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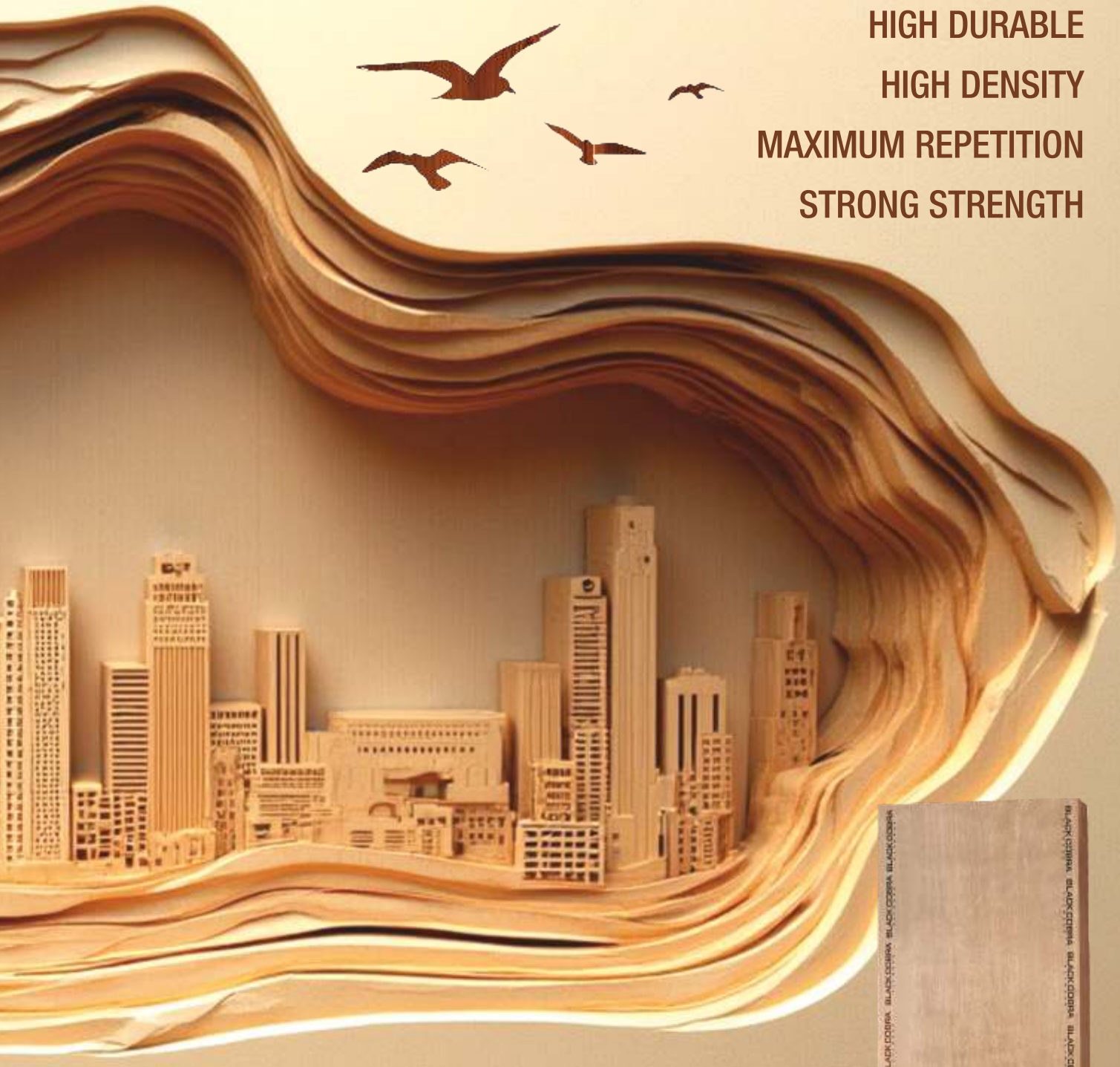

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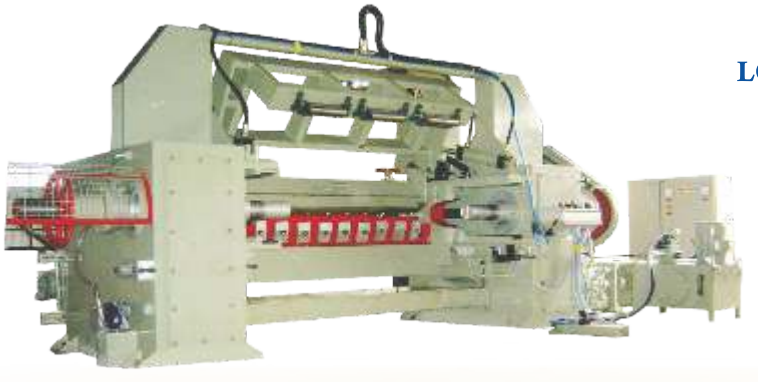
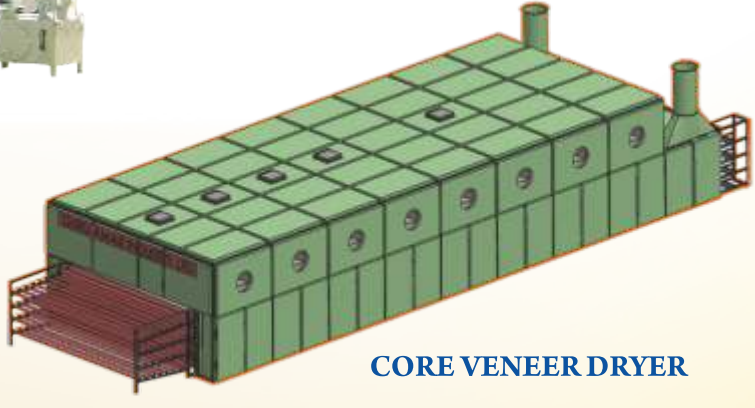


ROTARY VENEER LATHE (4Ft SIZE)
MODEL : RVT-50



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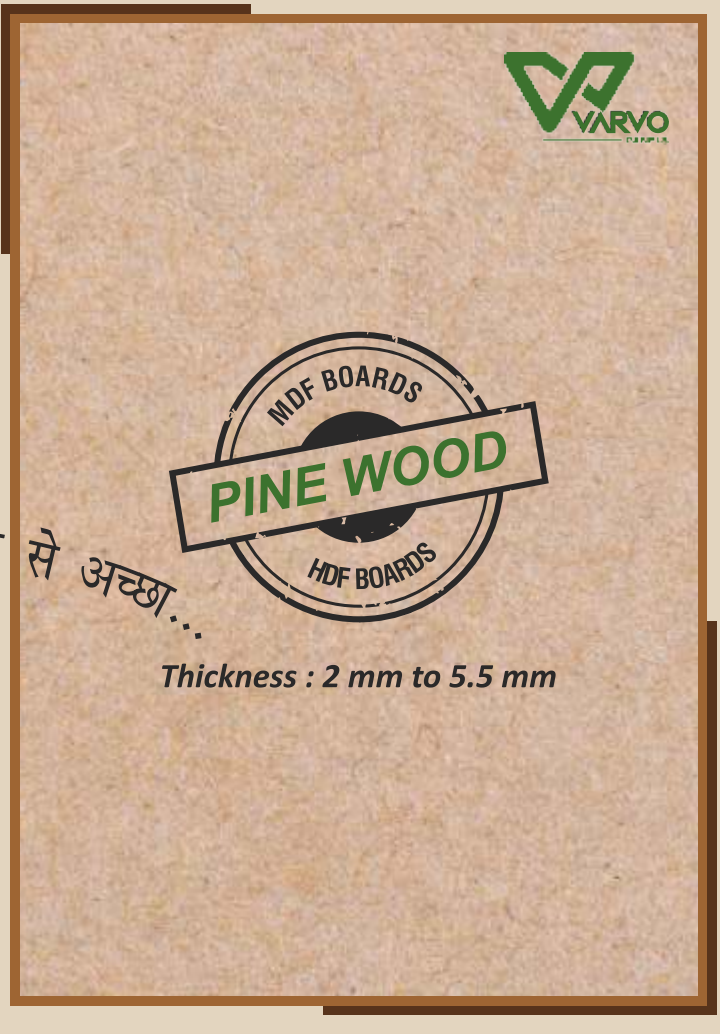

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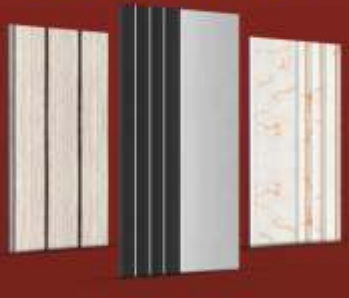

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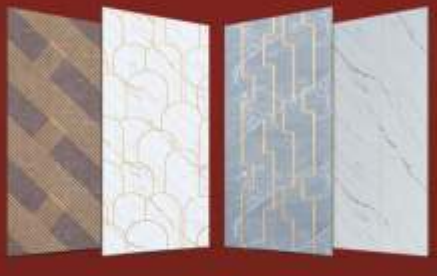

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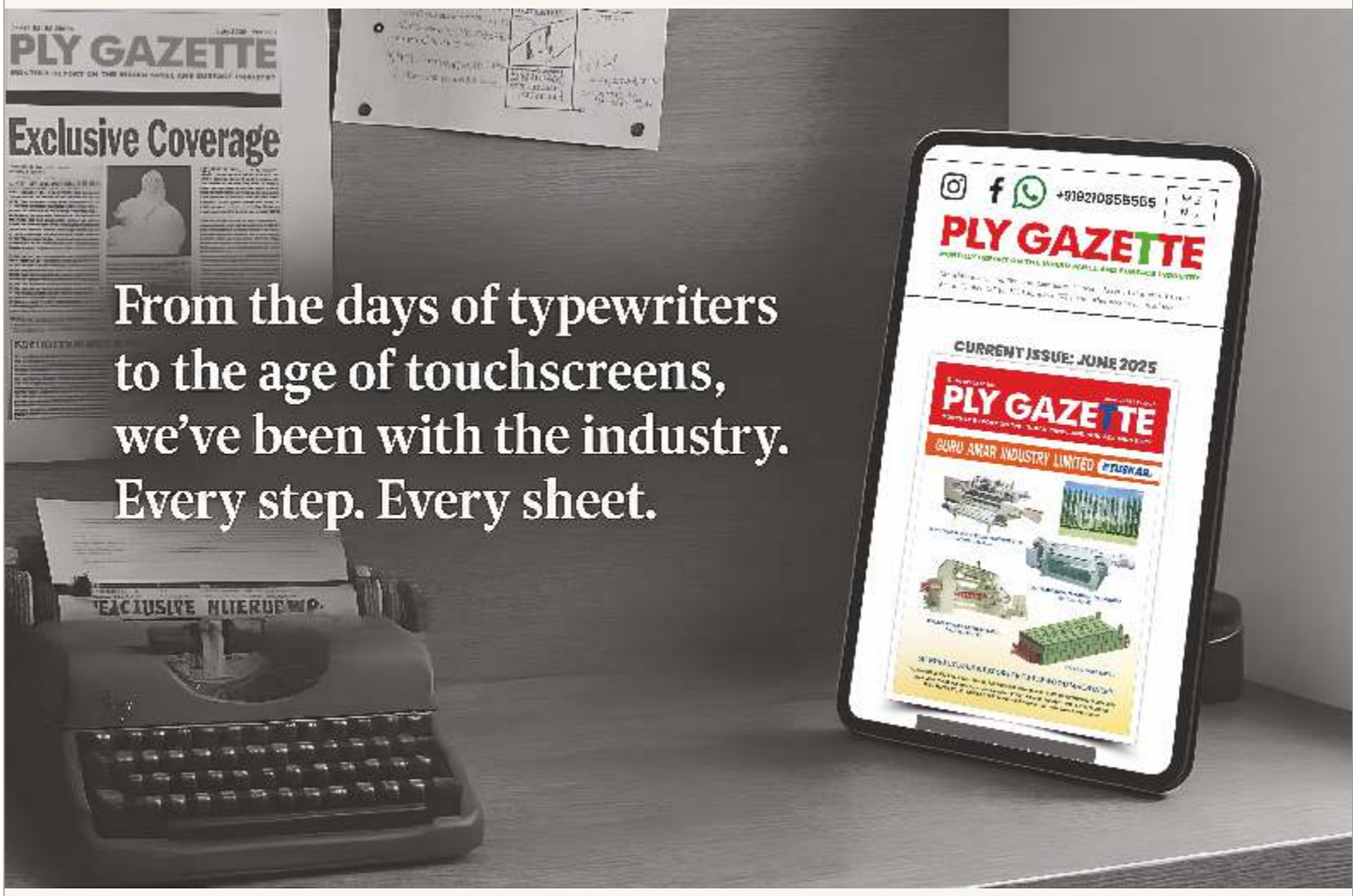

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Haryana CM Initiates Action Plan to Boost Yamuna Nagar's Plywood Industry

Haryana Chief Minister Nayab Singh Saini, while chairing a high-level meeting in Chandigarh on 17th July, 2025, directed officials to prepare a detailed action plan to promote the plywood industry in Yamuna Nagar as per news sources. The move aims to revitalise and support one of the region's most long-standing industrial sectors.

In the same meeting, the chief minister instructed the preparation of a comprehensive master plan for the revival of the metal industry in Jagadhri. Reviewing progress across various departments, including home, labour, industries and commerce, fisheries, and AYUSH, N S Saini stressed the need for high-quality and timely completion of developmental projects.

The chief minister also reviewed updates from the chief secretary's office and directed officials to ensure that infrastructure upgrades remain aligned with state priorities. Emphasising people-centric governance, he urged that policy decisions should reflect the actual needs of the population and focus on inclusivity, transparency, and effectiveness.

Raipur, Chhattisgarh

Hosting Key Meet on Wood-Based Industry Growth

An Institute-Industries-Forest Department Interactive Meet on harnessing the potential of wood-based industries in Chhattisgarh is being organised by the ICFRE- Institute of Wood Science & Technology (Indian Council of Forestry Research & Education), Bengaluru, an autonomous body under the Ministry of Environment, Forest and Climate Change, Govt. of India. Scheduled on 29th July 2025 from 11 am to 2 pm at Hotel Babylon International, Raipur, the event is supported by the Government of Chhattisgarh, its Forest & Climate Change Department, and Chhattisgarh State Industrial Development Corporation (CSIDC).

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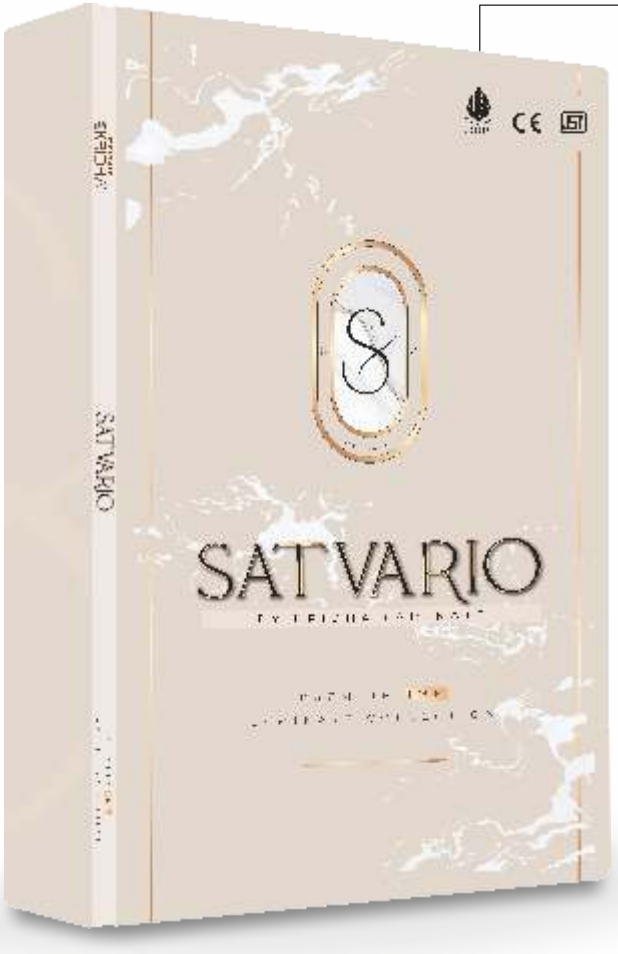

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Deepak Nitrite

Announces Major Expansion of Phenol Manufacturing Facilities

In a significant move toward strengthening domestic chemical manufacturing, Deepak Nitrite Ltd. announced plans to expand its phenol production capacity through a major greenfield project. The expansion will be undertaken by its subsidiary, Deepak Chem Tech Ltd. (DCTL), and will include the establishment of a new manufacturing line for phenol, acetone and isopropyl alcohol (IPA).

According to the company, the project is expected to entail an investment of approximately ₹3,500 crore, to be finalised during the detailed engineering phase. The funding will be sourced through a balanced mix of debt and equity. Officials stated that this new capacity will ultimately be integrated for the production of polycarbonate resins (PC), reinforcing the company's strategic goal of becoming one of the most integrated producers in India.

As part of the expansion strategy, DCTL has reportedly signed agreements to acquire and relocate a polycarbonate manufacturing plant from Germany to India. This will position Deepak Nitrite among the few Indian firms with fully integrated capabilities from phenol and acetone to polycarbonate resins.

These capacities will be in addition to the existing capacities of phenol, acetone and IPA currently held by Deepak Phenolics, the company's wholly owned subsidiary.

Chairman and Managing Director Deepak C. Mehta remarked that the expansion reflected the group's commitment to building a robust, self-reliant chemical ecosystem in India, contributing significantly to the vision of Atmanirbhar Bharat and Vikshit Bharat.

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Celebration of ACE Grandmasters in Style at Udaipur Gala

Greenply Plywood recently hosted its prestigious ACE Grandmasters event at the luxurious Fairmont Palace in Udaipur, transforming an evening of recognition into a spectacle of glamour and grandeur. According to a social media post by the company, the highlight of the night was a dazzling fashion show, where actor Dino Morea stunned as the showstopper, drawing applause from an enthralled audience.

The celebration, designed to honour Greenply's top-performing ACE Club members, blended style with substance. The evening featured show-stopping performances by music legends Adnan Sami and Sonu Nigam, whose acts paid tribute to the champions driving the company's success through Aspiration, Commitment, and Excellence.

According to company sources, the event served not only as a recognition platform but also as a reflection of Greenply's ethos, celebrating ambition, elegance, and achievement. With music, fashion, and heartfelt appreciation, the ACE Grandmasters night left attendees with memories of celebration and inspiration.

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In response to an unprecedented spike in timber and chemical prices, the All India Plywood Manufacturers' Association (AIPMA) has announced a ₹2 per sq. ft. increase in the price of 12 mm densified shuttering plywood. The decision was unanimously taken during a meeting held at City Mall, Yamunanagar, chaired by Devender Chawla on 2nd July 2025.

The revised rates take effect immediately. Members of the association have also resolved not to accept any new orders at increments below ₹2, mentioning the need to stabilise market operations amidst rising input costs.

It was further decided that if timber prices continue to climb or remain unchanged over the next 15 days, the association will meet again within the month to reassess the situation. The leadership called on all trade partners to support the move in order to protect the industry from further volatility.

The meeting was attended by key office bearers including President Devender Chawla, Chairman Naresh Tiwari, Secretary General Arun Mangia, and Treasurer Narinder Bansal.

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Plywood Manufacturers

Meet GST Commissioner Over Industry Concerns

A delegation of plywood manufacturers met CGST Principal Commissioner K.P. Singh in Delhi to highlight key issues affecting the industry. During the meeting, the delegation expressed concerns about complications arising from GST regulations and requested support to ease operational challenges. One of the primary demands was to start B2B e-invoicing for plywood sales from zero value upward, a proposal Singh assured would be considered seriously.

The group also raised concerns regarding the intrusive impact of GST compliance on daily business operations. In response, the Commissioner assured that efforts would be made to resolve issues within the department's capacity. He urged industry members to voluntarily ensure proper GST payment on all manufactured plywood and asked them to report cases of tax evasion so that non-compliant players can be brought into the formal tax system.

The delegation included Ramesh Agarwal, National President of AIPLI, along with Surendra Agarwal, Deepak Agarwal, Umang Bhalla, Sumit Agarwal, Ankit Poddar, and Achintya Goel. Deepak Agarwal, Chairman of IIA Lakhimpur Kheri, played a key role in coordinating the dialogue, which was seen as a constructive step toward industry-government cooperation.

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Naresh Tiwari

Appointed Chairman of Furniture and Ply Committee

The Punjab government has recently formed several industry-specific committees, including one dedicated to the furniture and plywood sector. This newly established group features prominent figures from the ply industry. Leading the group is Naresh Tiwari, Chairman of the All India Plywood Manufacturers Association and a leading figure from North India's ply industry.

Also appointed are Gopal Bansal, Inderjeet Sohal, Rajeev Singhal, and B.S. Sabharwal. The announcement was made by Punjab Minister Sanjeev Arora, highlighting the government's initiative to involve experienced industry voices in shaping sectoral policies.

FIPPI and Industry Partners Honour Visionary Leader Sajjan Bhajanka

On the evening of 10th July 2025, the grandeur of The Taj Mahal Hotel, New Delhi was matched only by the spirit of celebration as the wood and panel industry came together to honour one of its tallest leaders, Sajjan Bhajanka, Chief Patron of Century Plyboards and a proud Padma Shri awardee.

Organised by Federation of Indian Plywood and Panel Industry (FIPPI) with industry partners, the felicitation ceremony was a heartfelt tribute to S. Bhajanka's outstanding contributions, a journey defined by vision, innovation, and unwavering commitment to excellence. His leadership has not only shaped Century Plyboards into an industry benchmark but has also uplifted the sector as a whole.

The evening brought together stalwarts from across the country, industry leaders, associations, and well-wishers, all united in admiration and respect. Warm congratulatory messages and anecdotes flowed freely, each one echoing a legacy that continues to inspire.

Following the formal felicitation, guests engaged over an elegant executive dinner, a perfect close to an evening that celebrated not just an individual, but an industry coming together to honour excellence and envision the future.

When Sajjan Bhajanka received the Padma Shri award under the Trade and Industry category, it was more than just a personal accolade, it was a moment of recognition for an entire sector that has long driven India's construction and infrastructure economy from behind the scenes: the plywood industry.

Bhajanka, known for his decades-long leadership of Century Plyboards (India) Ltd, stated that plywood has always been his world. Accepting the honour with humility, he emphasised that the award was not his alone. "It belongs to the plywood fraternity, to my colleagues, and to this industry that has shaped my life," he reportedly said, calling the award a blessing from God and the nation. Despite his achievements, he said he never expected such an honour and had never applied for it.

Recalling the moment he learned about the award, Bhajanka shared how it was a close friend, Sukanta Majumdar, Union Minister of State for Education, who first informed him. While attending a wedding in Jaipur, Bhajanka received a call from Majumdar, telling him that the Home Ministry was trying to contact him. Soon after, a call from a secretary of Union Minister of Commerce and Industry, Piyush Goyal, connected him to the Joint Secretary of the Ministry of Home Affairs, who confirmed the news. "How are you feeling?" they asked. "Proud," he replied. "It is a big honour my country is giving me."

The news spread like wildfire within minutes. Phone calls, messages, and warm wishes poured in. Bhajanka described the outpouring of love and respect as deeply humbling. "After meeting you all and receiving your affection, I only bow down in gratitude and pray for your happiness and success," he said to the many well-wishers.

Sajjan Bhajanka's rise in the plywood sector is the kind of story that underscores the power of perseverance and belief. When he entered the plywood industry in 1974–75, many believed the sector wouldn't last. Timber from Assam was drying up, and the outlook was grim. But Bhajanka held firm. Even as the availability of forest timber reduced, innovation and technology brought

in new methods and improved quality. He believes that today's plywood, despite resource constraints, is technically superior to what was produced decades ago.

He recalled the humble beginnings of his career, which started in a small factory with no capital. “I had nothing,” he said. “I rented a closed factory from a Bengali owner for ₹3,500 for six months. There was no electricity, no knife to cut the wood, and no lifting tools.” He recounted how he made do with broken knives from a milling factory, paying ₹100–150 to get scrap blades. “From those bits, I began.”

By 1976, he launched his independent career. He never imagined that the company he would build would become one of India's largest in the sector. “But the possibilities were always there,” he said. “We just kept moving forward with hard work and God’s grace.”

Speaking optimistically, Bhajanka believes India’s plywood sector is on the brink of exponential growth. Currently lagging behind China, he predicts that in 10 years, India will produce five to ten times more plywood than it does today. “Even then,” he added, “we may still be producing only 50% of China’s output.”

He stressed that the demand is certain to rise due to India's economic development, increase in disposable income, and push for affordable housing. “Every house, big or small, needs plywood,” he said. The country’s focus on infrastructure and housing will drive the next big leap in consumption.

He pointed out that the rise in agroforestry, now accounting for 9% of India’s land, alongside 16% reserve forests, gives a combined 25% forest cover, which supports sustainability in timber supply. “More plantations will come up. More factories will be established. And plywood will remain irreplaceable, no true alternative exists.”

Bhajanka also emphasised that growth will not be limited to plywood alone. He foresees a booming market in MDF, particle boards, and decorative panels. “India is developing fast, and the people’s purchasing power is rising. With that comes the need for better homes, better furniture, and better materials.”

Throughout his career, Bhajanka has upheld hard work and honesty as his guiding

principles. While he acknowledged the role of destiny, he firmly believes that dedicated effort leads to inevitable success. "Destiny plays a role," he said. "But if you work with honesty, you will at least achieve ordinary success. And that cannot be taken away from you."

Several prominent industry leaders and associations paid tribute to Bhajanka's journey and his contributions to Indian trade and manufacturing. His younger brother, Prem Kumar Bhajanka, a veteran in the sector and Managing Director of Century Plyboards, spoke about his brother's visionary leadership.

Other key voices included:

- *Rajesh Mittal, President, FIPPI*
- *Jaydeep Chitlangia, Mentor at Duroply Industries*
- *N.K. Agarwal, Chairman, Action Tesa*
- *Dr. Prashant, President, CIPMA*
- *Jikesh Thakkar, Executive Director, AIPM*
- *Amit Goel, HPAM, Crosta Panel*
- *Bobby Verma, Bagasse-based PB Association*
- *Naveen Patel, GPMA*
- *Sandeep Gupta, Director, Northern Plywood*
- *M.M. Mujeeb, SOPMA*
- *Makhan Gattani, MD, Gattani Industries*
- *Ajay Garg, Director, E3 Group*
- *Dr. C.N. Pandey, Technical Advisor, FIPPI*
- *Dr. M.P. Singh, Director General, FIPPI*

These voices reflected the admiration and respect Bhajanka commands not only as an entrepreneur but also as a mentor and a pillar of India's plywood sector.

As Bhajanka repeatedly stated, this recognition is not his alone. "The Padma Shri I got is because of you, because of my industry, because of the plywood fraternity. Plywood is my everything," he said. Grateful for the love and support from colleagues, workers, and associates, he offered his heartfelt thanks and blessings to all.

The award, in many ways, celebrates the transformative journey of an industry, from struggling factories and limited raw materials to innovation-led manufacturing and growing global competitiveness.

For Sajjan Bhajanka, it is a personal milestone. For the plywood sector, it is a national recognition long overdue. And for the next generation of entrepreneurs, it is a reminder that with vision, resilience, and integrity, greatness can indeed be crafted, step by step.

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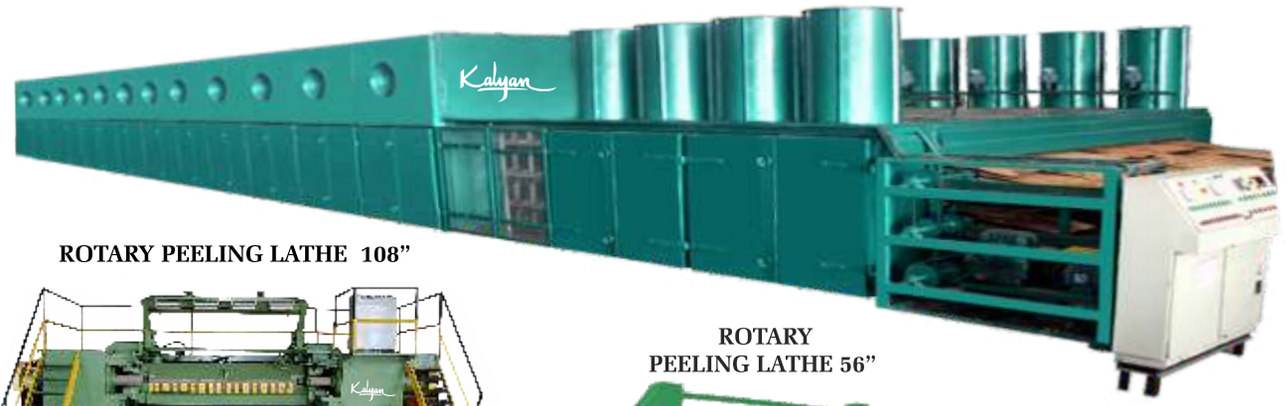

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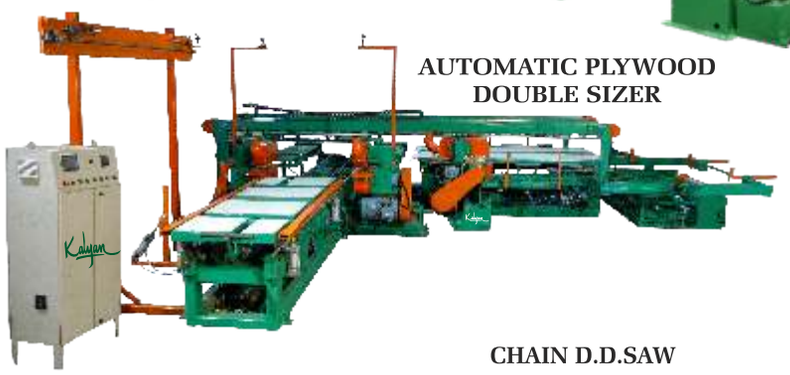

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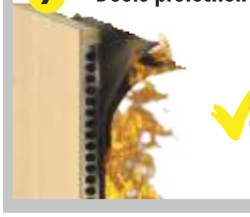

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Hardwood Forestry Fund

Winds Down, Passes the Torch to Tree Planting Allies

After 35 years of advancing sustainable forestry across the U.S. and abroad, the Hardwood Forestry Fund (HFF) has officially dissolved its operations, marking the end of an era. In a final act of legacy, the organisation announced a $190,000 distribution to the Arbor Day Foundation and One Tree Planted, organisations that will carry forward HFF's mission of hardwood reforestation.

Established in 1990 by members of the Hardwood Plywood and Veneer Association, now known as the Decorative Hardwoods Association, the HFF was a nonprofit 501(c)(3) based in Sterling, Virginia. Over three decades, it supported the planting of more than 5 million hardwood seedlings across 289 projects in 38 U.S. states and four countries, focusing on sustainability, education, and ecosystem restoration.

The Fund's inaugural project was a reforestation initiative on a 500-acre Boy Scout camp near Galesburg, Illinois. This event launched HFF's long history of collaborating with public agencies and nonprofit partners through grants, forestry field days, and hands-on reforestation events. Projects funded by HFF prioritised public lands and emphasised natural regeneration, selective tree planting, and forest management to enhance wildlife habitat, improve water quality, and educate the public.

HFF's financial support primarily came from forest products companies, individual donors, and foundations. The all-volunteer board, featuring key industry figures such as Tim Fixmer, President and CEO of CCI Media (Woodworking Network's parent company), has now entrusted its future mission to trusted allies.

The decision to dissolve, formally approved by the District of Columbia on 12th May 2025, was framed by the Board as a symbolic "passing of the torch." The final $190,000 donation reflects the Fund's continued commitment to hardwood reforestation, even as its formal chapter closes.

While the HFF's operations have ended, its impact endures, rooted in forests across the country, growing stronger with every season.

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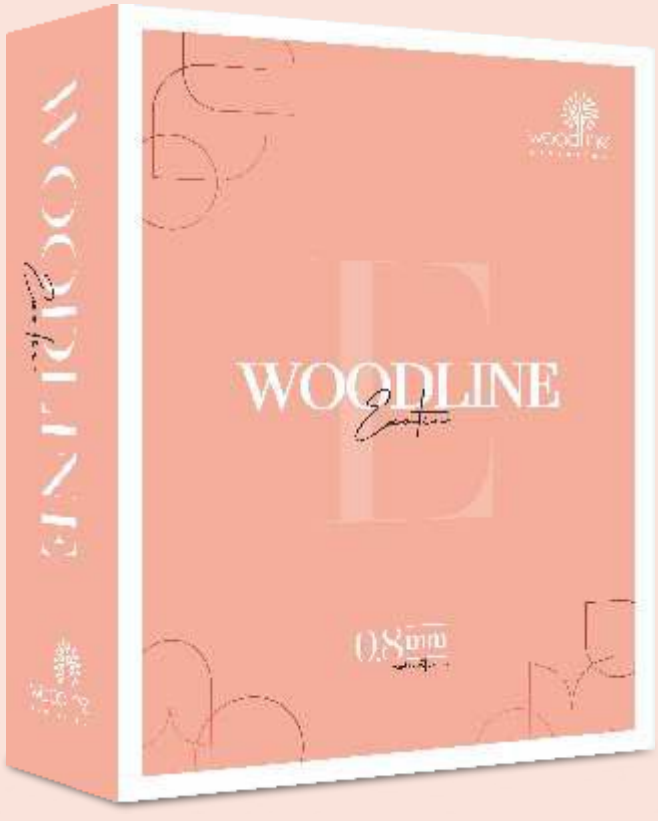

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U.S. Trade Panel

Plywood Imports Damaging, Paving Way for Duties

In a significant move for the U.S. hardwood and decorative plywood (HWDP) industry, the U.S. International Trade Commission (ITC) issued a preliminary determination on 3rd July, 2025, finding that imports from China, Indonesia, and Vietnam are causing material injury to domestic producers. The decision follows trade petitions filed by the Coalition for Fair Trade in Hardwood Plywood on 22nd May, 2025.

Represented by Washington-based law firm Wiley, the coalition includes five major U.S. producers: Columbia Forest Products, Commonwealth Plywood, Manthei Wood Products, States Industries, and Timber Products. The petitions allege that unfairly dumped and subsidised imports are undermining the competitiveness of U.S. manufacturers and threatening thousands of American jobs.

"The affirmative vote by the Commission takes the domestic industry one step closer to restoring fair competition on these products," said Timothy C. Brightbill, Wiley partner and lead counsel for the coalition.

Earlier, on 11th June, the U.S. Department of Commerce initiated antidumping (AD) and countervailing duty (CVD) investigations against these imports. The petitions claim dumping margins of up to 540.07% for China, 84.94% for Indonesia, and 152.41% for Vietnam, and mention dozens of subsidy programmes under review.

With the ITC's green light, the Commerce Department will now proceed with its investigations. Preliminary CVD findings are expected in August 2025, followed by AD findings in October. If Commerce also makes affirmative determinations, importers could face provisional duties based on the calculated margins.

Should final affirmative rulings follow from both agencies, AD and CVD orders will be imposed for a minimum of five years. Authorities may also retroactively apply duties to imports that entered up to 90 days before the preliminary findings, if a surge in shipments is detected.

The Wiley team also includes trade partner Stephanie M. Bell, associate Stephen A. Morrison, and analysts Richard F. DiDonna and Amy M. Sherman.

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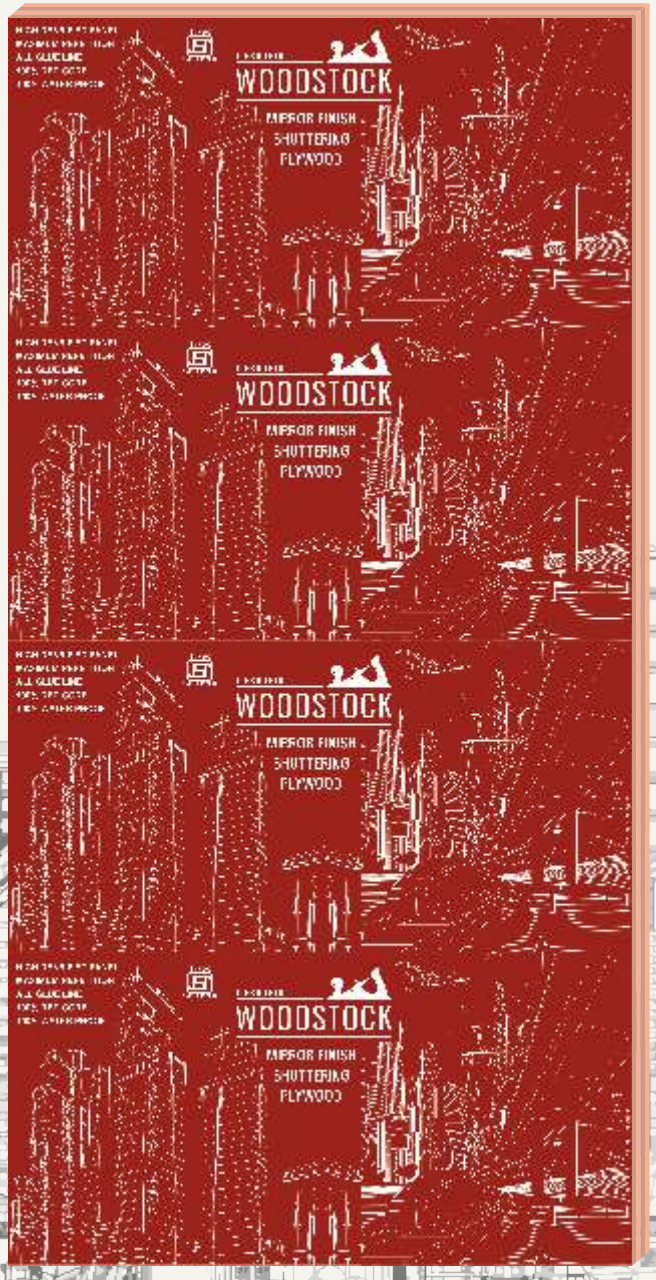

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Post QCOs For Plywood

Nepal Plywood BIS Licence Misuse Exposed

In the months following the enforcement of India's new Quality Control Orders (QCOs) for plywood and wood-based panels, unusual trends in trade with Nepal have raised red flags across the domestic industry. The surge in plywood imports from Nepal, despite a sharp drop in eligible exporters, has triggered calls for a formal investigation into potential misuse of BIS licences and circumvention of regulatory protocols.

Beginning in February 2025, the Government of India mandated that all plywood and wooden flush door shutters, along with wood-based boards imported into the country, must comply with newly enforced QCOs. These regulations, introduced through the Bureau of Indian Standards (BIS), aim to ensure product quality and public safety, while offering a level playing field for domestic manufacturers.

The rules stipulate that only BIS-certified manufacturers are permitted to export these products to India. With the new norms in place, Nepal — which had previously contributed nearly 21% of India's plywood imports — was expected to realign its export practices. Of the 54 Nepalese companies previously engaged in the trade, only nine managed to secure BIS licences in time. This reduced pool of certified exporters was, therefore, expected to result in a corresponding dip in export volumes.

However, import data paints a contradictory picture.

In March 2025, just weeks after the QCOs came into force, plywood was imported from Nepal. Notably, most of this came from

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exporters that lacked BIS certification. This pointed to a serious regulatory lapse: how were non-certified products being cleared at Indian ports? While April saw a decline in import value, the number surged in May, an unprecedented jump, despite the total number of eligible exporters remaining limited to just nine.

What has compounded the suspicion is the magnitude of growth recorded by several of these BIS-certified exporters. Data reveals that some manufacturers who had only modest trade activity from January to April 2025 showed exponential increases in May.

In volume terms, this translated to hundreds of thousands of square meters of plywood dispatched in a single month, in some cases, up to fourteen times their previous average monthly export volume.

In container terms, the disparity was equally glaring. One exporter that had shipped only nine containers of plywood in March sent 329 containers in May. Two others followed similar trajectories, going from low double-digit figures to well over 100 containers in just two months.

The core concern is that these staggering surges in BIS-certified export volumes could be masking the entry of non-compliant goods. The hypothesis is that uncertified manufacturers may be channeling their products through certified ones, using the latter's BIS credentials as cover. If true, this would represent a serious breach of India's regulatory framework, one that defeats the very objective of the QCOs.

Industry representatives argue that such activities are not just a procedural violation, but also create an uneven competitive landscape. Compliant domestic players are forced to operate under stricter cost and quality controls, while their counterparts, operating under alleged backdoor arrangements, gain a price advantage in the market.

Importantly, this situation also undermines consumer trust in regulatory enforcement and could pose quality risks for end-users who assume that all imported goods meet Indian standards.

Data further shows that the number of Nepalese manufacturers exporting plywood to India without BIS licences in March was not negligible. A list of 30 entities without certification contributed to the majority of imports that month. Following scrutiny, their consignments ceased in April and May, but by then the pattern of misrepresentation was already evident.

The analysis suggests that tighter enforcement mechanisms are needed to ensure that only genuine, certified products are cleared for entry. Without robust monitoring and traceability, licenced exporters could be exploited as conduits by unlicenced firms, a loophole that would render the BIS framework ineffective.

The domestic industry has urged Indian authorities to initiate an immediate investigation into the matter. A deeper probe is expected to determine whether licenced Nepalese manufacturers were knowingly facilitating the entry of uncertified products, and if so, what punitive measures must follow.

Suggestions include revoking the BIS licences of offenders and strengthening customs protocols to verify compliance at the port of entry.

This is not merely a question of trade statistics or import documentation. It cuts to the heart of India's policy on manufacturing standards, consumer protection, and trade equity. If non-compliant goods are entering through formal channels, the repercussions will ripple far beyond the plywood sector.

At a time when the Indian government is emphasising "Make in India" and encouraging high-quality production practices, loopholes in implementation could weaken global confidence in its systems. Furthermore, such anomalies risk eroding the credibility of BIS certifications, which are designed to reassure buyers of quality and safety.

As plywood demand remains robust, especially in real estate, infrastructure, and interior design sectors, ensuring quality compliance is critical. While foreign trade is essential and Nepal remains a close trading partner, regulatory transparency must be upheld across borders.

The call for investigation comes not as a rejection of imports, but as an affirmation of fair play. With only nine manufacturers currently holding valid BIS licences in Nepal, the volumes being reported demand explanation.

Authorities have been provided with detailed trade data, volume records, and container tracking information to support further inquiry. The expectation is that with proper auditing and field checks, any misuse of certification will be identified and addressed in a time-bound manner.

In a rules-based trading system, accountability is non-negotiable. If India's quality control regime is to function as intended, it must be implemented in both letter and spirit. Otherwise, the gatekeepers of quality may find themselves outmanoeuvred, and consumers, once again, left vulnerable.

As the dust settles on post-QCO trade realities, one thing is clear: vigilance must match policy ambition. Only then can India build a truly self-reliant, quality-first industrial ecosystem.

Rajkamal Plywood

Carving a Niche in Delhi's Panel and Surface Market

Rajkamal Plywood India Pvt. Ltd., a prominent name in Delhi's thriving Kirti Nagar timber and hardware hub, has been serving the plywood and panel trade for over three decades. Established in 1989, the company has built a strong reputation for reliability and product excellence across North India's interior and furniture markets.

Under the leadership of Director Nimish Baweja, the firm operates from its long-established head office in Kirti Nagar and has expanded its operations with a modern office and warehouse in Mundka. N Baweja plays a crucial role in overseeing the distribution network, ensuring timely supply and efficient client servicing.

Rajkamal Plywood markets its

NIMISH BAWEJA

products under the KLYSTA brand, which is especially known for calibrated, shuttring ply BWP-grade plywood made using pre-press technology. The offerings include premium-quality plywood, blockboards, flush doors, and decorative veneers, ideal for use in high-end interiors and architectural applications.

Nimish mentions of decorative wall panels and louvers being imported from abroad. These are available ex-stock in a wide variety of textures, colours, and finishes, catering to the creative demands of architects and designers.

In addition, Rajkamal Plywood offers a complete range of value-added interior materials such as flexi ply, acrylic sheets, stone veneers, MDF louvres, and veneer louvres, cementing its position as a one-stop destination for quality wood panel products in Delhi-NCR.

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Ventura International

A Leading Name in Premium Architectural Surfaces

Prashant Maheshwari

Ventura International Pvt. Ltd., founded in 1994, has grown to become a major player in India's premium architectural and decorative surface segment. Originally operating from Paharganj and later Green Park, the company is now headquartered in Delhi's Kirti Nagar, a central hub for plywood and hardware trade. Directors Prashant and Manish Maheshwari have led the company through consistent growth and product diversification.

Renowned for its high-quality offerings, Ventura caters to the evolving needs of architects, designers, and homeowners. Its product portfolio spans acrylic laminates, charcoal wall panels, decorative louvres, and more. It is also a stockist of compact laminates in varied thicknesses (0.8mm, 1mm, 1.2mm) and offers an extensive range of ARCHITECTURAL LAMINATES.

The company has an exclusive distribution partnership with Duro in the

Delhi-NCR region. Duro's NATURE SIGNATURE veneer collection is one of Ventura's premium offerings in the decorative category. Marketing Manager Tarun Saini indicates that the company focuses on qualitative imports, including its in-demand Decorative Planks range.

A standout innovation is VALCHROMAT, an organically coloured wood fibre board MDF, imported from abroad and available in thicknesses ranging from 8 mm to 25 mm.

In the exterior cladding space, Ventura offers popular branded products such as LEGNOKLAD, TECHKLAD, ALPHA LEGNOKLAD PLUS, reinforcing its position as a complete solutions provider in the surface décor industry. With its commitment to quality and innovation, Ventura International continues to lead in both aesthetics and performance-driven design.

Shanti Plywood Co.

Trusted Name in Ply and Panels

Shanti Plywood Co. is a reliable name in Delhi's Kirti Nagar timber market since 1996. Led by Dinesh Gupta, the company has built its reputation over three decades by consistently serving wholesale customers with a focus on quality and timely delivery.

Operating primarily in the plywood and panel segment, it deals in leading brands such as Greenply, Century Ply, Black Cobra, and Archid Ply, along with MDF boards including Green Panel MDF. The company also stocks Royal Touch and Bhutan Tuff plyboards, and is a prominent stockist of Alstone products for the exterior panel segment.

DINESH GUPTA

Premier Sales Corporation

A Trusted Name in Delhi's Panel Trade

Premier Sales Corporation, based in Delhi's bustling timber and wood products market, Kirti Nagar Market, has emerged as a key player in the plywood and panel trade since its inception in 1989. Founded by Vinod Sawa shortly after the market was established, the company started as an independent venture after gaining initial experience in the region's plywood business landscape.

The enterprise primarily deals in Greenply Plywood and MDF boards from Green Panel, catering to both commercial and residential needs. In the decorative range, it prominently features the Legend brand Decorative Veneers and Archid Ply. For laminates, the Mumbai-based BRAVIA brand is a notable inclusion in its portfolio.

With a solid reputation among contractors and architects, Premier Sales Corporation has carved a significant presence in the commercial interiors segment. Says young entrepreneur Harsh Sawa, bringing in a new generation of leadership focused on growth and innovation.

VINOD SAWA

The company continues to be regarded as a reliable and preferred whole sale supplier across Delhi-NCR, known for its product range, quality assurance, and long-standing industry experience.

Ply Samrat

A Trusted Name in Plywood Since 1990

Ply Samrat (India) Ltd, based in Delhi's Kirti Nagar, has been recognised as a prominent player in the plywood industry since its inception in 1990. The company was founded by Bijoy, Sitaram, and Gopal Prasad. Over the years, it has built a strong portfolio featuring major plywood brands like Duro and Century Ply, with HANS PLY from Southern India and SAHARA representing its registered laminate brand.

In the HDMR segment, the company has partnered with Green Panel and Nu-Wud products. Its decorative offerings also include leading names like DURO, Century, and Greenlam's Decowood.

Under the leadership of Bishal and Vivek Jhawar, who currently head the company's sales operations, Ply Samrat has expanded its reach. According to Vivek Jhawar, the company is also a distributor for Action TESA's flooring sheets in the Delhi region.

Ply Mahal

A Trusted Hub for Decorative Plywood

Ply Mahal has earned a strong reputation in Delhi's Kirti Nagar market (main road) as a leading name in decorative products. Incepted in 1998 by Pankaj Kumar, the organisation is known for delivering quality materials for furniture and interior applications across homes, offices, hotels, and institutions. Pankaj Kumar, who continues to lead operations, has built the business on a foundation of quality assurance and product expertise.

Ply Mahal offers a wide array of premium products, including decorative panels, laminates, veneers, louvers, acrylic sheets, and charcoal sheets. The brand maintains a consistent focus on design and finish, catering to evolving market preferences.

Pankaj Kumar

According to Pankaj, the enterprise imports decorative panels and markets them under the brand name MERIDIAN. The market has responded positively to the brand. In addition, it is the sole distributor of Delhi based decorative panel brand GLOIRIO, in the region. With over three decades of experience, Ply Mahal continues to hold a prominent place in Delhi-NCR's decorative plywood sector, serving both professional and retail customers.

Mangalam Décor

Growing Presence in Delhi-NCR

Nikunj Karnany

Mangalam Décors India Pvt. Ltd., based in Delhi's Kirti Nagar décor hub, has built a solid reputation in decorative plywood and interior material Products. The company was founded in 1987 by Pradip Kumar and has since accumulated nearly four decades of experience. Known for its wide-ranging product portfolio, the business primarily operates in the wholesale distribution of premium interior décor materials.

Mangalam Décor serves as the Delhi-NCR distributor for "Natura Veneer," a brand by Ahmedabad-based Turakhia Overseas. It is also associated with Mumbai's EURO-Pratik for a variety of products including decorative panels, louvers, and charcoal sheets. Company sources state that they import decorative wall panels from international suppliers, which are also distributed across the market.

The company aligns its product offerings with the evolving demand in Delhi-NCR. The firm's marketing and brand strategy is managed by Nikunj Karnany, the company's young director, who oversees promotional efforts and business outreach.

Subhnen Panel Products

A Dependable Name in Plywood and Decoratives

Established in 1998 by Shushil Agarwal in Delhi's prominent plywood hub, Kirti Nagar, Subhnen Panel Products (P) Ltd. began its journey as Subhnen Ply and Laminates. Over the years, it has emerged as a recognised brand in the plywood and decorative panel segment.

The company's flagship brand, EURO PLUS, represents its core offering in the plywood category. It also holds the distinction of being the sole distributor of EURO PRATIK in North India, covering a wide portfolio that includes decorative wall panels, louvres, charcoal sheets, acrylic sheets, and MDF designer panels.

Young and Energetic Director Bhumanyu Agarwal emphasises the company's commitment to innovation and premium quality.

Bhumanyu Agarwal

For the past ten years, Subhnen has also been actively marketing the LIBA brand in the decorative surface segment. Under this label, the company offers a wide variety of louvres, panels, and MDF-based designer products. LIBA's offerings are appreciated for their aesthetics and variety, securing a strong presence in the market.

Subhnen Panel Products continues to expand its footprint by delivering versatile, high-demand surface solutions.

Saket Mica

Celebrates Dealers and Growth at Udaipur

Udaipur witnessed a vibrant gathering of camaraderie and celebration on 21st June, 2025, as Saket Mica hosted its annual Dealer Meet at the scenic Resort Divine Inn. The event brought together over 45 dealers and channel partners, highlighting the brand's commitment to expanding its presence and strengthening bonds across Rajasthan.

Saket Mica, known for its growing presence in the decorative laminates sector, is backed by the established legacy of Amulya Mica. Both brands operate under Amulya Mica Industries Pvt. Ltd., a company reputed for quality craftsmanship and product innovation.

The event was organised in collaboration with Rishi Laminates, Saket Mica's Udaipur distributor, and recognised outstanding partners with Achiever Awards. Members of the leadership team, including Deputy Regional Manager Mukesh Sharma, Deputy Branch Manager Manoj Nagarka, TSM Tarvinder Singh, and ISR Harshit Joshi, joined the celebration

alongside distributor representatives Virendra Sanghavi and Amit Sanghavi.

The meet opened with a traditional lamp-lighting, followed by Ganesh Vandana and the national anthem. M. Sharma's keynote address introduced new product innovations, including pastel-toned textures such as Abstract Grill, Moroccan Mesh, and Crossed Stone. He also spotlighted the brand's premium collections like Metallic Digital Laminates and 1.25 mm bendable PVC laminates.

Attendees learned of Saket Mica's recent achievements, including impactful CSR activities and its recognition with the CII National MSME Shining Award 2025 for manufacturing excellence.

Interactive games, music, and an elaborate gala dinner brought energy and joy to the evening, reflecting the company's focus on both business and bonding. The Udaipur Dealer Meet was not only a celebration of milestones but also a reaffirmation of Saket Mica's vision to grow through collaboration, innovation, and trust.

ACIMALL

New Board, Charting Path for Innovation and Growth

The general assembly of Acimall, Italy's association of furniture and wood technology manufacturers, convened on 3rd July to elect its new board for the 2025–2027 term. The announcement came during the annual gathering, where key figures from the sector reflected on industry trends and future strategies.

The new board will include five members: Marianna Daschini of Greda, Mario Moretti of Costa Levigatrici, Pierluigi Paoletti of Paoletti Energy, Franco Paviotti of Metal World, and Gianluca Storti of Storti. They will serve alongside current president Enrico Aureli of SCM Group and Raphaël Prati of Biesse, whose term is set for renewal next year as per Acimall's statutes.

In his opening address, Aureli emphasised the importance of digital transformation, urging members to focus beyond surface-level innovation and prioritise the role of software as the core of technological advancement. He noted that companies must embrace change with a new perspective, leveraging not only technical expertise but also experience and deep-rooted competence to stay competitive globally.

The assembly unanimously approved the financial statements before shifting attention to a detailed industry report by Mecs (Manufacturing Economic Studies). The study painted a robust picture of Italy's woodworking technology sector, highlighting its employment of nearly 10,000 individuals across 188 significant companies. The industry achieved a production value of €2.47 billion in 2024, with exports comprising 74.1% of that figure, or €1.83 billion.

The day concluded with a keynote by Riccardo Cavanna, president of the newly formed Federazione Confindustria Macchine, which unites Acimall with other industrial associations including Acimac, Amaplast, and Ucima. Cavanna underscored the federation's mission to advocate for Italian mechanical engineering on both national and global platforms, aiming to influence policy decisions that shape the sector's future.

XYLEXPO 2026

Unveiling a Bold, Cross-Industry Future

The upcoming edition of XYLEXPO, scheduled from 9th to 12th June, 2026, Milan, is set to mark a transformative moment for the woodworking and furniture industries. Announced as part of a broader event titled "Matec–materiali e tecnologie," the biennial international exhibition will align itself with other key sectors in manufacturing, signaling a shift toward a more integrated, cross-industry showcase of technologies.

This new direction will see XYLEXPO sharing the stage with Plast, the international exhibition for plastic and rubber industry technologies, and Composites Future, an expo-conference dedicated to composite materials and solutions. Organised with the support of Assocompositi, the national association of composite industry players Composites Future will be held in halls 14 and 18 of FieraMilano-Rho, under the banner "Porta Ovest."

The decision to hold the event in early June was influenced by scheduling constraints at the FieraMilano-Rho venue, which has been partially allocated to the Milano-Cortina 2026 Winter Olympics. This logistical adjustment, however, has become an opportunity to reimagine the exhibition format. The three participating shows will adopt a segment-based layout, defined by technologies and materials, opening the door for future collaboration with additional sectors of the manufacturing industry.

Organisers noted that this convergence reflects a growing industry demand for multi-material, multi-technology solutions. The initiative also aligns with efforts by Federazione Confindustria Macchine, the federation representing machinery manufacturers across wood, plastic, ceramics, and packaging sectors, to develop closer ties and shared innovation.

Enrico Aureli, President of XYLEXPO and Acimall, emphasised that this edition represents a strategic milestone. He said the exhibition aims to create "stronger, more tangible, and attractive synergies" by bringing together industries with overlapping needs. Aureli added that by offering a unified platform for advanced manufacturing technologies, XYLEXPO 2026 is poised to provide both exhibitors and visitors with richer opportunities for discovery, innovation, and growth. The show's expanded scope reflects a broader ambition: to redefine the way industries connect, collaborate, and evolve.

RIL

Inviting Visitors to Experience ReLWOOD at AceReflect 2025

Reliance Industries Limited (RIL) invites industry professionals to explore ReLWOOD® at AceReflect 2025, scheduled on 19th–20th July from 10 am - 7 pm at the Jaipur Exhibition & Convention Centre (JECC). Positioned as a sustainable, high-performance alternative to wood, ReLWOOD® promises durability, design freedom, and a revolutionary leap in materials.

Nepal Wood 2025

Announcing 11th Edition in Kathmandu

Organisers have announced the 11th edition of Nepal Wood International Expo from 19th to 21st December, 2025, at Bhrikuti Mandap, Kathmandu. Exhibitor registrations and stall bookings are now open for Nepal's premier expo on wood, woodworking, and furniture production technology, organised by Media Space Futurex. Details are available at www.nepalwood.com.np

Glue Formulations – Preparation and Properties of Glue Mix

Dr. S.K. Nath

The article reproduced below is Chapter 27 – "Glue Formulations - Preparation and Properties of Glue Mix" from the book entitled ***Plywood Manufacturing Practices in India - 2nd Edition.*** *The book has been compiled and edited by Dr. S.K. Nath, Joint Director (now Retd.), Indian Plywood Industries Research and Training Institute (IPIRTI), Bengaluru (Karnataka). The book covers the entire production line of plywood manufacture suitable for small and medium scale industry under the Indian conditions.*

Formulating an adhesive to join together slices of wood to make plywood is not an easy task because this natural lignocellulose material has varying properties from species to species and also differs within the same species. A plywood adhesive should therefore be of such flexible properties as to outlaw all minor differences in properties within the adherent (wood) and attains sufficiently strong bond on curing.

An adhesive should be such that upon completion of hot/cold pressing must have wet the surface of the wood, penetrated a few cells deep and have chemically cross linked (cured), yet left sufficient glue in the glue line to form a continuous homogeneous film between the two surfaces and still have a greater tensile strength than the surrounding wood so that mechanical failure will be in the wood, not in the glue. As the resin cures, small chain polymers are changed into solid polymers of enormous chain length, these chains are also branched to nearby chain forming giant molecules. It is this cross linking that is typical to thermoset adhesive. On the other hand, adhesives, such as PVA tend to form long straight chains, are thermoplastic and can be easily softened upon heat application, re-dissolved or will creep under applied load. At present, the only proven plywood adhesives are formaldehyde based. In India, urea and phenolic are used almost absolutely in plywood industry.

Adhesives used in plywood industry are composed of the components suspended in water. These components are: (1) Synthetic resin, (2) Extender and/or filler, (3) Hardener or catalyst and buffer and (4) Glue line poison, if needed. Other additives are also added to glue mix as and when needed.

It should be noted that UF and PF resins in liquid form, as used by the factories, are of varied solid content. Thus UF is available in powder form or as liquid with solid content varying from 48 percent to 65 percent. Comparatively, PF resin is normally

made and used in liquid form having solid content of 42 to 50%, although PF film and powder resin are also available for use in plywood industry. Care should be taken while formulating an adhesive for a particular grade of plywood in adding water to glue mix so that required resin content is attained in the glue mix.

The role of the resin used in the adhesive formulation is to impart strength to the film developed upon cross linking, and hold the two adjoining surfaces to give the glue line resistance to moisture. The type and preparation of the resin employed is dictated by end use of the product. UF resins are used for products that will not be required to have high moisture resistance i.e. for cool, dry interior. PF resins are used for applications where a very high moisture resistance is required e.g. marine, high temperature conditions. For intermediate exposure conditions between these two extremes, a melamine fortified UF resin or melamine urea formaldehyde (MUF) resin can be used. Both UF and PF resins are capable of forming creep resistance glue lines in their respective areas of use.

The filler/extender components are the sand/screenings of concrete. They are used to control viscosity and flow characteristics, decrease cost and impart tack to pre–pressed veneer. The type of filler/extender used with an adhesive may affect its durability and the use of extender may be prohibited for highest grade of adhesive. Amylaceous (starch) and proteins are hygroscopic in nature and may be affected by moisture changes and fungal attack and although the adhesive itself might be considered immune to these agents, a lowering of the efficiency and durability of the glue lines might result by the presence of extenders.

In formulating UF resin adhesives the amount of filler/extender added is governed by the final exposure hazard to be experienced by the products. For example, exposure of the product to limited wetting would require the use of low extensions whereas cool dry interior, low stress applications, high extension of flour, etc. can be used, thus cheapening the adhesive. UF extensions do require water addition to compensate for increased viscosity brought about by flour and/or proteinous extenders.

Fortification of UF resin with melamine chemical increases the moisture resistance of the adhesive. However manufacture and use of MUF resin has become common in plywood factories, although addition of melamine powder to UF resin is also a common practice. Melamine may be added during preparation of adhesive mix, but care should be taken on the following points:

(a) There must be sufficient formaldehyde either in the free form and/or be split off in the UF crosslink reaction to cure the added melamine.

(b) Formaldehyde may be added to adhesive mix.

(c) Sufficient moisture must be present in the glue line during hot pressing to allow the melamine addition reaction to proceed.

Phenolic resin adhesives are less flexible, mainly as a result of cure rate and melt flow characteristics. Large extender dilutions of PF resin cannot be made because PF glue lines are required to be far more stressed in service either mechanically or subjected to more severe attack by the wood destroying elements. It should be noted that phenolic resins cure far more slowly than UF. The period and degree of reduction of resin viscosity during onset of hot pressing are far greater than UF. Because of these, they are very much sensitive to moisture content variations in the hot press.

Mineral extenders are of low cost, but they only serve to control initial viscosities. These are used to cheapen the adhesive making no contribution to tack or flow characteristics.

Organic extender such as flours and starch are capable of forming films in their own right. It should be noted that these extenders exhibit much greater mix viscosity changes than mineral extenders/fillers. Again starches and wood flour mixes usually continue to rise in mix viscosity to a far greater degree than, for instance, nutshell flours.

The effect of glue line pH is of importance as the pH of an adhesive is not adjusted to suit a particular species of timber but rather determined by the curing requirements of the adhesives. The catalyst/hardener component of the adhesive

control the reactivity of the adhesive and with UF, a variety of acid salts and buffers are available to set the curing pH to a particular value. Investigations have demonstrated that adhesives with pH below 2.7 damage wood fibre adjacent to glue. The value of pH of adhesives below which optimum bond strength are not obtained and deterioration upon ageing become appreciable was around 4 for urea resin bonded plywood and 3.5 for phenolic resin bonded plywood. It has also been found that at a given pH, strong mineral acids like hydrochloric or sulphuric acid had a considerably more deteriorating effect on wood than weaker organic acid e.g. para toluene sulphonic acid or nitranilic acid.

Highly alkaline adhesives can apparently also have an adverse effect on the structure of the adhesive in the glue lines or on timber. For example, birch plywood made with a phenolic resin catalysed with a strong alkali (sodium hydroxide) decreased in strength as the pH of the plywood increased. Although not agreed by all, but many authorities are with the opinion of limiting the pH value of the cured film to not less than 2.5 nor more than 11.7 for phenolic resin.

The viscosity at which the adhesive is used is easily controlled through filler and extender addition but viscosity should be controlled within narrow limits as flow characters can be altered dramatically by changes in glue spread. Viscosity is important mainly in the glue application area. A suitable viscosity must be chosen so that desired spread is achieved and the mix can obviously be handled. It is the components of the mix that have more effects on the final results not the actual mix viscosity. Typical viscosities of glue mix should be 200–370 cp for UF based adhesive and 350–500 cp for PF base (in B6 flow cup of IS–3944–1969 should be 15–20 secs. for UF based adhesives and 30–60 secs. for PF based adhesive). However viscosities are not hard and fast to effect bonding.

Addition of water to adhesive mix is to be restricted within certain limit to resin. A higher amount of water, extender and filler should not be added unnecessarily to adhesive mix in order to cheapen the glue, such adhesive would otherwise lead to form poor bond and other defects such as blister, delamination, etc. Typical example, for PF resin based adhesive mix, the ratio of resin to water should be 1:1 and for UF resin, the adhesive mix may contain 1.5 times water compared to resin.

The interval between spreading of glue on the first veneer and the application of full or adequate pressure on the veneer assembly is called assembly time and a good structural adhesive should remain damp or tacky for the whole of this period at normal floor temperature. At the same time, adhesive formulation and adjustment of hardener/catalyst should be such that the resin should cure with specified time of hot pressing or on clamping.

Curing of UF based adhesive can be brought about by lowering pH either at room temperature or at elevated temperature. A small amount of an acid or acid salt is added to the glue mix. It produces no visible change except slightly lowering the pH of glue mix just below pH 7. After few hours, thickening starts and the resin gels and hardens to

insoluble material.

Usually ammonium salts, generally ammonium chloride or sulphate is used as hardener for urea resin. These hardeners are better than strong acid like hydrochloric acid as the later produces weaker joints. Ammonium chloride reacts with free formaldehyde in the resin to produce hydrochloric acid.

$$4NH_4Cl+6HCHO \rightarrow 4HCl+C_6N_4H_{12}+6H_2O$$

The rate of curing of the resin is determined by the rate of acid release and also on the amount of heat supplied. Thus the curing time may be a few hours at ambient temperature and a few minutes at 100°C or more. Often ammonia solution is added to lengthen the usable life (pot life) of the glue mix.

For melamine fortified UF resin, curing conditions are more or less the same. However, for MUF co-condensed resin, para–toluene sulphonic acid has been found to perform better as catalyst than ammonium salts. Where melamine replaces urea in UF resin by 50% or more in weight ratio, the resultant MUF resin can be cured without addition of a catalyst, only by application of heat.

Alkaline phenol formaldehyde resin is cured only by application of heat without using catalyst. However, the resin does not cure under prolonged pressure at ambient temperature. A minimum heat input of 100°C for minimum 3 minutes or more for low condensed phenolic resin is required to initiate curing. However, phenol formaldehyde can be cured at ambient temperature by lowering pH of the resin. Usually paratoluene sulphonic acid with or without boric acid is used to lower the pH of the resin to 2–4. At this pH, phenol formaldehyde can be cured under pressure without application of heat.

Preparation of Adhesive Mixes

The adhesive components have to be mixed by weight and for this purpose, accurate measuring equipment should always be available.

The equipment used for mixing should be made of a material which will not react chemically with any components of the adhesive and which is easy to clean. It will be an advantage if separate mixing equipment can be kept for different adhesives. However, if the same equipment is used for all types of adhesives, it should be thoroughly cleaned with water or chemicals, if necessary, before changing to a different adhesive.

Equipment which reacts with acid or alkali should not be used with resin or other additives which are acidic or alkaline in nature. In practice, plastic containers are often used because they are easier to clean even after unused adhesive has been allowed to store for longer period.

There are several methods of mixing adhesive components together and the use of a particular method depends upon the amount of adhesive required and the type of adhesive selected for use. Several equipment used glue mixing are:

a) Stirring or whisking by hand.
b) Slow speed electrical drill perhaps

with reduction gear attachment and stirring equipment (Fig. 27.1).

c) Special container with paddle blades attached to and driven by glue spreader.

d) Motor driven glue mixer (Fig. 27.2)

Fig. 27.1 Vertical type Glue Mixer

Plywood mills in India use horizontal drum type glue mixer attached with motor driven horizontal blades (Fig. 27.2). The mixer opens at the top which serves as inlet for mixing ingredients. The outlet opens at the bottom fitted with a valve. The equipment is made of steel or mild steel.

Fig. 27.2 Horizontal type Glue Mixer

It is necessary to make sure that the correct paddle or stirrer speed is used. Too rapid stirring will mix air with the adhesive and cause foaming while a slow paddle speed will take a long time, may cause lumping of the adhesive and possibly reduce the assembly life of the glue. A mixer speed of 60 rpm is suitable for the lighter adhesive, while the heavier types may require speeds as low as 30–40 rpm. 7After mixing, the adhesive mix is usually recommended to stand for a period so that any entrapped air bubbles can rise to the surface. This is necessary because the use of aerated adhesives could lead to formation of non-uniform glue lines.

Liquid resins made from powder form, can be a source of annoyance to the user unless precautions are taken to prevent the formation of lumps during mixing. When mixing powder by hand, it is preferable to add it to water gradually while stirring. Any lump formed can then be beaten out before more powder is added. Mechanical mixing, however, requires the opposite technique and liquids should be added slowly to the powder while the mixer is in operation.

The quantity of glue prepared in one batch depends upon the curing properties of the material. Glue with a very short working life must be prepared in small batches. Even when glue remains usable over a long storage period, but its spreading properties change substantially with time, it is desirable to prepare small batches.

Adhesive components which tend to increase temperature during mixing require careful treatment. To minimise the effect of the increased temperature, either small

batches are prepared or large mixes are distributed in shallow trays. A water jacketed mixer with the jacket filled with cold water or ice may be found useful during warm weather to prolong the working life of the adhesive.

Adhesives are liable to cause dermatitis and it is essential that employees who handle them are provided with protective clothing (rubber gloves, goggles, aprons) and adequate washing facilities. Gluing crews should be encouraged to make use of barrier creams before commencing gluing operations and wet rags, while handling adhesives, so that glue which settles on exposed skin can be removed before it has opportunity to dry as this is believed to be a cause of dermatitis.

It is also essential that scratches and cuts, which may be caused by dried glue or equipment may be given first aid treatment and covered from liquid adhesives. As additional precaution, sulphite soap should be made available for washing and its use encouraged.

Prime requirements of a good adhesive

1) While bonding, the adhesive must not shrink unduly thereby, setting up excessive internal stresses in the joint.
2) An adhesive must have the toughness and strength to resist failure within the glue line under the condition to which the joint will be subjected to in service.
3) During the bonding or shortly thereafter, the adhesive must become harder and tougher.
4) An adhesive must not act adversely on the material being bonded.
5) An adhesive should be either a liquid or a soft, readily deformable solid. By flow or deformation, the adhesive must shape intimately to the roughness of the solid surfaces of wood/veneer.
6) An adhesive must share some mutual attraction with solid surfaces in bonds.

Testing of Resins, Adhesives and Plywood Bond Strength

The analysis and characterisation of materials is a major part of adhesive

development. Such studies contribute towards a basic understanding of the adhesion phenomenon and provide information on the adhesion mechanisms of specific adhesive formulations. Effective product analysis ensures consistent product quality and also facilities to maintain uniformity in service, which is applied to produce a secondary product using it as raw material.

There are two ways to look at adhesive characterisation. From an application viewpoint, most of the information needed for adhesive formulation can be obtained through adhesive specification, mechanical testing and end use properties. Measurements of viscosity, stress/strain and peel tests are commonly used.

Another way to characterise the adhesive system is to view it at microscopic and molecular levels. An adhesive, after all, consists of chemicals, each of which possesses a unique structure that can be related to some specific properties. Thus, structural characterisation or understanding the chemistry of the adhesive can provide information on how or why a given adhesive system works or fails.

A plywood factory normally uses a resin or an adhesive prepared from the resin whose properties are well established. But regular testing of the resin and the adhesive are necessary in order to maintain uniform quality so that plywood made by using them produces uniform bond quality. The testing and characterisation will therefore be limited to adhesive specification, mechanical testing and end use properties.

Resin and adhesive characters which are generally tested: 1) solid content, 2) viscosity, 3) water tolerance, 4) gel time, 5) shelf life, 6) pot life, 7) pH value.

Tests carried out to study the mechanical strength properties related to adhesive bond are (1) knife test and (2) glue shear strength.

A few tests are carried out to find out the durability under various environmental conditions are: 1) warm and boiling water resistance, 2) cyclic test, 3) resistance to micro-organisms.

Tests carried out to assess Resin and Adhesive properties

1) Solid Content

It is the percent by weight of non–volatile present in a material. Approximately 2 gm. of resin weighed up to nearest 1 mg is taken in pre–weighed Petri dish of size 100mm by 22 mm or its equivalent and mixed well with about 10 gm. (accurately weighed) oven dried quartz sand and distributed uniformly over the bottom of the dish in a thin layer. The Petri dish along with its content is kept in an air oven at $103^{\circ} \pm 2^{\circ}C$ till the constant weight is obtained.

The percent of non-volatile content or total solid is determined as follows:

$$\text{Non-volatile content, percent} = \frac{\text{Wt. of residue}}{\text{Wt. of specomen}} \times 100$$

The weight of the residue is the difference in the weight of the dish and content before and after heating.

2) Viscosity

Ideal viscous bodies exhibit flow with the rate of flow being a function of the stress. Such bodies cannot sustain strains for long since these are relieved by flow. Regardless of the geometry of the body and the deformation, the flow will always be in the form of laminar shear. The ratio of applied shearing stress to rate of shear for ideal viscous bodies are called the co-efficient of viscosity. The best known ideal viscous body is the Newtonian fluid for which the "coefficient of viscosity" is a constant. The coefficient of viscosity is generally called simply "viscosity" and is measured in terms of poises (dynes-sec/cm^2). For a resin, viscosity is a measure to assess the progress and extent of polymerisation of the resin either during manufacture or use. Measurement of viscosity is thus helpful to control and to determine the end point of a resin during manufacture. Viscosity of a resin also dictates the quantity of additives to be added in a glue mix to obtain an adhesive of definite consistency.

There are various types of viscometer for measuring viscosity of a resin or an adhesive mix i) rotational viscometer, (ii) capillary viscometer, (iii) falling and rolling ball viscometer, (iv) raising bubble viscometer and others. However, only for very precise work in the laboratory, viscometer is used. At the resin plant or in

factory, the actual viscosity of resin or glue mix is not measured; rather the flow properties of resin or adhesives are studies by use of standard flow cups. The method is very simple and quick and therefore suitable for instant recording in an ongoing process.

In the actual process, the resin or an adhesive is allowed to flow through a calibrated orifice of a standard cup having definite capacity. Time taken by a definite volume of resin or adhesive to pass through the orifice of a standard cup is noted and comparative viscosity is found. However, for practical purpose the value of flow time of the resin or adhesive is considered sufficient for quality assessment.

3) Water Tolerance

Water tolerance is a measure of the extent of progress of the chemical reaction between the reacting molecules of a resin. It is defined as the number of quanta of water by weight that can be added to unit quantum of resin before incipient precipitate appears.

Almost all resins used in plywood manufacture are in aqueous medium and during preparation of glue from resin, water is always an additive to the glue mix – the quantity added may vary from a small to a great extent depending on the bond type to be manufactured utilising the particular adhesive. Water tolerance determines the maximum quantity of water that may be added safely to the resin so that the backbone resin will remain well in solution.

Normally during manufacture of urea formaldehyde resin or phenol formaldehyde resin by conventional method, water tolerance decreases as the cooking or polymerisation proceeds. On the other hand, phenol formaldehyde resin manufacture with 15% or more caustic on weight of phenol show gradual increase in water tolerance and for such resin reaction is arrested as the resin attains infinite water tolerance. Like viscosity measurement, water tolerance is also used to monitor the progress of polymerisation of UF, PF or similar resins and thus dictates the end point of the cooking of a resin suitable for plywood manufacture. Sometimes, measurement of water tolerance as a single property of the resin determines the end point of cooking if desired viscosity is not attained within the time frame of cooking and water tolerance begins to fall below limit.

Water tolerance can be measured by a very simple means and does not require elaborate or high cost equipment. A weighed quantity of resin is taken into a glass test tube and the same quantity or its fraction of water is added each time. After each addition, the content in the test tube is shaken, allowed to stand for a minute and observed closely to find if any precipitate is formed. The weight of water added (or the weight ratio of resin : water) just before the last addition when precipitate appeared is taken as water tolerance of resin.

4) Gel Time

Binding of two timber faces with an adhesive is done by applying the adhesive on one of the two faces of timber or veneer and then hardening or curing the adhesive between two faces under pressure or both heat and pressure. During this process of

bonding, two changes occur in the resin – it is transformed from liquid state to solid state and secondly it undergoes an irreversible polymerisation. Such transition in a resin can be brought about by heat and addition of a catalyst or hardener or both.

Gel time of an adhesive is defined as the time required by it to transform from liquid to gel or solid after addition of hardener or catalyst or the application of heat.

Gel time is determined in a very simple instrument named Gel Timer. This instrument has an expendable rotor, affixed to the shaft (which operates the second or minute hand of a clock) is inserted into the adhesive. The later is heated at a definite temperature. As the mixture gels, the rotor is prevented from turning and stops the clock.

Gel time can be determined in the laboratory without the aid of an instrument. About 10 gm. of resin is taken in a test tube and, where a hardener is used for curing, required quantity of hardener is added to it and test tube is immersed into a constant temperature bath maintained at curing temperature of the resin. The resin and the hardener are constantly stirred with a glass rod till the resin gels and the time noted.

Gel time of a resin is dependent on temperature and the quantity and type of hardener or catalyst. Higher the temperature, lower is the gel time. A mineral acid can bring about instant gel in urea or phenol formaldehyde resin but a hardener like ammonium chloride, added to UF or paratoluene sulphonic acid added to PF brings slow gelling of the resin. Higher quantity of hardener also leads to comparatively faster gelling.

5) Pot Life

After the addition of additives and hardener or catalyst to the resin to make a glue mix, the usable life of the synthetic resin starts decreasing. The rate of diminishing of usable life of the resin may be slow or quick depending on the type of resin and the type of hardener and their quantity added to it.

The pot life of an adhesive is the time between the addition of hardener to the resin and when it is no more in usable condition. Pot life can be used to indicate the state of polymerisation of the resin and is also a quality of fundamental importance to the users, since the viscosity which is greatly influenced by the degree of polymerisation has considerable importance on the rate and ease of polymerisation. The transition point from liquid to gel is often quite sharp and pot life and gel time are virtually identical, in certain instances. However, pot life is generally very long and the transition point is not clearly detectable.

The pot life of an adhesive depends primarily on the type and quantity of hardener, temperature and also influenced by loss of water by evaporation, type and extent of extender used.

The pot life of an adhesive can be determined by keeping about 100 gm of the prepared glue in a beaker immediately after addition of hardener and monitoring the time till it starts gelling. A better means of evaluating the actual usable life of a glue mix is to prepare plywood with the adhesive at different interval of time after the adhesive is

made ready for use and assessing the bond quality of the plywood. Pot life of the glue mix is that period of time till the plywood made with the glue mix meets the bond quality as per the relevant standard.

6) Storage Life

Storage life or shelf life of a resin is the time from its preparation till which it can be used to manufacture plywood with standard bond quality. Storage should be done in a dry room at about 25°C temperature. When a resin is received from other manufacturer, storage life or date of expiry is marked on the containers. But in India, many plywood manufacturers make resin in plywood factories for in-house consumption. In such a case, storage life of the resin has to be worked out by them. A resin is said to be expired when it fails to give adequate bond strength in plywood as required to meet the relevant specification.

Powdered resin used in Indian plywood factories have an average storage life of six months and that of liquid resin (UF and PF) are of one month provided the resin is stored in a cool place and containers are always kept properly sealed. Loss of solvent from liquid components due to damaged container or improperly replaced covers is likely to reduce substantially their storage life and seriously affect the quality of the adhesives. Powder resin should be stored in air tight containers; contamination of water will lead to lump formation and spoil the resin.

7) pH of Resin and dhesive

pH is a measure of acidity or alkalinity of a given substance. In dealing with plywood adhesives, the knowledge of pH of resin, glue mix and glue line (or cured adhesive) are necessary. The pH of thermosetting resin is a major factor so far as the stability or shelf life is concerned and is measured and adjusted as a part of routine test at the manufacturing stage. pH of adhesive mix is very important as it affects both curing and pot life of the adhesive. Great importance is associated with the pH of the cured adhesive or glue line pH. Very high and very low pH is undesirable. The extreme limit of glue line pH is 2.5 and 11.7 – pH outside this range causes degradation to the adherents or of the adhesive itself.

pH can be determined by use of pH paper or a pH meter with glass electrode. For routine work with resin and adhesive, pH values are checked and adjusted with the help of pH paper. For very precise work where accurate data is requireds pH values can be determined using a pH meter. pH of cured adhesive can be determined by the method suggested in IS: 848–1974 (Acidity or alkalinity or pH value).

Test for Mechanical Strength Properties

The single most widely tested property of plywood is perhaps its adhesive bond quality. This is because of the fact the integrity of plywood as a panel depends entirely on the tenacity with which the constituent plies of the panel are held together by the adhesive. Adhesion of plies is tested by either a forcible separation by using a knife to open the plies or by cyclic test.

Knife Test

The knife test is a quasi-rationalised visual or appearance test. It helps to assess the bond quality between adjacent veneers after they have been separated from one another by using a knife as prescribed in IS: 1734 – 1972 (Part V).

Knife test is carried out on a stout table with a thick wooden batten screwed on to its surface. The edge of the test piece is placed against the batten. The knife is inserted into a depth of about a meter-centi with its cutting edge parallel to the grain of the face veneer and the veneer is praised upward. On praising upwards, the veneer usually breaks off over a width which is only slightly greater than that of the tool. Plywood made up of hard and dense species of veneers, requires considerable force to effect entry of knife, even the aid of a hammer may be necessary. Knife test can be carried out in dry state or after boiling the sample in water for prescribed period.

In testing of plywood bond quality, the knife test is more useful than shear test because it allows a better assessment of the interlocking of the adhesive and the surface. After the test, the test pieces are compared with the master scale to assess the quality of bond. As per IS: 1734 (Part V) – 1972, the bond quality is categorised to be in three groups.

1. Excellent: The highest bond quality

is obtained when the separation occurs only through the breaking of the wood itself i.e. the pried open surface is entirely covered by adhering wood fibre.

2. Pass standard: The glue line is mostly covered by adhering fibre with a small glue line failure percentage.
3. Poor Bond: The bond quality obtained with separation through the glue line to which a few or no wood fibre is left adhering. In this case, the knife meets very little resistance through the glue line.

Due to the fact that no objective and quantitative measurements can be made with this test, not such importance is given on this test in the Indian Standard and also in the field of research work in India.

However, keeping in view of the fact that this test helps in actual evaluation of the glue wood interaction, it can be standardised and a quantitative master scale can be prepared for evaluating the results of knife test. For example, the British Standard BS: 1455–1963 contains a scale of six bond qualities. The highest bond quality is given in No.10 and the lowest 0 with intermediate qualities being given the even number 8, 6, 4, 2.

The actual assessment can be done by visually comparing a knifed sample with those of the master act and each glue line stabbed at a particular spot can be assigned to a particular number of the master scale. If a number of such mean is rounded off to the nearest whole number it will give the average quality index of the material under test.

Tensile Glue Shear Test

Of all the mechanical tests, tensile glue shear test is almost a common and most widely used test to determine the adhesive bond quality of plywood.

The test is carried out on carefully prepared 3–ply specimens under fairly well defined conditions described in IS:848 –1974. The specification for preparation of test specification is length 100 mm, width 25 mm, shear length 25 mm, width of notches 3 mm, depth of notches – cut through the face and core ply upto second glue line.

When the number of plies exceeds three in the plywood, it is stripped off all except any three selected plies either by chiselling or by planning. The stripping has to be done so as to test any two of the adjoining glue joints provided at least half of the number of the specimens so tested include the innermost glue joint. If any crack is developed in the specimen during chiselling, the same is to be rejected as the specimen may fail at the crack before the full joint strength is developed.

Tensile glue shear test is conducted on a tensile testing machine or on a Universal Testing Machine. The rate of loading as per Indian Standard is specified as 135–270 kg/min. The glue shear strength or maximum breaking load is recorded either visually or on a machine chart. After the test is over, the broken samples are examined for percentage of glue or wood failure between the notched areas. There is no method for quantitative measurement of wood failure and the value of percent failure has to be assigned visually.

The value of tensile glue shear strength and wood failure are greatly correlated as regards the durability of bond particularly in higher grade plywood. If for a particular test specimen the wood failure is estimated to be greater than 50% and the failing load is less than the specified value, then the value of the breaking load obtained may be discarded for averaging purposes.

Durability Test of Glue Bond

Plywood is used in various service conditions. As a general rule, urea formaldehyde adhesive bonded plywood is used for interior use and those bonded with phenolic resin is used for exterior use. Exterior grade plywood is subjected to alternate heat and cold, high and low humidity or wet and dry conditions. All plywood may be victim of attack by wood destroying organism. The tests described under this caption are intended to indicate durability of the glue bond under the service conditions.

Water Resistance Test

For interior grade plywood (moisture resistance of IS: 303–1989) samples are immersed in warm water at $60^{\circ} \pm 2^{\circ}C$ for 3 hours and then subjected to tensile glue shear test or knife test. Accordingly, test samples have the same specification required for glue shear strength or knife test.

For exterior grade plywood e.g. BWR and BWP grade plywood, samples are kept submerged in a water bath or a pan of boiling water for 8 hours and 72 hours respectively. The total period of boiling may be continuous one or summed up periods of boiling of the test specimens. During the later process, the samples should be kept immersed in cold water for period when the samples are not being boiled. After the total period of boiling is over, the samples are plunged into cold water and tested while still wet. The tests carried out are tensile glue shear strength and knife test as per IS: 1734–1983. Sample specification is also same as per requirement of these two tests.

Conformity to specifications of the results obtained in tensile glue shear tests or knife tests after the samples have been immersed in warm or boiling water for different periods is to be judged differently as per BIS specification. The relevant specifications for MR and BWR grade is IS:303–1989 and for BWP grade plywood is IS:710–1976.

While carrying out water resistance test, a relative study of the percentage of wood failure vs. glue failure after glue shear test or knife must be made. In fact, tests carried out after boiling the plywood is to check for the wood/glue failure as it indicates the durability of the bond. Higher glue failure indicates poor bond.

Cyclic Test

Exterior grade plywood is exposed to natural weathering i.e. alternate heat and cold or dry and wet conditions. It is necessary to know for a product how long it can withstand or survive under exposure in a definite climatic condition. Cyclic tests are accelerated aging tests in which under laboratory conditions, plywood is subjected

to alternate heat and cold or wet and dry conditions and after completion of a number of such cycles, glue lines are observed visually or with a knife if any delamination has taken place.

For cyclic test of different grade of plywood, test specimen of size 125 mm x 125 mm having full thickness of the plywood are taken. Test method and criteria of conformity are given below:

Type of Bond	Test Method	Criteria of conformity
BWP (Boil Water Proof)	Six cycles, each cycle consists of 8 hours boiling in water and drying at 60OC for 16 hours	(i) No separation of plies at the edge surface at the end of six cycles. (ii) On forcible separation of plies with knife wood failure shall be predominant and shall be more than 75% for excellent bond, not less than 50% for pass standard and less than 50% of wood failure means fail.
BWR (Boil Water Resistant)	Three cycles, each cycle consists of 8 hours boiling in water and drying at 60°C for 16 hours.	Criteria of conformity are same as in the case of BWP grade plywood.
MR (Moisture Resistant)	Three cycles, each cycle consists of submerging plywood for 3 hours in water at 60° ± 2°C and drying at 60°C for 16 hours.	Criteria of conformity are same as in the case of BWP grade plywood.

Mycological Test

Usually, a number of extenders are used in the glue mix, many such extenders contain food for micro–organisms. Such an adhesive at the glue line may be attacked by micro–organism and deteriorate the bond strength. This test intends to evaluate the bond strength by subjecting the plywood samples to forcip attack by micro–organisms.

Test samples are similar to that for tensile glue shear strength. A bed of saw dust from sap wood of non-durable timber such as semul or mango is made in an enamelled iron dish. The saw dust should be moistened with a 1.5% sugar solution in water so that the dust remains saturated with moisture but free water would not come out of it if squeezed by hand pressure. The saw dust in the bed is then inoculated with spores of commonly occurring Indian fungi such as Aspergillus. The test specimen is then pressed into the saw dust bed so that their upper surfaces are level with the top of the saw dust layer. The dish is covered with a glass sheet and edges sealed with modelling clay or putty. The dish with its content is then kept at temperature 27° ± 2°C for 3 weeks, after which the samples are removed, washed with water and subjected to tensile shear test. The test results are compared with required value for a particular

grade of plywood.

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नरेश तिवारी फर्नीचर और प्लाई उद्योग की समिति के अध्यक्ष बने

पंजाब सरकार ने हाल ही में कई उद्योग-विशेष समितियों का गठन किया है, जिनमें फर्नीचर और प्लाईवुड क्षेत्र के लिए एक विशेष समिति भी शामिल है। इस नवगठित समिति में प्लाई उद्योग की प्रमुख हस्तियों को शामिल किया गया है। समिति की अध्यक्षता ऑल इंडिया प्लाईवुड मैन्युफैक्चरर्स एसोसिएशन के चेयरमैन और उत्तर भारत के प्लाई उद्योग की जानी-मानी शख्सियत नरेश तिवारी कर रहे हैं, जिन्हें इस समिति में शामिल किया गया है।

इसके अलावा गोपाल बंसल, इंदरजीत सोहल, राजीव सिंघल और बी.एस. सभरवाल को भी समिति में नियुक्त किया गया है। यह घोषणा पंजाब के मंत्री संजीव अरोड़ा द्वारा की गई, जिन्होंने सरकार की इस पहल को रेखांकित किया कि अनुभवी उद्योग प्रतिनिधियों को नीतिगत निर्णयों में शामिल कर सेक्टोरल पॉलिसी को और सशक्त बनाया जाए।

रायपुर, छत्तीसगढ़

लकड़ी आधारित उद्योग के विकास पर प्रमुख बैठक

छत्तीसगढ़ में लकड़ी आधारित उद्योगों की संभावनाओं का दोहन करने के उद्देश्य से एक संस्थान-उद्योग-वन विभाग संवादात्मक बैठक का आयोजन किया जा रहा है। इस बैठक का आयोजन आईसीएफआरई-वुड साइंस एंड टेक्नोलॉजी संस्थान (भारतीय वानिकी अनुसंधान एवं शिक्षा परिषद), बेंगलुरु द्वारा किया जा रहा है, जो कि भारत सरकार के पर्यावरण, वन और जलवायु परिवर्तन मंत्रालय के अंतर्गत एक स्वायत्त निकाय है।

यह कार्यक्रम 29 जुलाई 2025 को सुबह 11 बजे से दोपहर 2 बजे तक होटल बैबिलॉन इंटरनेशनल, रायपुर में निर्धारित है। इसका समर्थन छत्तीसगढ़ सरकार, वन एवं जलवायु परिवर्तन विभाग, तथा छत्तीसगढ़ राज्य औद्योगिक विकास निगम (CSIDC) द्वारा किया जा रहा है।

इस बैठक का उद्देश्य संस्थानों, उद्योगों और वन विभागों के बीच सहयोग को सुदृढ़ कर सतत औद्योगिक विकास को बढ़ावा देना है।

प्लाईवुड के लिए QCOs लागू होने के बाद

नेपाल प्लाईवुड द्वारा BIS लाइसेंस के दुरुपयोग की सम्भावना

भारत में प्लाईवुड और लकड़ी आधारित पैनलों के लिए नए गुणवत्ता नियंत्रण आदेश (QCOs) के लागू होने के बाद के महीनों में नेपाल के साथ व्यापार में असामान्य रुझानों ने देश की घरेलू उद्योग में चिंता की लहर पैदा कर दी है। नेपाल से प्लाईवुड आयात में अचानक आई बढ़ोतरी, जबकि निर्यातकों की संख्या में तेज गिरावट आई है, ने BIS लाइसेंसों के संभावित दुरुपयोग और नियामकीय प्रक्रियाओं को दरकिनार करने की आशंका को जन्म दिया है। इसके चलते इस पूरे मामले की औपचारिक जांच की मांग की जा रही है।

फरवरी 2025 से भारत सरकार ने यह अनिवार्य कर दिया कि देश में आयात किए जाने वाले सभी प्लाईवुड, लकड़ी के फ्लश डोर शटर और लकड़ी आधारित बोर्ड नए लागू किए गए गुणवत्ता नियंत्रण आदेशों (QCOs) का पालन करें। भारतीय मानक ब्यूरो (BIS) के माध्यम से लागू किए गए ये नियम उत्पाद की गुणवत्ता और सार्वजनिक सुरक्षा सुनिश्चित करने के साथ-साथ घरेलू निर्माताओं के लिए समान प्रतिस्पर्धा का वातावरण प्रदान करने के उद्देश्य से लाए गए हैं।

नियमों के अनुसार केवल वही निर्माता जो BIS (भारतीय मानक ब्यूरो) से प्रमाणित हैं, भारत को इन उत्पादों का निर्यात कर सकते हैं। नए नियमों के लागू होने के साथ ही नेपाल जो पहले भारत के प्लाईवुड आयात में लगभग 21% का योगदान देता था से अपेक्षा की गई थी कि वह अपने निर्यात प्रथाओं को इन मानकों के अनुरूप बनाएगा। पहले जहां नेपाल की 54 कंपनियाँ इस व्यापार में शामिल थीं, उनमें से केवल नौ कंपनियाँ ही समय पर BIS लाइसेंस प्राप्त कर सकीं। प्रमाणित निर्यातकों की यह कम संख्या आयात की मात्रा में समान रूप से गिरावट लाने की उम्मीद के अनुरूप थी।

हालांकि, आयात आंकड़े एक विरोधाभासी तस्वीर पेश करते हैं।

नेपाल का प्लाईवुड ऐसे निर्यातकों से आया जिनके पास BIS प्रमाणन नहीं था। यह एक गंभीर नियामक चूक की ओर इशारा करता है: जब उत्पाद प्रमाणित नहीं थे, तो उन्हें भारतीय बंदरगाहों पर कैसे क्लियर किया गया।

इस पूरे मामले पर संदेह को और भी गहरा करने वाला पहलू यह है कि कई BIS प्रमाणित निर्यातकों द्वारा दर्ज की गई व्यापार वृद्धि का पैमाना असामान्य रूप से बड़ा है। आंकड़ों से पता चलता है कि कुछ निर्माता, जिनका जनवरी से अप्रैल 2025 तक बहुत सीमित व्यापार था, उन्होंने मई में अचानक अत्यधिक वृद्धि दर्ज की।

उदाहरण के लिए, एक निर्माता जिसने जनवरी से अप्रैल के बीच भारत को जो प्लाईवुड निर्यात किया था, उसमे मई में अचानक वृद्धि देखी गई। मात्रा के हिसाब से यह एक ही महीने में लाखों वर्ग मीटर प्लाईवुड के निर्यात के बराबर था — कुछ मामलों में यह उनके पिछले औसत मासिक निर्यात से चौदह गुना अधिक था।

कंटेनरों के संदर्भ में भी यह असमानता उतनी ही चौंकाने वाली थी। एक निर्यातक, जिसने मार्च में केवल 9 कंटेनरों में प्लाईवुड भेजा था, ने मई में 329 कंटेनर भेजे। दो अन्य निर्यातकों का भी ऐसा ही रुझान देखने को मिला — उन्होंने दो महीनों के भीतर दो अंकों की छोटी संख्या से बढ़कर 100 से अधिक कंटेनर भेज दिए।

मुख्य चिंता यह है कि BIS प्रमाणित निर्यात मात्रा में यह चौंकाने वाली बढ़ोतरी कहीं गैर-अनुपालक (non-compliant) माल की एंट्री को छिपाने का जरिया तो नहीं है। आशंका यह जताई जा रही है कि बिना प्रमाणन वाले निर्माता, प्रमाणित कंपनियों के BIS लाइसेंस का इस्तेमाल कर अपने उत्पाद उनके माध्यम से भारत भेज रहे हैं। यदि यह सच है, तो यह भारत के नियामकीय ढांचे का गंभीर उल्लंघन होगा — जो QCOs के मूल उद्देश्य को ही विफल करता है।

उद्योग जगत के प्रतिनिधियों का कहना है कि इस प्रकार की गतिविधियाँ न केवल प्रक्रियात्मक उल्लंघन हैं, बल्कि इससे प्रतिस्पर्धा का असमान माहौल भी बनता है। अनुपालन करने वाले घरेलू उत्पादकों को कड़े लागत और गुणवत्ता मानकों के तहत काम करना पड़ता है, जबकि कथित ''बैकडोर'' समझौते के तहत काम करने वाले उनके प्रतिस्पर्धी बाजार में मूल्य लाभ प्राप्त कर रहे हैं।

महत्वपूर्ण बात यह है कि यह स्थिति न केवल उपभोक्ताओं के बीच नियामक प्रवर्तन पर विश्वास को कमजोर करती है, बल्कि उन अंतिम उपभोक्ताओं के लिए गुणवत्ता संबंधी जोखिम भी उत्पन्न कर सकती है जो यह मानकर चलते हैं कि सभी आयातित उत्पाद भारतीय मानकों का पालन करते हैं।

आंकड़ों से यह भी स्पष्ट होता है कि मार्च महीने में नेपाल से भारत को BIS लाइसेंस के बिना प्लाईवुड निर्यात करने वाले निर्माताओं की संख्या मामूली नहीं थी। बिना प्रमाणन वाले 30 निर्यातकों की एक सूची सामने आई है, जिन्होंने उस महीने के अधिकांश आयात में योगदान दिया। बाद में जांच के बाद अप्रैल और मई में इनकी खेपें बंद हो गईं, लेकिन तब तक फर्जीवाड़े का यह पैटर्न सामने आ चुका था।

विश्लेषण से यह संकेत मिलता है कि केवल प्रमाणित और वास्तविक उत्पादों को ही प्रवेश की अनुमति सुनिश्चित करने के लिए और अधिक कठोर प्रवर्तन तंत्र की आवश्यकता है। यदि मजबूत निगरानी और ट्रेसबिलिटी (ट्रेस करके पहचानने की व्यवस्था) नहीं होती, तो लाइसेंसधारी निर्यातकों का इस्तेमाल गैर-लाइसेंसधारी कंपनियाँ एक माध्यम के रूप में कर सकती हैं — एक ऐसी खामी जो पूरे BIS ढांचे को निष्प्रभावी बना सकती है।

घरेलू उद्योग ने सम्बंधित एजेंसीओ (Indian authorities) से तत्काल इस मामले में औपचारिक जांच शुरू करने की मांग की है। अपेक्षा की जा रही है कि गहराई से की जाने वाली जाँच से यह स्पष्ट हो पाए कि क्या लाइसेंस प्राप्त नेपाली निर्यातकर्ता जानबूझकर गैर-प्रमाणित उत्पादों की एंट्री में सहायता कर रहे थे; और अगर हाँ, तो उनकी प्रतिक्रिया में क्या दंडात्मक कार्रवाई की जानी चाहिए। सुझावों में दोषियों के BIS लाइसेंस रद्द करने और बंदरगाह पर प्रवर्तन के दौरान अनुपालन सत्यापन के लिए कस्टम्स प्रोटोकॉल को मजबूत करने के उपाय शामिल हैं।

यह मामला केवल व्यापार आँकड़ों या आयात दस्तावेजों के प्रश्न तक सीमित नहीं है। यह सीधे भारत की विनिर्माण मानक नीति, उपभोक्ता संरक्षण, और व्यापार समानता की मूल नीति पर प्रभाव डालता है। यदि गैर-अनुपालक माल औपचारिक चैनलों के माध्यम से प्रवेश पा रहा है, तो इसके प्रभाव प्लाईवुड क्षेत्र से कहीं आगे तक फैल सकते हैं।

ऐसे समय में जब भारतीय सरकार ''Make in India'' को बढ़ावा दे रही है और उच्च-गुणवत्ता

वाले उत्पादन प्रथाओं को प्रोत्साहित कर रही है, कार्यान्वयन में पाई जाने वाली खामियों से वैश्विक स्तर पर उसकी प्रणालियों में विश्वास कमजोर हो सकता है। इसके अतिरिक्त, इस तरह की विसंगतियाँ BIS प्रमाणपत्रों की विश्वसनीयता को भी कमजोर करने का जोखिम पैदा करती हैं—जो खरीदारों को गुणवत्ता और सुरक्षा का आश्वासन देने के लिए डिज़ाइन किए गए हैं।

चूंकि प्लाईवुड की मांग रियल एस्टेट, इन्फ्रास्ट्रक्चर और इंटीरियर डिज़ाइन जैसे क्षेत्रों में लगातार मजबूत बनी हुई है, ऐसे में गुणवत्ता अनुपालन सुनिश्चित करना अत्यंत महत्वपूर्ण हो जाता है। विदेशी व्यापार आवश्यक है और नेपाल भारत का निकट व्यापारिक साझेदार भी है, लेकिन सीमाओं के पार भी नियामकीय पारदर्शिता बनाए रखना अनिवार्य है।

जांच की मांग आयात का विरोध नहीं, बल्कि निष्पक्षता और समान नियमों के पालन की पुष्टि के रूप में सामने आई है। वर्तमान में नेपाल में केवल नौ निर्माता ऐसे हैं जिनके पास वैध BIS लाइसेंस हैं, ऐसे में जो आयात मात्रा रिपोर्ट हो रही है, वह स्पष्टीकरण की माँग करती है।

अधिकारियों को विस्तृत व्यापार डेटा, आयात मात्रा के रिकॉर्ड और कंटेनर ट्रैकिंग की जानकारी सौंपी गई है ताकि आगे की जांच को समर्थन मिल सके। अपेक्षा की जा रही है कि उचित ऑडिटिंग और मैदानी जांच के ज़रिए प्रमाणपत्रों के किसी भी दुरुपयोग की पहचान की जाएगी और समयबद्ध तरीके से कार्रवाई की जाएगी।

एक नियम-आधारित व्यापार प्रणाली में जवाबदेही से कोई समझौता नहीं किया जा सकता। अगर भारत का गुणवत्ता नियंत्रण तंत्र अपने उद्देश्य के अनुरूप काम करना है, तो उसे न केवल कागजों पर, बल्कि व्यवहार में भी पूरी तरह लागू किया जाना चाहिए। अन्यथा, गुणवत्ता के प्रहरी पीछे छूट सकते हैं और उपभोक्ता एक बार फिर असुरक्षित स्थिति में रह जाएंगे।

QCO लागू होने के बाद व्यापारिक परिदृश्य में जो स्थिति उभरी है, उसमें एक बात स्पष्ट है: सतर्कता को नीति की महत्वाकांक्षा के बराबर होना चाहिए। तभी भारत एक आत्मनिर्भर, गुणवत्ता-प्रधान औद्योगिक पारिस्थितिकी तंत्र का निर्माण कर सकेगा।

चूंकि प्लाईवुड की मांग रियल एस्टेट, इन्फ्रास्ट्रक्चर और इंटीरियर डिज़ाइन जैसे क्षेत्रों में लगातार मजबूत बनी हुई है, ऐसे में गुणवत्ता अनुपालन सुनिश्चित करना अत्यंत महत्वपूर्ण हो जाता है

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डेन्सिफ़ाइड प्लाईवुड के दामों में 5% की वृद्धि

लकड़ी और रसायनों की कीमतों में अभूतपूर्व वृद्धि के चलते, ऑल इंडिया प्लाईवुड मैन्युफैक्चरर्स एसोसिएशन (AIPMA) ने 12 मिमी डेंसिफाइड शटरिंग प्लाईवुड की कीमत में ₹2 प्रति वर्ग फुट की वृद्धि की घोषणा की है। यह निर्णय 2 जुलाई 2025 को यमुनानगर स्थित सिटी मॉल में श्री देवेंद्र चावला की अध्यक्षता में आयोजित बैठक में सर्वसम्मति से लिया गया।

संशोधित दरें तत्काल प्रभाव से लागू होंगी। एसोसिएशन के सदस्यों ने यह भी तय किया है कि वे ₹2 से कम की बढ़ोतरी पर कोई नया ऑर्डर स्वीकार नहीं करेंगे, ताकि बढ़ती इनपुट लागतों के बीच बाजार संचालन को स्थिर किया जा सके।

यह भी निर्णय लिया गया कि यदि अगले 15 दिनों में लकड़ी की कीमतों में और वृद्धि होती है या वे स्थिर बनी रहती हैं, तो एसोसिएशन माह के भीतर पुनः बैठक करेगी और स्थिति का पुनर्मूल्यांकन करेगी। AIPMA नेतृत्व ने सभी व्यापार भागीदारों से इस निर्णय का समर्थन करने की अपील की है ताकि उद्योग को और अधिक अस्थिरता से बचाया जा सके।

इस बैठक में प्रमुख पदाधिकारियों ने भाग लिया, जिनमें अध्यक्ष श्री देवेंद्र चावला, चेयरमैन श्री नरेश तिवारी, महासचिव श्री अरुण मंगिया और कोषाध्यक्ष श्री नरेंद्र बंसल शामिल थे।

दीपक नाईट्रेट

फिनोल निर्माण सुविधाओं के बड़े विस्तार की घोषणा

घरेलू रासायनिक निर्माण को सुदृढ़ करने की दिशा में एक महत्वपूर्ण कदम उठाते हुए, दीपक नाईट्रेट लिमिटेड ने फिनोल उत्पादन क्षमता के विस्तार की योजना की घोषणा की है, जिसे एक बड़े ग्रीनफील्ड प्रोजेक्ट के माध्यम से अंजाम दिया जाएगा। यह विस्तार इसकी सहायक कंपनी दीपक केम टेक लिमिटेड (DCTL) द्वारा किया जाएगा।

कंपनी के अनुसार, इस परियोजना में लगभग ₹3,500 करोड़ का निवेश अनुमानित है, जिसे विस्तृत इंजीनियरिंग चरण के दौरान अंतिम रूप दिया जाएगा। इस निवेश को ऋण और इक्विटी के संतुलित मिश्रण के माध्यम से वित्तपोषित किया जाएगा। अधिकारियों ने बताया कि यह नई क्षमता अंततः पॉलीकार्बोनेट रेज़िन्स (PC) के उत्पादन में एकीकृत की जाएगी, जिससे कंपनी की भारत में सबसे

एकीकृत उत्पादकों में शामिल होने की रणनीतिक योजना को बल मिलेगा।

विस्तार रणनीति के तहत, DCTL ने reportedly जर्मनी से एक पॉलीकार्बोनेट निर्माण संयंत्र को खरीदने और भारत में स्थानांतरित करने के लिए समझौते किए हैं। इससे दीपक नाईट्रेट उन कुछ भारतीय कंपनियों में शामिल हो जाएगी, जिनके पास फिनोल और एसीटोन से लेकर पॉलीकार्बोनेट रेज़िन तक की पूरी तरह एकीकृत क्षमताएं होंगी।

ये नई क्षमताएं दीपक फिनोलिक्स (कंपनी की पूर्ण स्वामित्व वाली सहायक इकाई) द्वारा वर्तमान में संचालित मौजूदा क्षमता के अतिरिक्त होंगी।

कंपनी के चेयरमैन और मैनेजिंग डायरेक्टर श्री दीपक सी. मेहता ने कहा कि यह विस्तार समूह की भारत में एक मजबूत, आत्मनिर्भर रासायनिक इकोसिस्टम बनाने की प्रतिबद्धता को दर्शाता है, जो आत्मनिर्भर भारत और विकसित भारत की परिकल्पना में महत्वपूर्ण योगदान देगा।

साकेत माइका

उदयपुर में डीलर मीट का आयोजन

21 जून 2025 को उदयपुर में साकेत माइका द्वारा आयोजित वार्षिक डीलर मीट के अवसर पर सौहार्द्र और उत्सव का जीवंत माहौल देखने को मिला। यह भव्य आयोजन सुरम्य रिज़ॉर्ट डिवाइन इन में हुआ, जिसमें राजस्थान भर से आए 45 से अधिक डीलर्स और चैनल पार्टनर्स ने भाग लिया। इस आयोजन ने ब्रांड की राज्य में अपनी उपस्थिति को विस्तार देने और व्यापारिक संबंधों को मजबूत करने की प्रतिबद्धता को उजागर किया।

साकेत माइका, जो डेकोरेटिव लैमिनेट्स क्षेत्र में तेजी से अपनी पहचान बना रहा है, को अमुल्या माइका की सशक्त विरासत का समर्थन प्राप्त है। दोनों ब्रांड अमुल्यमाइका इंडस्ट्रीज प्रा. लि. के अंतर्गत संचालित होते हैं, जो गुणवत्ता और नवाचार के लिए प्रसिद्ध कंपनी है।

यह संध्या साकेत माइका के उदयपुर डिस्ट्रीब्यूटर, ऋषि लैमिनेट्स के सहयोग से आयोजित की गई थी। इस अवसर पर उत्कृष्ट साझेदारों को "अचीवर अवॉर्ड्स" से सम्मानित किया गया। इस जश्न में कंपनी के नेतृत्व दल से डिप्टी रीजनल मैनेजर मुकेश शर्मा, डिप्टी ब्रांच मैनेजर मनोज नागरका, टीएसएम तरविंदर सिंह और आईएसआर हर्षित जोशी उपस्थित थे। इनके साथ डिस्ट्रीब्यूटर प्रतिनिधि वीरेन्द्र

सांघवी और अमित सांघवी ने भी भाग लिया।

कार्यक्रम की शुरुआत परंपरागत दीप प्रज्वलन, गणेश वंदना और राष्ट्रगान के साथ हुई। इसके बाद मुकेश शर्मा ने अपने मुख्य वक्तव्य में नई प्रोडक्ट इनोवेशन की जानकारी दी, जिसमें पेस्टल-टोन टेक्सचर्स जैसे एब्सट्रैक्ट ग्रिल, मोरक्कन मेश और क्रॉस्ड स्टोन शामिल हैं। उन्होंने ब्रांड के प्रीमियम कलेक्शनों जैसे मेटैलिक डिजिटल लैमिनेट्स और 1.25 मिमी बेंडेबल पीवीसी लैमिनेट्स को भी प्रमुखता से प्रस्तुत किया।

उपस्थित मेहमानों को साकेत माइका की हालिया उपलब्धियों के बारे में भी बताया गया, जिसमें सामाजिक उत्तरदायित्व (CSR) गतिविधियां और उत्कृष्ट निर्माण के लिए मिला CII नेशनल MSME शाइनिंग अवार्ड 2025 शामिल हैं।

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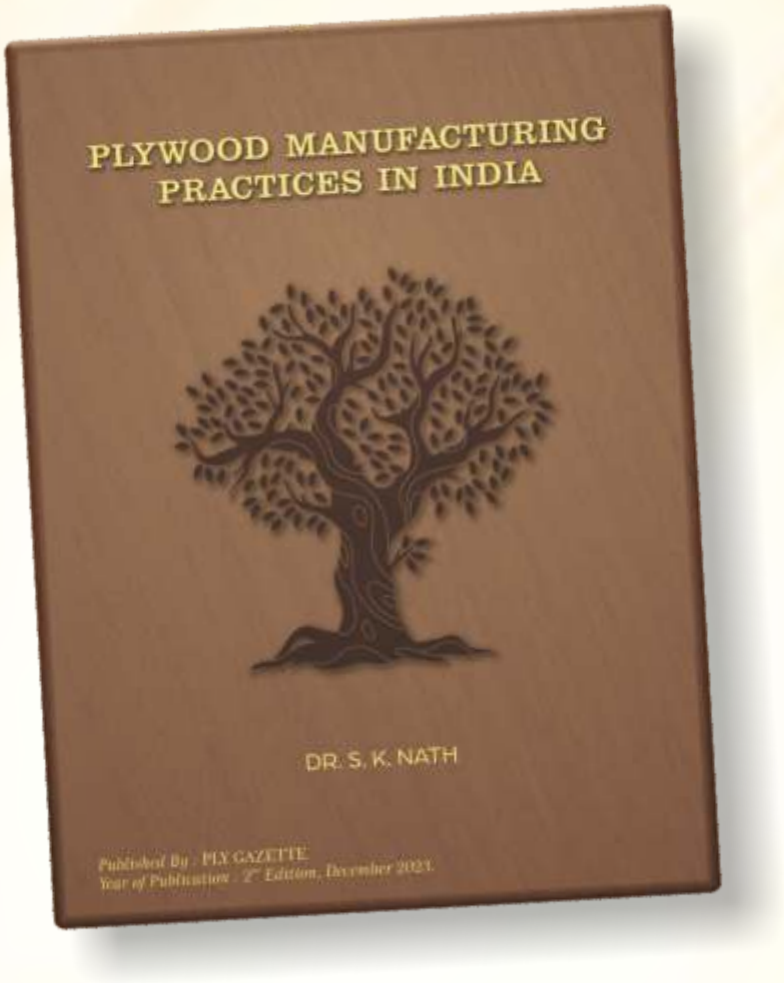

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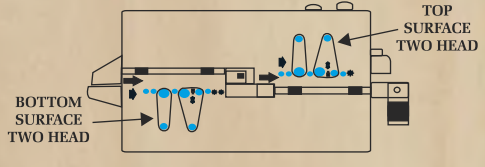

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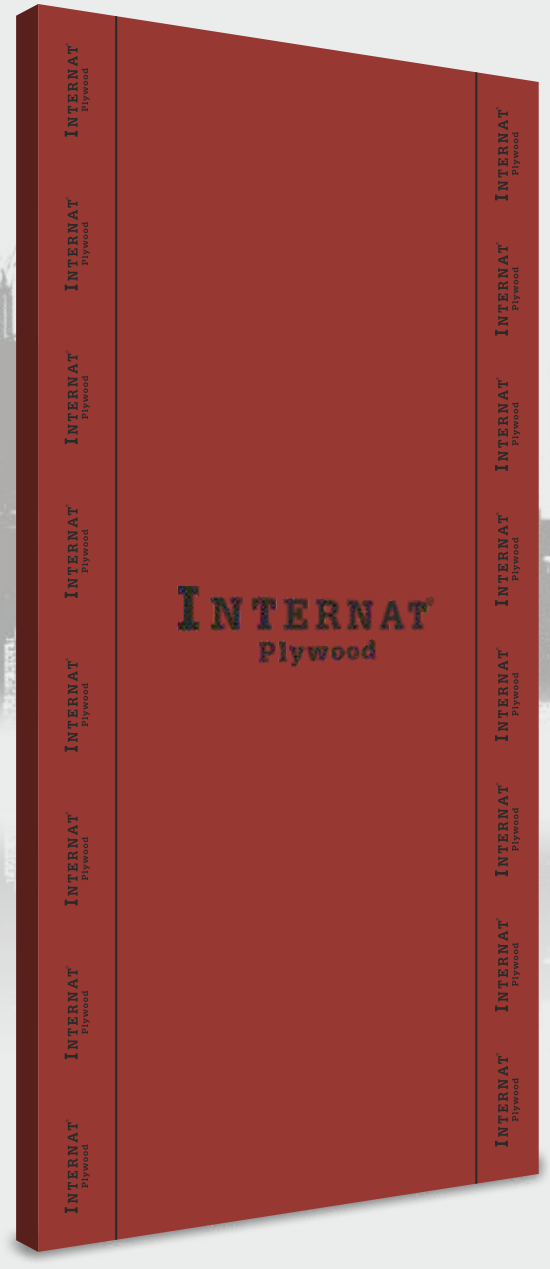

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