

# Engineered Wood Panels - lines & nail marking patterns

## Marking with DOD Valve Technology

### Market

#### **What is being marked?**

Engineered wood panels, such as OSB (oriented strand board) and plywood.

### Application

#### **Why is it being marked?**

The nail lines aid the carpenters, or installers to easily locate where nails are to be placed. Lines are printed on 16" and 24" centers, a dimension which coincides with wall studs and roof rafters.

#### **How is it marked?**

A custom solution has been developed by Matthews Integrated Solutions Group (ISG). Single valve printheads are mounted on a custom mounting bridge, with the heads positioned as required, on the correct center to center. A custom controls enclosure provides a touch screen interface, allowing the customer the ability to turn on and off valves with the touch of a button. In many applications raising and lowering of the mounting bridge is automated, to allow for multiple thickness of boards. The SCP901 black ink is typically recommended, with excellent UV stability. Large capacity ink systems are included for ink and cleaner supply.



#### **When is it marked?**

Boards are printed after coming out of the press, on cut panels 4' X 8' size, or prior to being cut when two boards are side by side, up to 8' wide and lengths as long as 72 feet. Line speeds are average 200-300 fpm. Temperature at time of printing may be 225-250°F (107-121°C); care should be taken to confirm temperature.



### Matthews Marking Products

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### Helpful Hints

Competition for this application is frequently an atomizing spray nozzle, which can be messy and wastes ink. The shut off of this type of nozzle is not always responsive, which causes overspray at the end of the board. The Matthews single valve printheads respond quickly, turning on and off immediately as programmed. We "control" every drop of ink!

Matthews has worked closely with the engineered wood industry, and the gypsum industry, to help develop nail marking "patterns" or symbols, in place of solid nail lines. The symbol is applied in a strategic location, on centers, saving ink, and allowing nailing to be more accurately positioned, or for specific board installation requirement.

Line applications are everywhere. Insertion marks, cut and tear lines, a white stripe around the OD of a pipe - and more.

Standard valve printheads may be the better recommendation for a specific line marking application than the single valve head. Check with ISG for the best recommendation.