Specified and developed existing scientific and reasonable cost ratios softwood and hardwood in lumber production using strichkopylkovoho equipment. Questions rationing of wood in the production of three-layer laminated veneer lumber and wood products.

Pylovochni logs, hardware, lumber, glulam, standards.

Along with the development of technology and technology lumbering and wood products industry and improved. With the increase in the cost of raw materials and environmental constraints znachymishymy

requirements are efficient use of wood. Processed almost all regulatory and technical documentation for products sawmill and woodworking.

The experiments were carried out to establish standards posortnyh outputs pyloproduktsiyi pylovochnyh logs of various grades and diameters groups based on technology of timber.

For research rozpylyuvan taken appropriate timber sizes, breeds and quality according to GOST 9463, GOST 9462 and GOST EN 975-1-2001.

Suggestions and recommendations on improving the use of raw materials pylovochnoyi conifers and hardwoods, their methods of setting the costs of the integrated use of raw materials in the manufacture of lumber. Example Softwood lumber output ratios shown in Table. 1.

1. Standards edging out Softwood Lumber% in accordance with GOST 8486-86 pylovochnoyi of raw materials in accordance with GOST 9463-88 (when sawing machines for strichkopylkovyh).

Planks	Average timber (14 ... 24cm) grade			Large timber (26 cm or more) class		
	1st	2nd	3rd	1st	2nd	3rd
Length 1 m and more						
0-th grade	4.9	1.9	1.8	7.4	2.1	1.5
1st quality	17.5	10.9	6.4	17.8	12.3	10.5
2nd quality	18.5	12.1	18.2	15.9	16.1	11.1
3rd grade	22.4	30.4	18.0	21.3	25.9	21.7
4th grade	13.1	17.0	23.6	16.1	20.3	27.3
Distance 0.5 ... 0.9 m	1.8	2.1	2.4	2.0	1.8	2.0
Total timber	78.2	74.4	70.4	80.5	78.5	74.1
Normal consumption of raw materials, m3 / m3	1,279	1,344	1.420	1.242	1.274	1,350

Established that surround output pyloproduktsiyi conifers (pine, spruce), cut down on strichkopylkovomu equipment rozvalnym means an average of over 2.8 ... 9.4% (for diameters of 14 ... 24 cm) 3.0 ... 11.9% (for diameters of 26 ... 40 cm) than the surround output pyloproduktsiyi, cut down on the saw-frames ceteris paribus.

Surround output pyloproduktsiyi hardwood (oak, beech), cut down on strichkopylkovomu equipment rozvalnym way on average higher by 2.9 ... 9.4% (for diameters of 14 ... 24 cm), 3.6 ... 10.2% (for diameters of 26 ... 40 cm) and 5.3 ... 10.4 (for diameters 40 cm or more) than the surround output pyloproduktsiyi, cut down on the saw-frames ceteris paribus.

The main methods of developing consumption rates of raw materials in the production of woodwork and construction products are cash-analytical and research. Odds costs by timber by timber rozpylyuvan research on woodworking enterprises and conditional on passports rozpylyuvan timber boards. Odds costs of lumber to concrete slabs set as average values according to all rozpylyuvan and differentiated on grades, character processing methods and sawing lumber. Recommendations pooperatsiynyh factors determining the cost of wood in the manufacture of laminated veneer lumber are given in Table. 2.

2. Summary of factors pooperatsiynyh consumption rates in wood 1 m3 pieces of laminated timber window section 72h86 mm

№z / n	Technological operations and cost factors	Saw sawmills		
		And C	II with	III c
1	Open Log: - factor costs (K) - The size of blanks for UK-section, mm	1.724 32h98	2,174 32h98	2,380 32h98
2	Drying: - factor costs (K) - Size pieces for the UK section, mm	1.04 ... 1.10 30,5h94	1.04 ... 1.10 30,5h94	1.04 ... 1.1 30,5h94
3	Calibration and: - factor costs (K) - Size pieces for the UK section, mm	1.09 28h91	1.09 28h91	1.09 28h91
4	Cut defects: - factor costs (K) - Size pieces for the UK section, mm	1.10 ... 1.15 28h91	1.35 28h91	1.65 28h91
5	Zoschuvannya: - factor costs (K) - Size pieces for the UK section, mm	1.04 ... 1.10 28h91	1.04 ... 1.10 27h91	1.04 ... 1.1 27h91
6	Calibration II: - factor costs (K) - Size pieces for the UK section, mm	1.11 ... 1.15 25h86 22h86	1.11 ... 1.15 25h86 22h86	1,11.1, 15 25h86 22h86
7	Gluing: - factor costs (K)	-	-	-

№z / n	Technological operations and cost factors	Saw sawmills		
		And C	II with	III c
	- Size pieces for the UK section, mm	72h86	72 ... 86	72h86
8	Crude costs for wood 1 m3 laminated veneer lumber (K) The calibration disc: - factor costs (K) - The size of glued UK	2.925 1.11 69h81	4.139 1.11 69h81	5.538 1.11 69h81
9	Trimming disc: - factor costs (K) - The size of glued UK according to specification	1.06 69h81	1.06 69h81	1.06 69h81
	Crude costs for wood 1 m3 pieces of laminated veneer lumber	3.440	4.869	6.516

Notes:

1. After the second calibration blank (lamella) section timber window 25h86 (outer layer) and section 22h86 (inner layer) in a three-layer glued window scantlings section 72h86 mm.
2. In the practice of companies use third grade sawlogs in the production of laminated veneer lumber inappropriate due to restrictions on timber quality and high raw material overruns.

Our studies allow for the cost coefficients wood and accepted engineering operations to develop basic standard rates in the production of laminated veneer lumber and modern cabinet designs, calculate the need for feedstock and production capacity plant (station). Developed standards wood costs in production of modern and traditional SB will monitor the issue of rational and efficient use of wood raw material in the manufacture implement scientifically grounded progressive norms.

Utochnenы suschestvuyuschye and razrabotanы scientific obosnovannые normatyvы rashoda timber hvoynыh and lystvennыh breeds in production with pylomateryalov Using lentochnopylnoho equipment. Rassmotrenы question normyrovanyya rashoda raw materials in the production trehsloynoho kleenoho timber and stolyarnыh products.

Pylovochnые machine too, equipment, pylomateryalы, glued beams, standards.

Scientifically based wood consumption specifications in timber production using horizontal band mill. Some problems of wood expenditure normalization in joiner's wares have been discussed in this article.

Logs, equipment, saw-timbers, glued squared beam, norms.