



WOODEN HAUS SUPPLY

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*Smart by Nature*

# Utilization of Small Diameter Timber

Forest Stewardship through the  
manufacture of Solid Timber products



Patrick Clark  
**Wooden Haus Supply**

406 212 0388



# European Timber Products:

## Manufacturing, utilization and opportunities in Montana







🌿 **Wooden Haus Supply:** Specialist for innovative building products made from wood



# Agenda

- 🌿 **Wooden Haus Supply** European/USA Partner firms
- 🌿 Hasslacher Noritec Holzindustrie - Austria
- 🌿 Rema Holzindustrie- Austria
- 🌿 Steico Wood Fiber - Germany/Poland
- 🌿 KLH CLT - Austria/USA
- 🌿 Global Wholesale Supply - USA



# Agenda

- 🌿 **Wooden Haus Supply**
- 🌿 **Timber Product Mix for a Full System Built Timber Solution**
- 🌿 Cross Laminated Timber ( CLT)
- 🌿 Duo/Trio Lam
- 🌿 Glulam Timber
- 🌿 KVH
- 🌿 Brettstapel/Solid Timber Ceiling and Roof
- 🌿 Dreischichtplatten/ 3 Ply Panel
- 🌿 Wood Fiber Insulation



# STEICO Munich (GER)



## STEICO Headquarters Feldkirchen / Munich

- ✔ Worldwide sales management and corporate control
- ✔ Unique construction system for innovative timber constructions
- ✔ Broadest assortment of the whole industry
- ✔ Leader in technical development and client services
- ✔ Close cooperation with universities. Sponsor of international timber frame construction developments

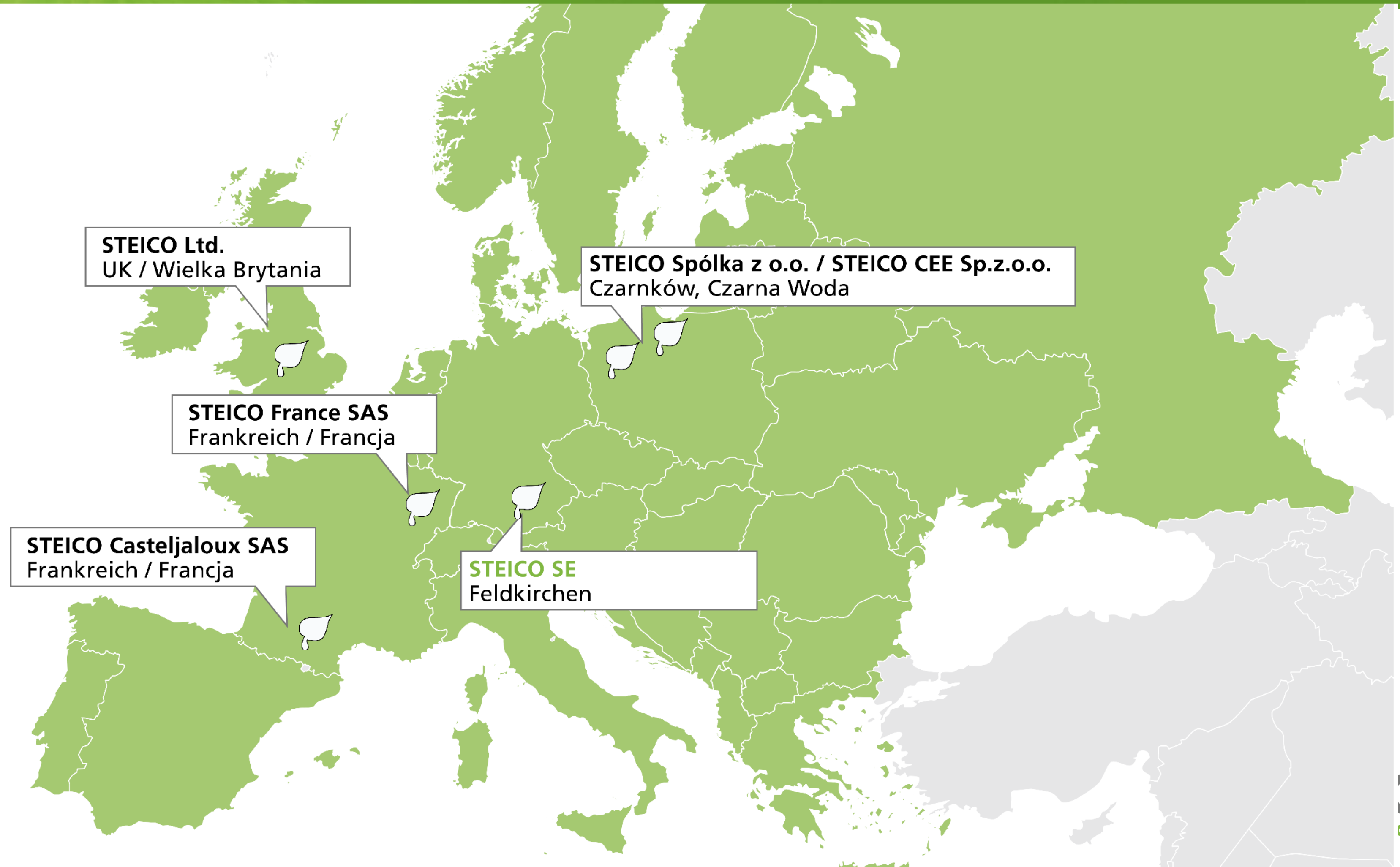


# Steico

Employees:	1,300
Headquarter:	Feldkirchen near Munich
Locations:	6 including 3 production sites
Annual turnover:	About USD \$250 Million (2016); \$226 Million (2015)
Sales:	Worldwide
Logistic:	Mixed truck and container loads, insulating and constructional materials
Investments:	<p>\$60 Million for a new STEICO <i>LVL</i> production plant (increase of capacity in planning process)</p> <p>\$12 Million for another production plant for wood fiber board of wet process</p>



# Locations





# Czarnków (PL)

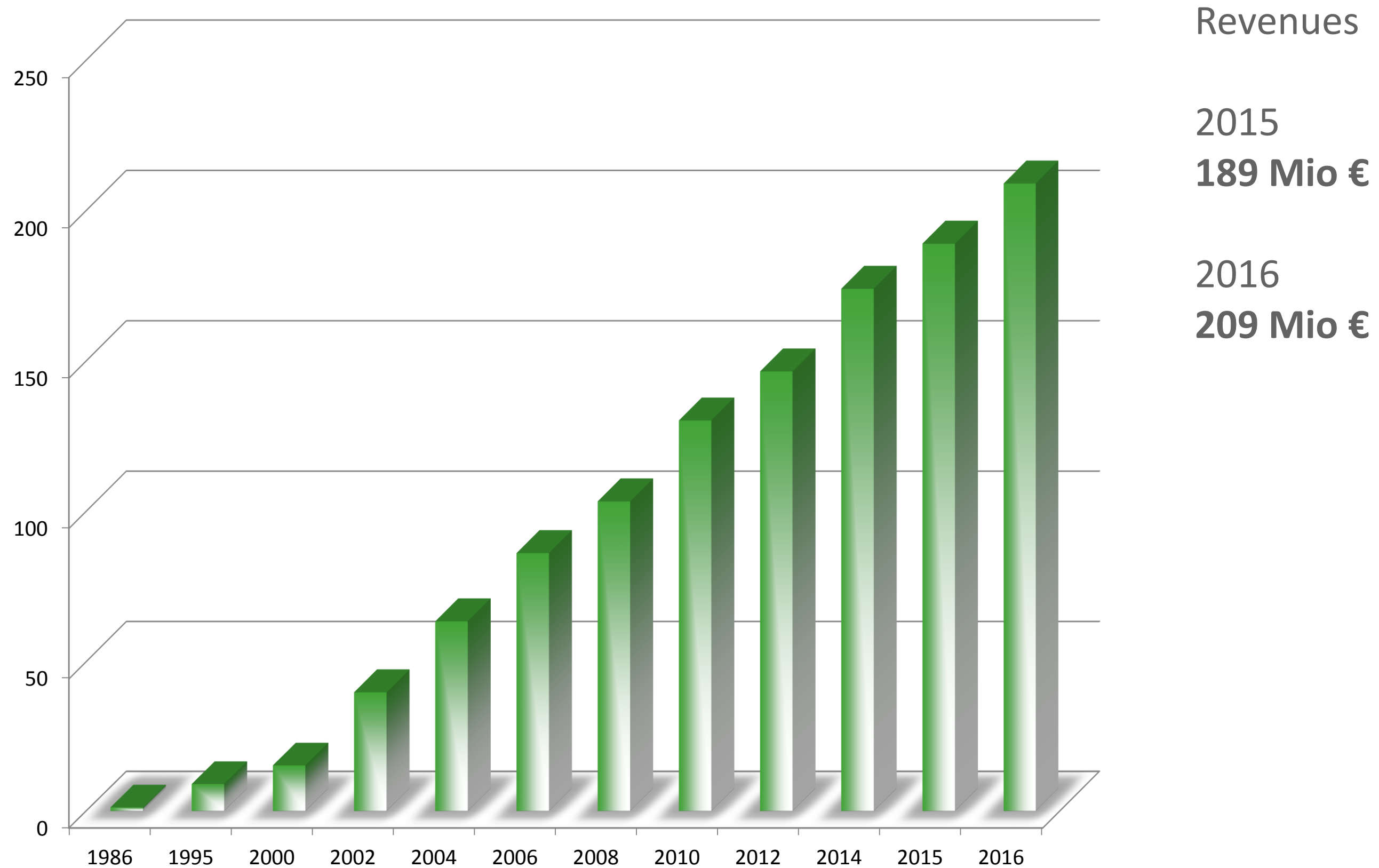


## World's largest production site for ecological insulation

- 🌱 Location: ca. 60 km (37.2 miles) from Poznan
- 🌱 Size: ca. 50 ha. (123.5 acres)
- 🌱 8 production lines for wood fibre insulation with more than 2 million m<sup>3</sup> (70.6 million cubic ft) capacity p.a.
- 🌱 Europe's largest line for I-joist with 25 mio. m (82 million linear feet) capacity
- 🌱 Around 730 Employees
- 🌱 350 Trucks per week, 120 trucks on peak days
- 🌱 Main production site for insulation material and beams

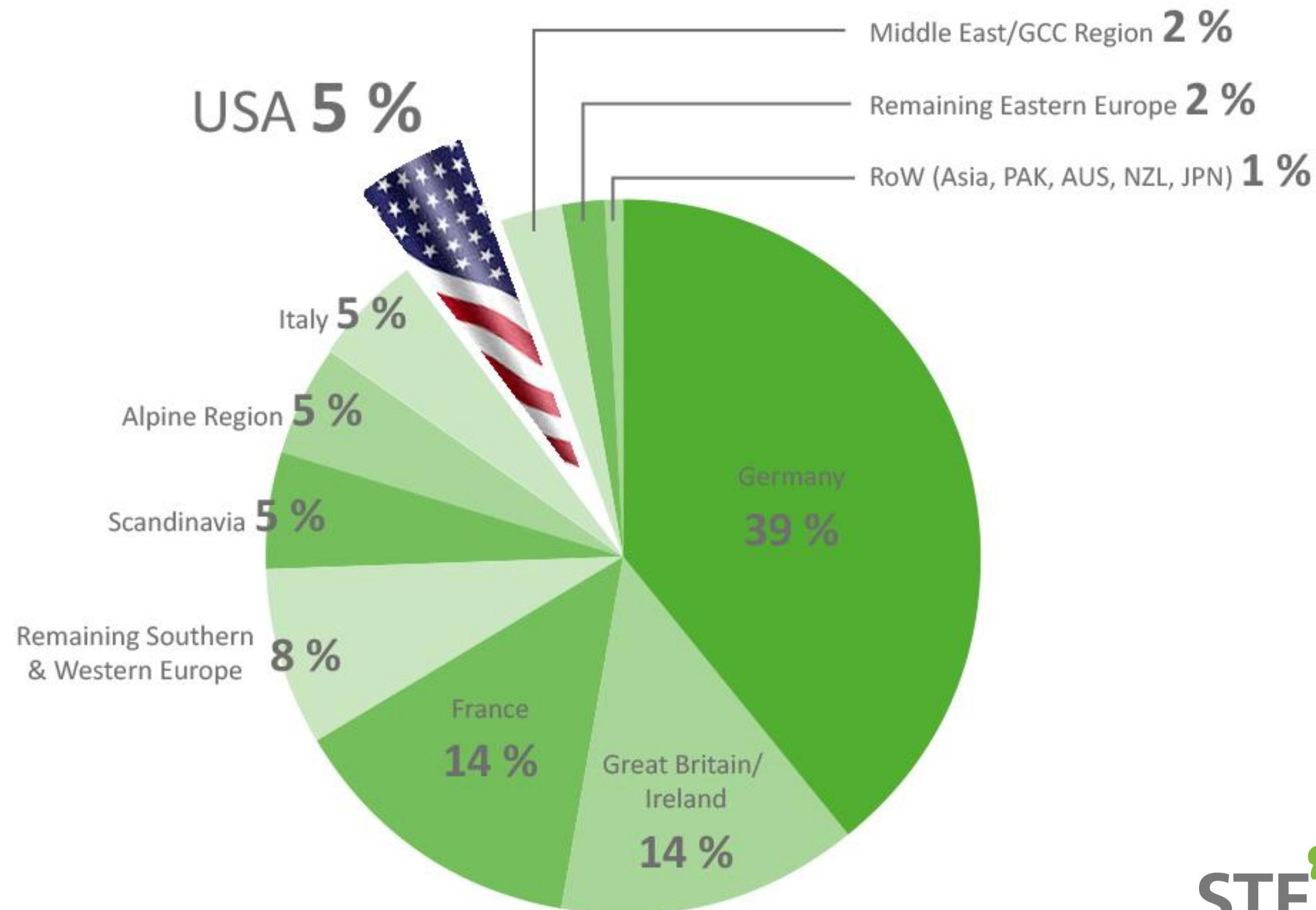


# STEICO SE – Development of Turnover in Mio €



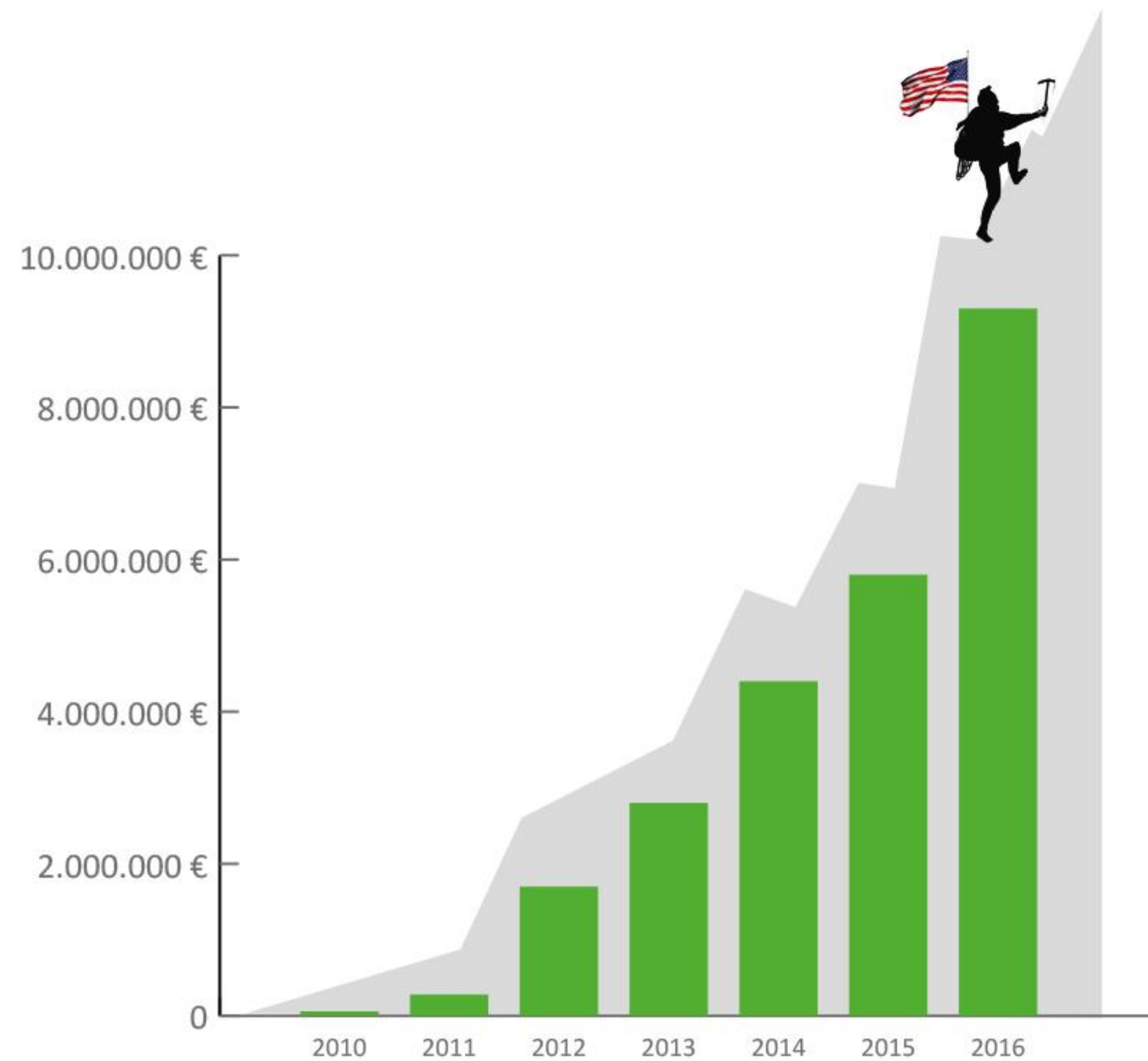


# STEICO SE – Breakdown of Sales by Markets in 2016



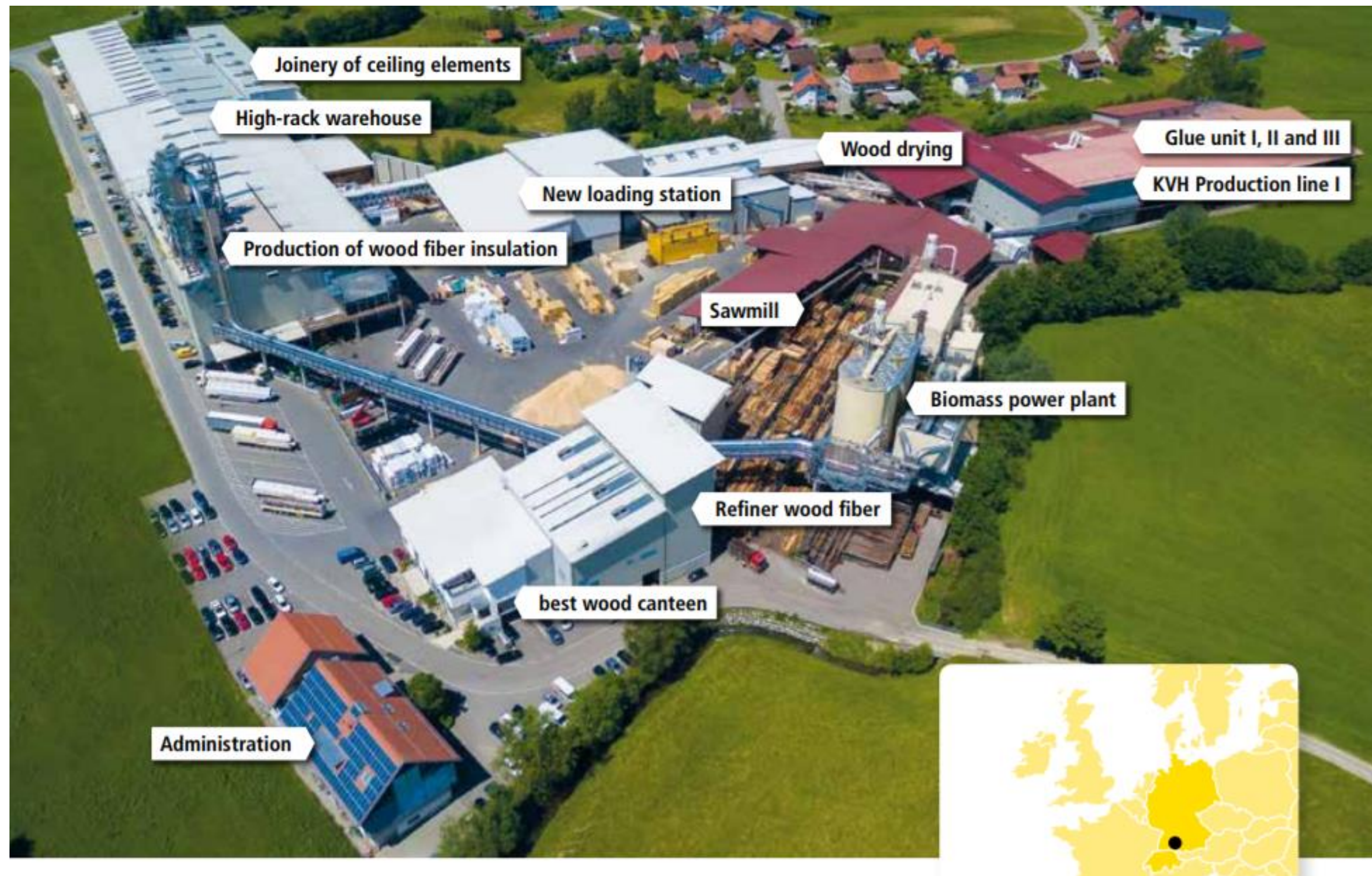


# STEICO SE – Development of Turnover (USA)





# Integrated Micro Wood Fiber Plant



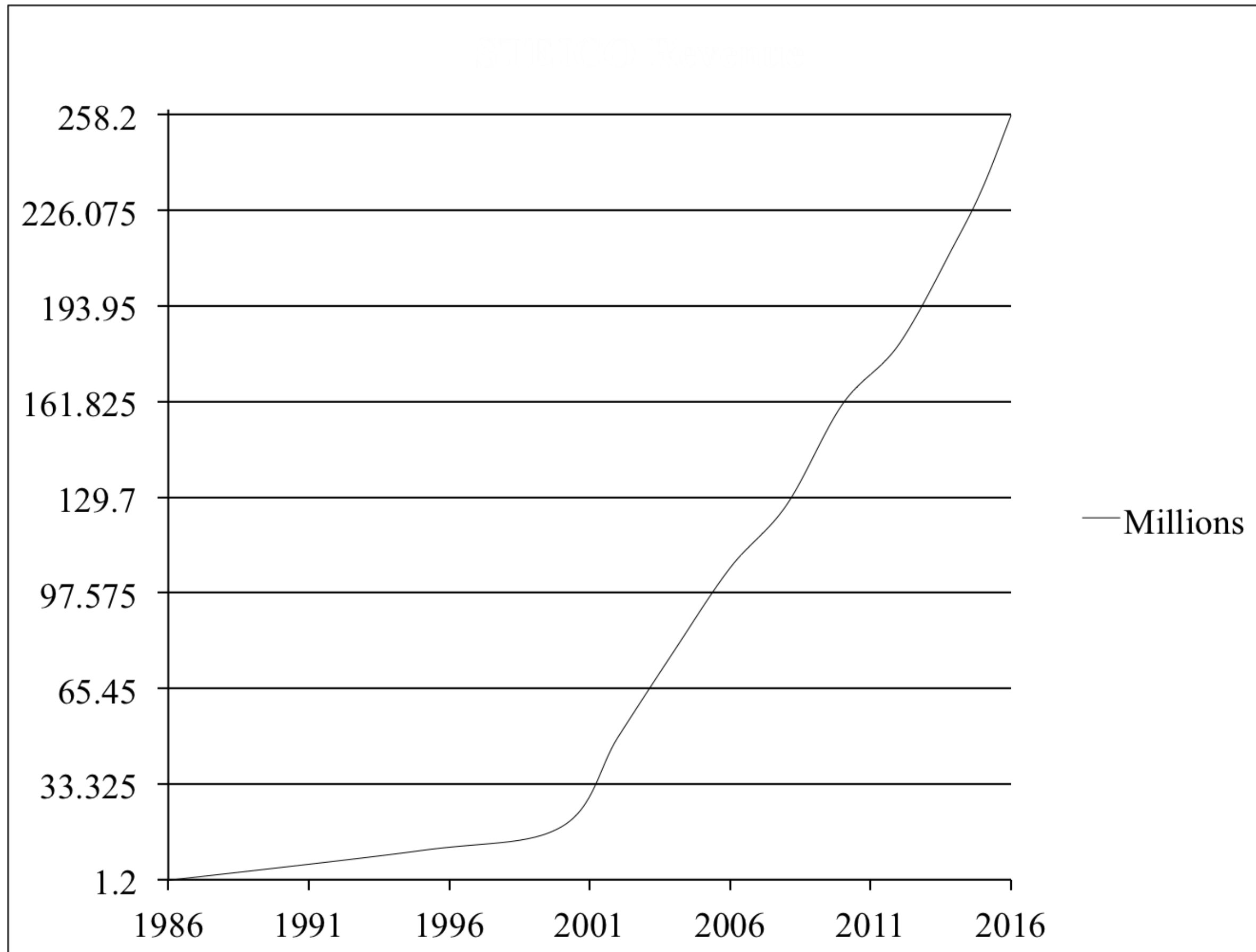


# Wood Fibre Insulation History

- 🌿 Wood Fibre Insulation has been in Europe and the U.S. for over 70 years
- 🌿 U.S. products were once used for structural sheathing prior to OSB
- 🌿 U.S. products are now used for cover board in commercial roofing, sound board and some sheathing.
- 🌿 There were once around 20 fiberboard plants in the U.S. & Canada – now there only 4.
- 🌿 European use of fiberboard/ wood fibre insulation is surging with the growth curve of energy efficient and healthy buildings.
- 🌿 Renovation market is also significant in Europe as families keep houses for generations.
- 🌿 The differences between U.S. and European products is significant.
- 🌿 The target markets for European style wood fibre insulation are: Passive/ High Performance Homes, Timber Frame Construction, CLT Construction.

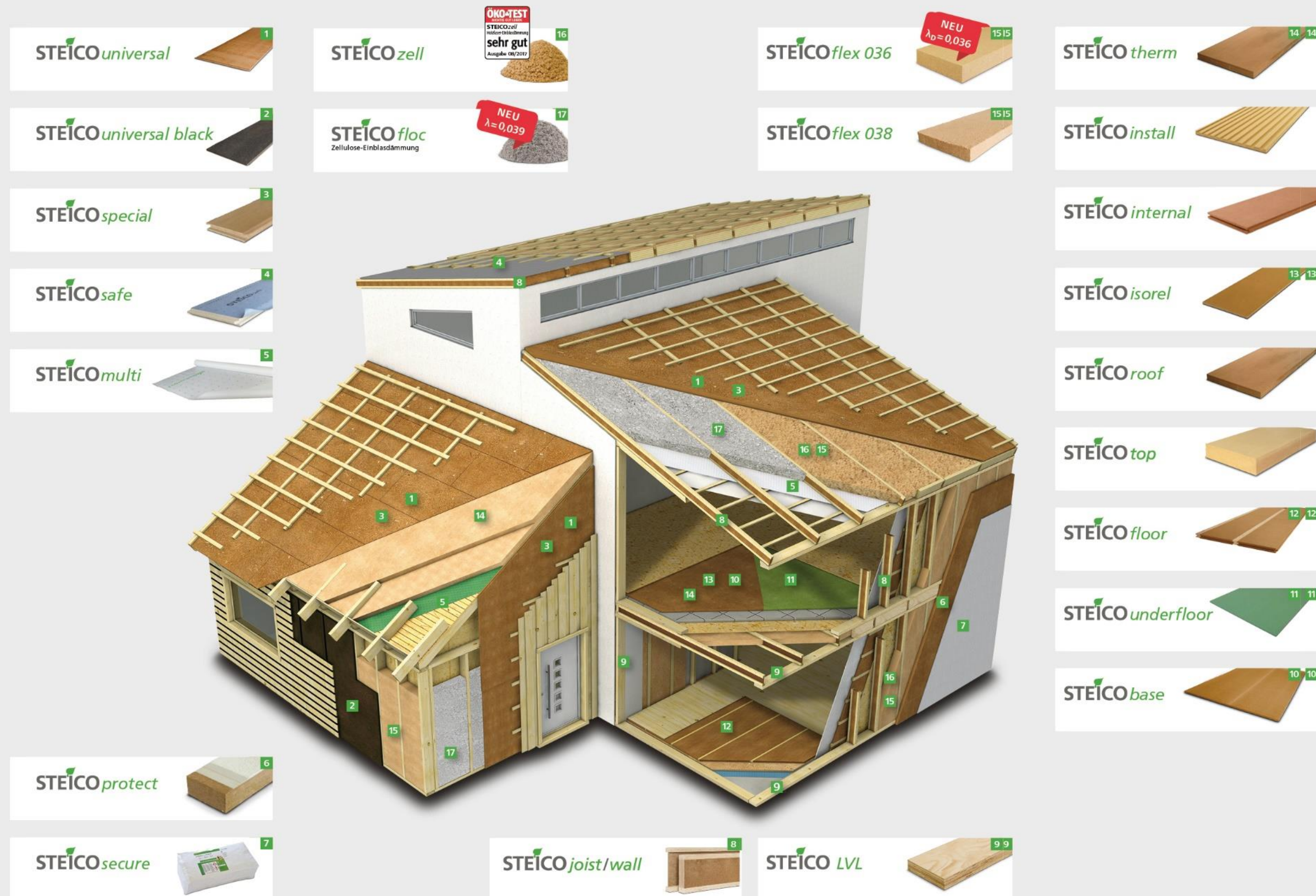


# History - Growth of Wood Fibre Insulation





# Product Range





# Product Range Overview



**Wood fiber  
boards – wet  
process**



**Wood fiber  
boards – dry  
process**



**Flexible wood  
fiber boards**



**Wood fiber  
& cellulose  
injection  
insulation**



# Production Processes



**EN13171**



## The Wet Process

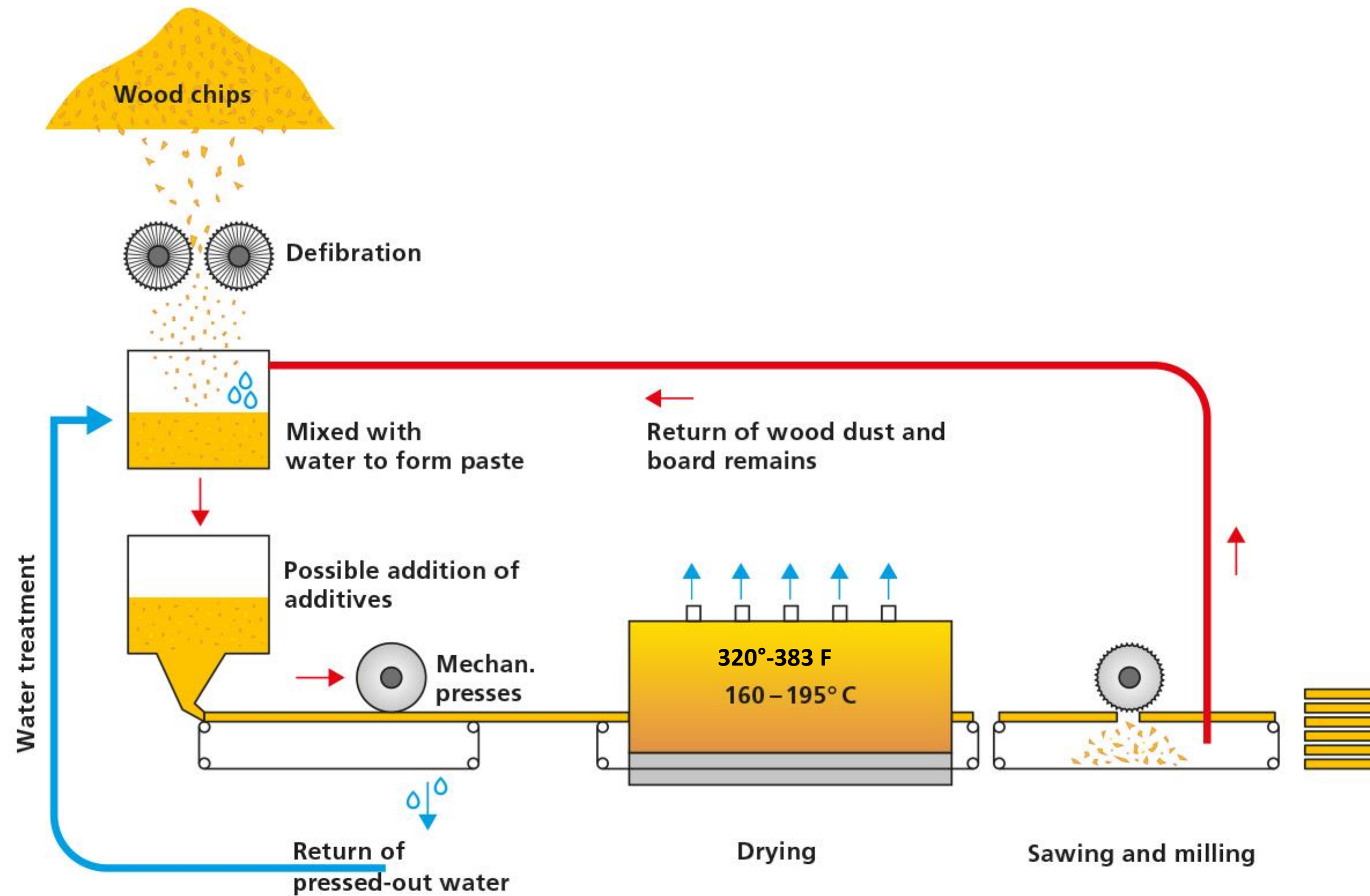
- ✔ Wood own binding materials
- ✔ Bulk density 16.9 lb/f<sup>3</sup>
- ✔ Water vapor diffusion resistance factor  $\mu$ : 5
- ✔ R value 3
- ✔ Higher Density/ Lower R value/ higher u value

## The Dry Process

- ✔ Additional binding materials (3-5%)
- ✔ Bulk density 11.25 – 13.1 lb/f<sup>3</sup>
- ✔ Water vapor diffusion resistance factor  $\mu$ : 3
- ✔ R value 3.5
- ✔ Lower Density/ Higher R value/ lower u value



# Wet Process





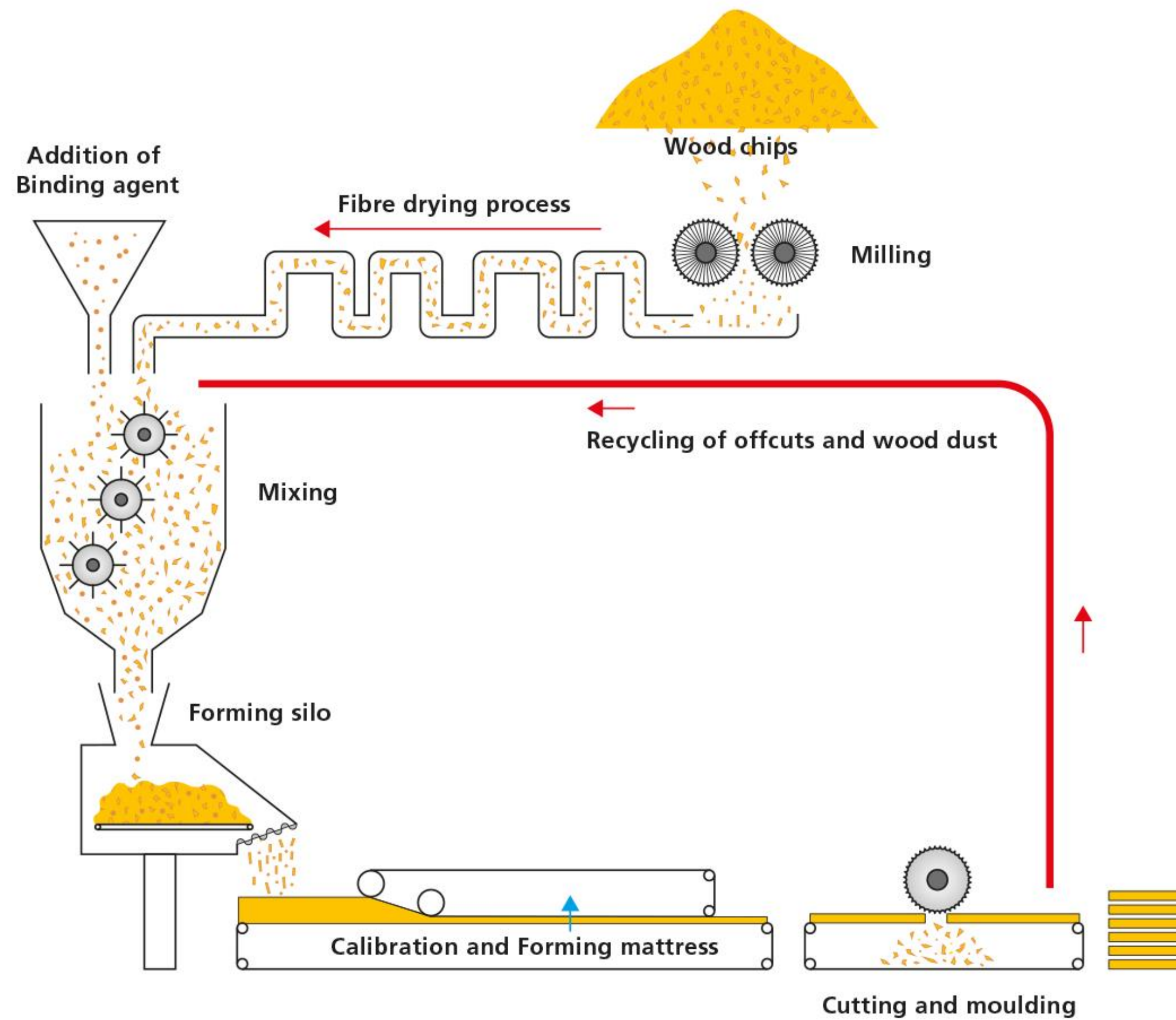
# Wet Process Ingredients

- 🌿 **Wood Fibre/ Natural Resins**
- 🌿 **Water**
- 🌿 **Paraffin**
  - principal user: candle industry
- 🌿 **Aluminium sulphate**
  - flocking agent
  - further areas of use: flocking agent in the water treatment, backing agent in the food industry
- 🌿 **Silicate**
  - binding mechanism: CO<sub>2</sub>-absorption and water loss
  - further areas of use: binding agent in mineral colours and paper





# Dry Process – Wood Fibre Boards





# Dry Process Ingredients

## 🌿 Wood Fibre/ Natural Resin

## 🌿 Ammonium Phosphate

- function: fire retardent agent
- mineral salt out of the elements nitrogen (N) and phosphorus (P)
- further areas of use: fertilizer / food industry

## 🌿 Polyolefin Fibre

- function: binding agent
- textile fibre from the clothing industry

## 🌿 Paraffin Wax

- principal user: candle industry

## 🌿 Polyurethane Resin





# Wood Chips – All FSC Wood





# Chips/ Fibers Routed to Processing





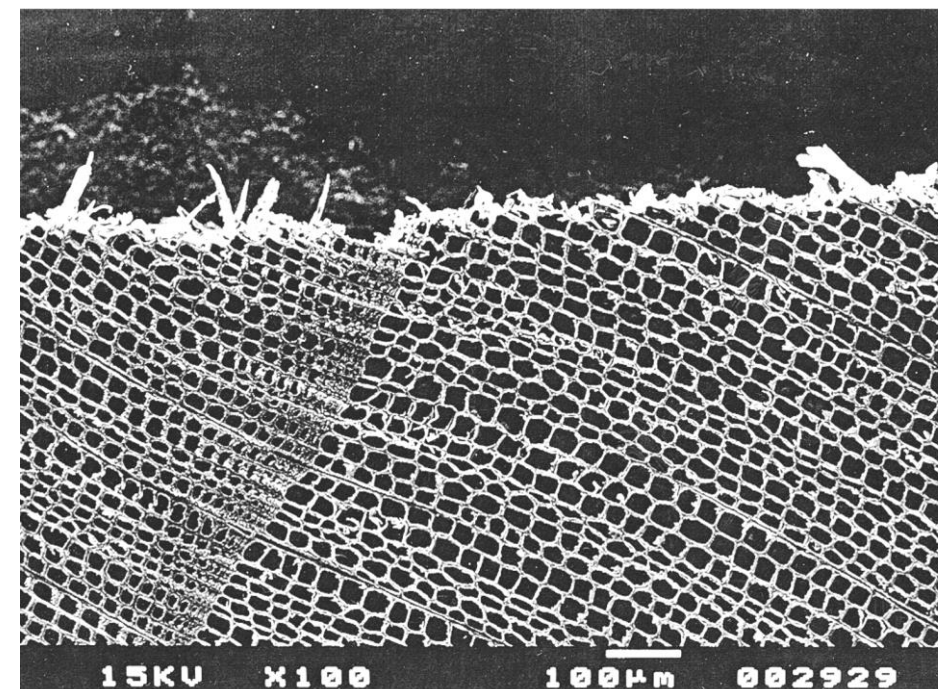
# Dry Board Processing – Rolled/ Compressed to Thickness



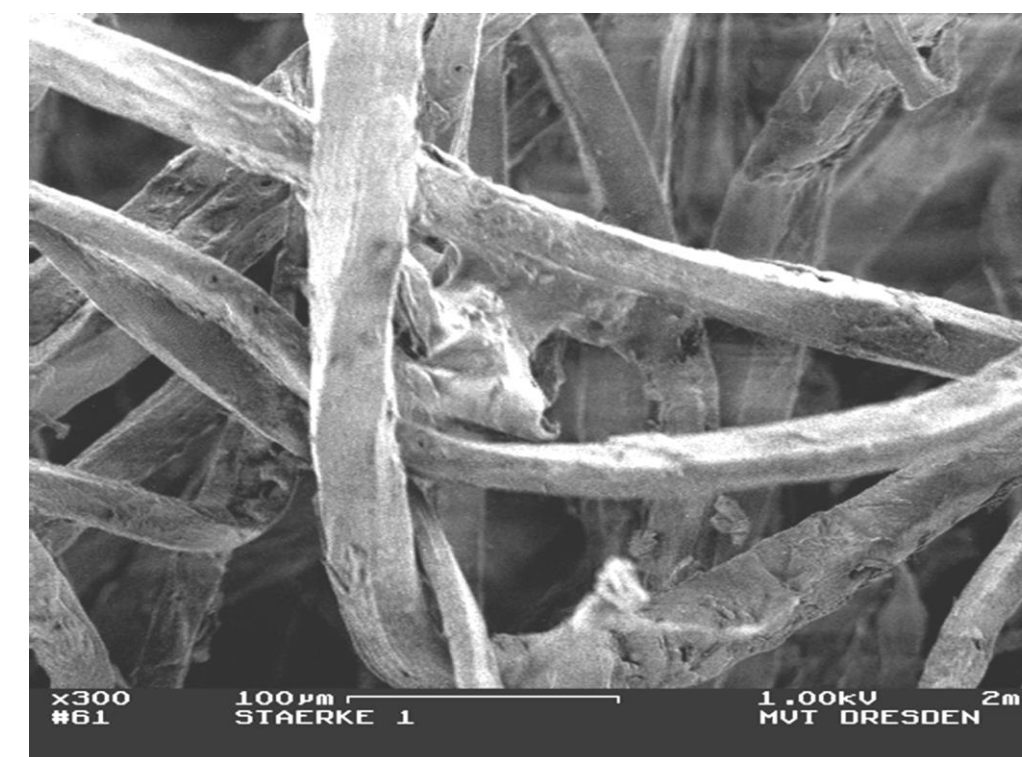


# Why Wood Fibre Insulation?

## Wood is a Natural Insulator



- ✔ Low Thermal Conductivity
- ✔ High Specific Heat Capacity
- ✔ High density Insulation

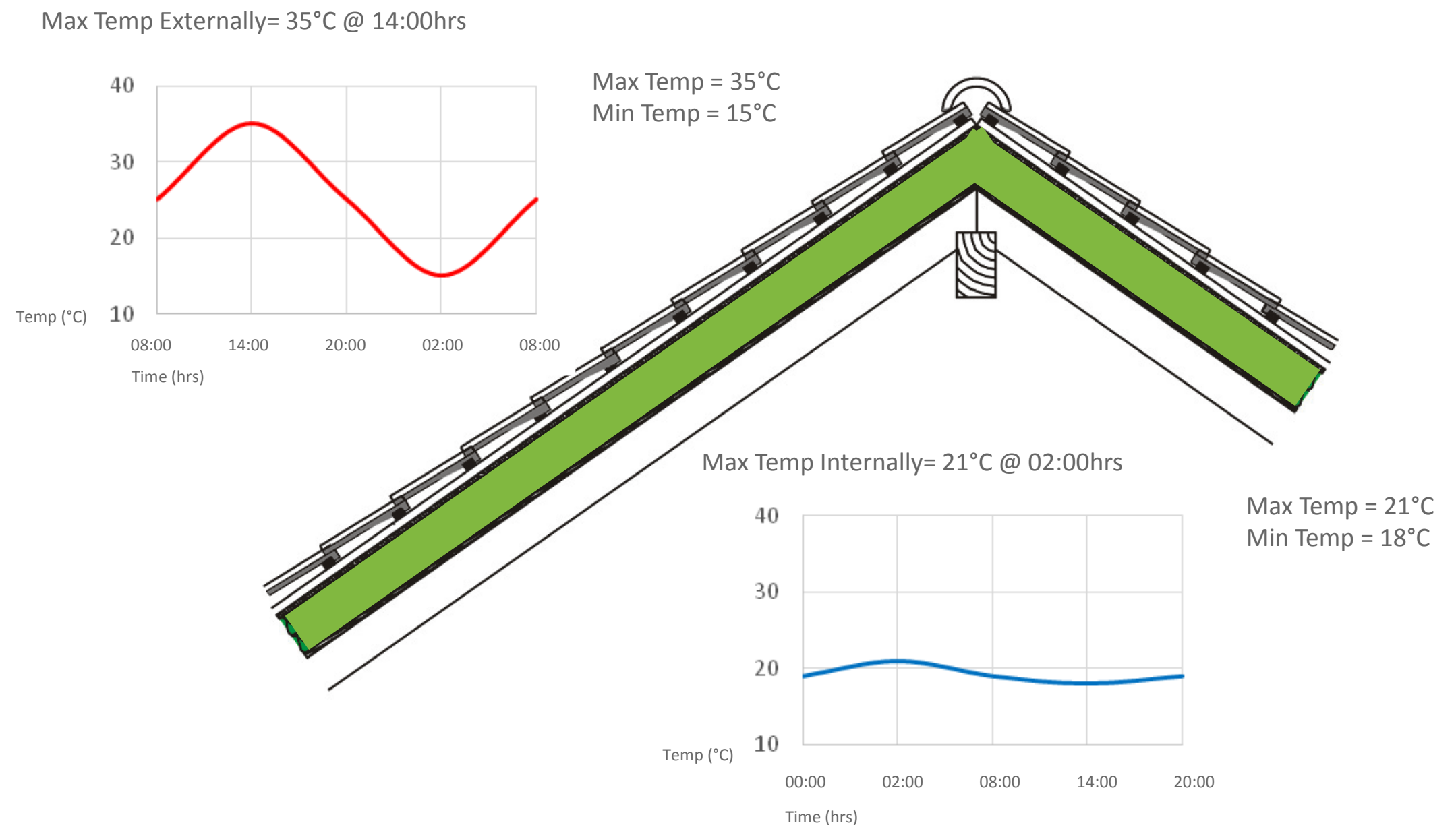




# Why Wood Fibre Insulation?

## Phase Shift Explained

**Phase Shift is defined as the time span between the highest external temperature and the highest internal temperature**  
**In this example the highest temperature is at 2:00 PM and the highest internal temperature at 2:00 AM. This equates to a 12hr Phase Shift**  
**With this level of performance a portion of the heat stored in the insulation components is returned to the external air**  
**Internal temperature will never reach that of the external**



How does this work in practice.....



# Installation and Detailing





# Installation and Detailing





# Flexible Insulation Board



**STEICO***flex*  
flexible Wärmedämmung





# Flexible Insulation Board





# Case study





# Flexible Insulation Board



 Isoflex-Cut





# Installation and Detailing





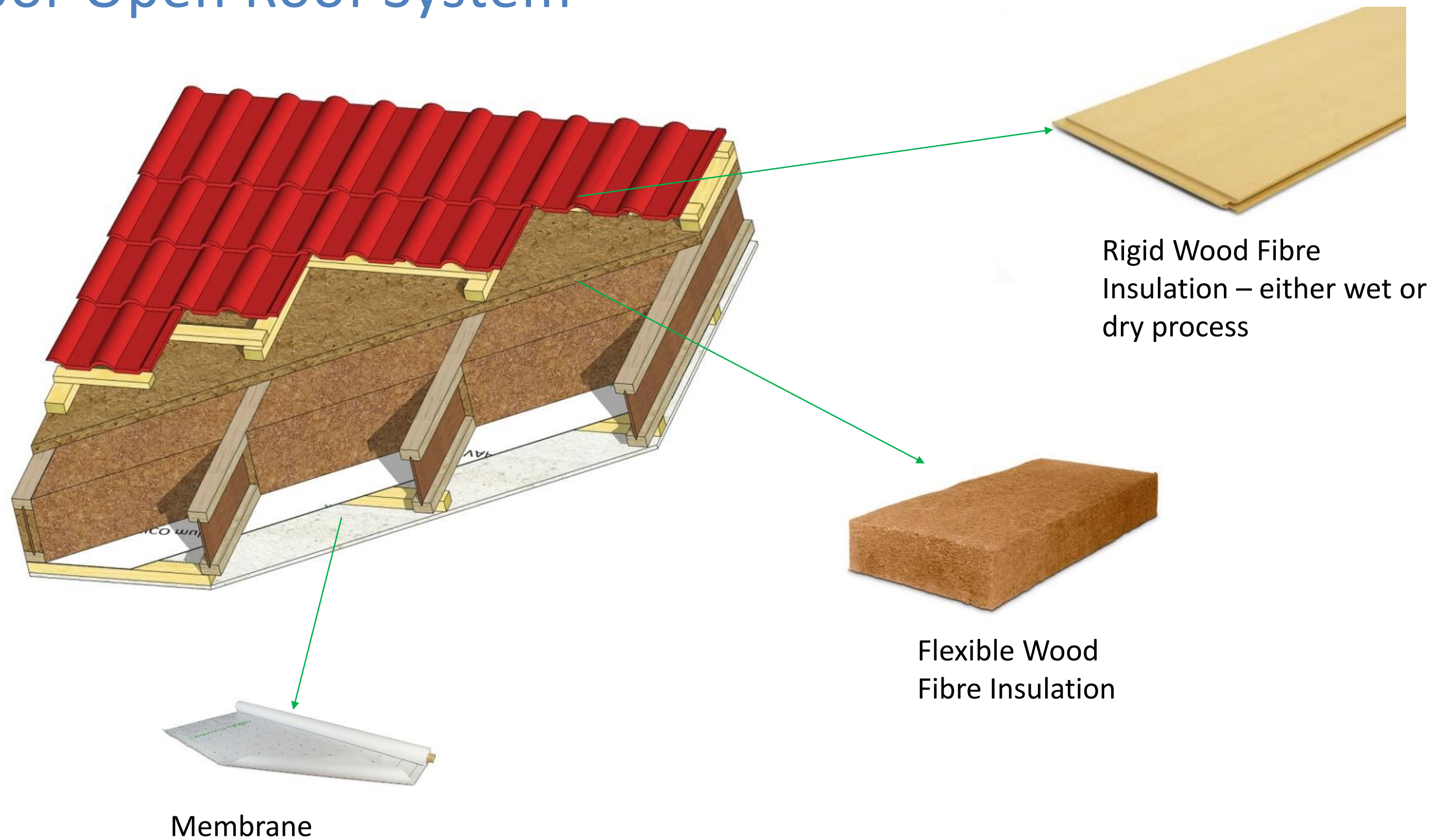
# Installation and Detailing





# Installation and Detailing

## Vapor Open Roof System



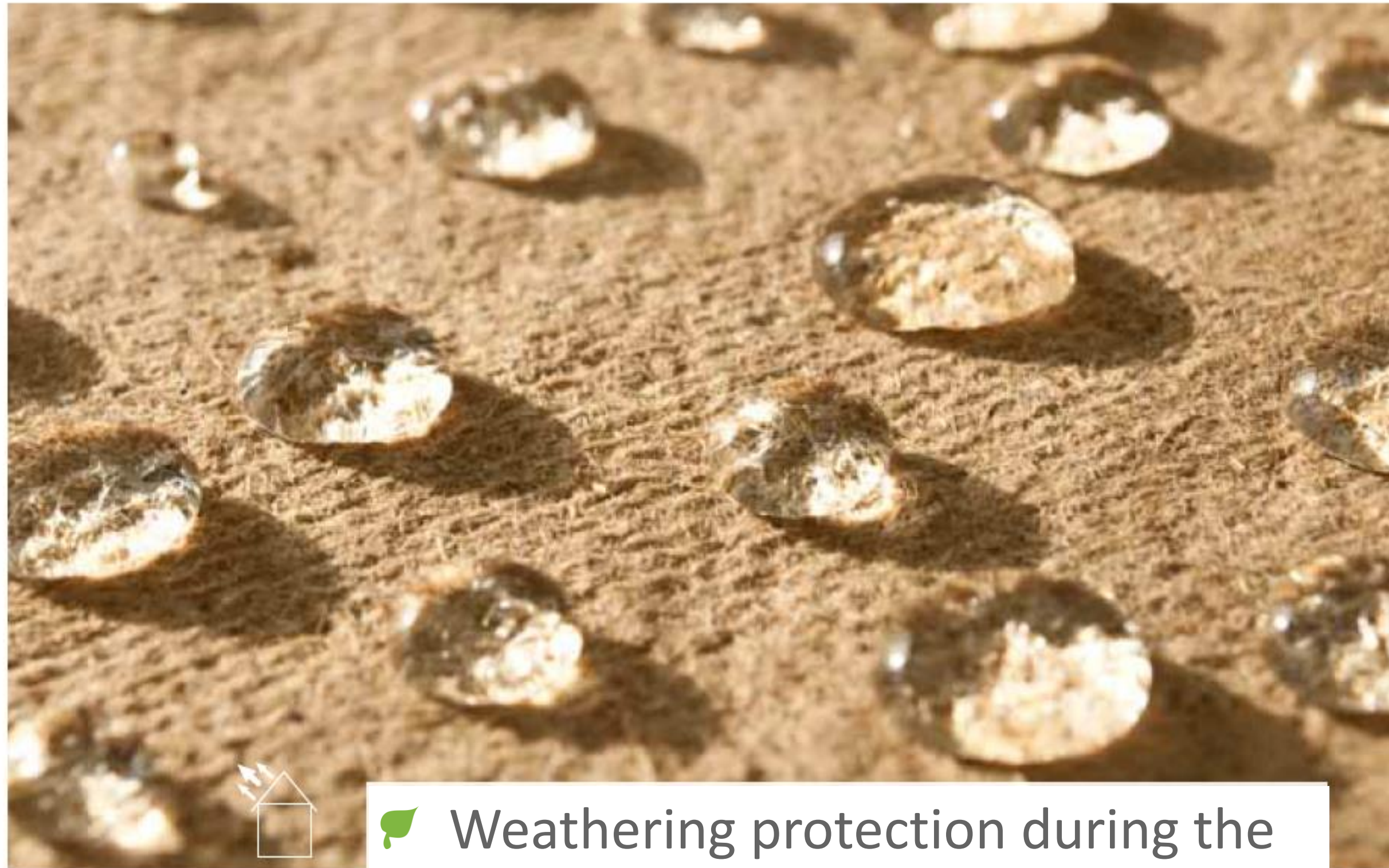


# Installation and Detailing





# Weathering protection



Weathering protection during the building phase



# Loose fibre

## 🌱 Packaging / Delivery



🌱 PE-bag 15 kg

🌱 ~ 2,5 bag per m<sup>3</sup>





# Loose fibre

Product Range





# Loose fibre



Injection lance





# Pressure Resistant Board



**STEICO** *therm*  
stabile Wärmedämmung

**STEICO** *therm internal*  
Innendämmung aus Holzfasern

**STEICO** *floor*  
Fußboden-Dämmsystem

**STEICO** *universal*  
Unterdach- und Wandbauplatte

**STEICO** *special*  
Holzfaser-Dämmsystem

**STEICO** *protect*  
Holzfaser-Dämmplatte

**STEICO** *underfloor*  
Parkett- und Laminatbodenunterlage

**STEICO** *isorel*  
vielseitige Holzfaserplatte





# Installation

Product Range





# Installation





# Floor systems



in combination with timber floor boards



**STEICO** *floor*  
Fußboden-Dämmsystem





# Case Study

Product Range





# Case Study





# Installation and Detailing





# Case study





# Case Study

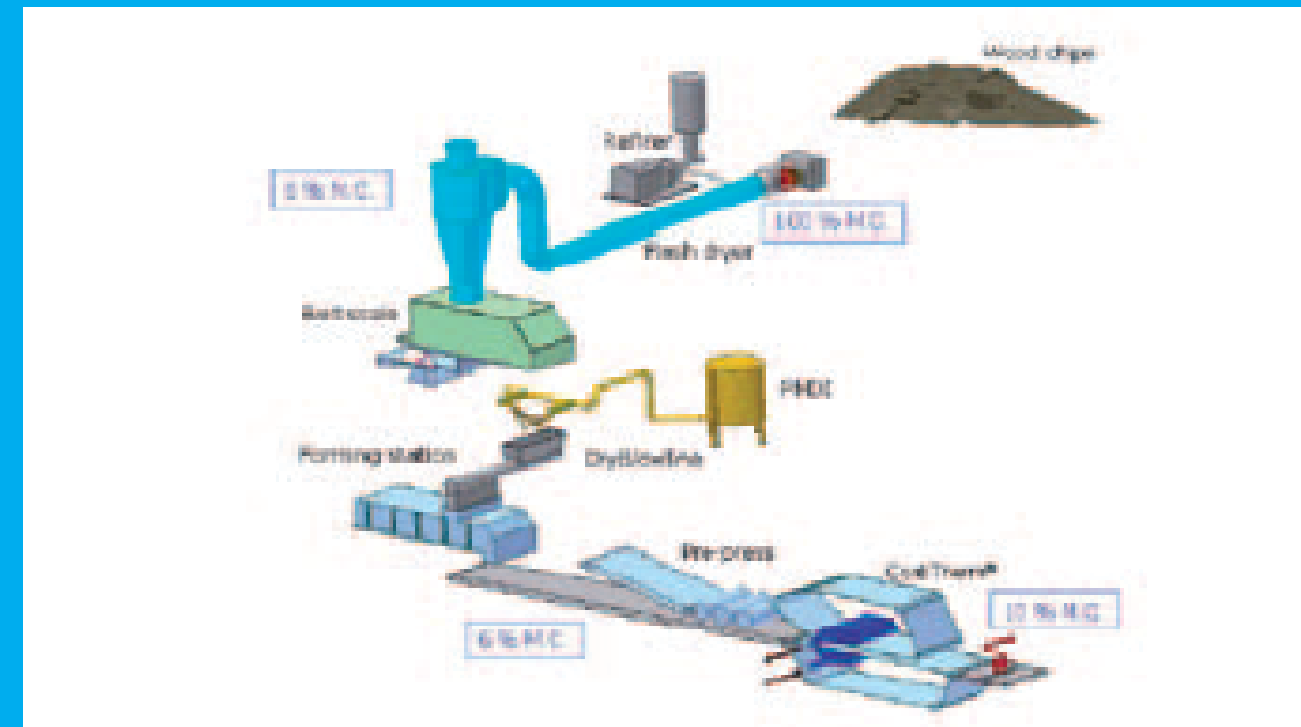




# Case Study







## > PRODUCTION PLANT DATA

Raw material Wood (without bark) Binder  Hydrophobic additive (for special applications) Fire retardant (depending on density)	softwood (like spruce, fir, pine) PMDI (for rigidboards) Option: Bico-fibers (for flexible boards) paraffin emulsion ammoniumphosphate
Site (for the production line without warehouse, infrastructure etc.) Masterboard width	approx 6,500 m <sup>2</sup> (70,000 sq. ft.) approx 150 m x 42 m (500 ft. x 140 ft.) approx. 2,400 to 2,600 mm (8.0 – 8.5 ft.), depending on final board size
Rigid board – Capacity (depending on density and thickness) Throughput	36 – 72 m <sup>3</sup> /h (1,270 – 2,540 cu. ft./hour)  up to 7 t/h (7.7 ton/hour) wood
Option: flexible board – Capacity (depending on density and thickness) Throughput	45 – 75 m <sup>3</sup> /h (1,585 – 2,648 cu. ft./hour)  up to 3 t/h (3.3 ton/hour) wood



# HASSLACHER Group

**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.

Founded in 1901 by Jakob HASSLACHER  
400 Mio. EUR Turn-over  
1.600 employees at 8 locations in 4 countries  
Headquarter: Sachsenburg/Carinthia/Austria





# HASSLACHER Group Production sites

**HASSLACHER**  
**NORICA TIMBER**

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## AUSTRIA

Sachsenburg  
Stall im Mölltal  
Hermagor  
Preding

## GERMANY

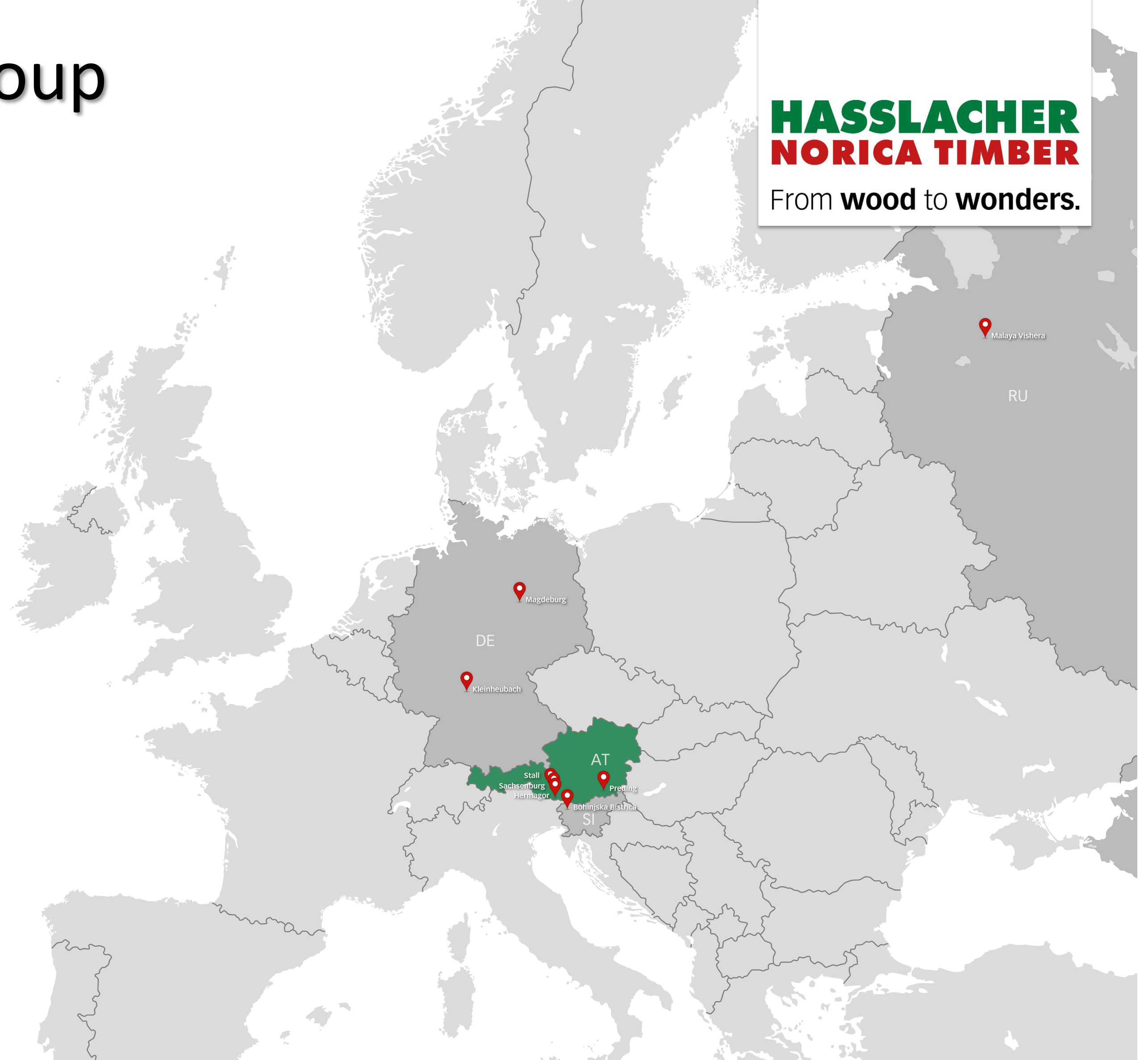
Magdeburg  
Kleinheubach

## SLOVENIA

Bohinjska Bistrica

## RUSSIA

Malaya Vishera





# ANNUAL PRODUCTION



**750,000 m<sup>3</sup>**  
SCHNITTHOLZ  
SAWN TIMBER  
SEGATI



**90,000 t**  
PELLETS  
PELLETS  
PELLET



**160,000 m<sup>3</sup>**  
HOBELWARE  
SURFACED TIMBER  
PERLINE E PIALLATI



**1,000,000 PIECES**  
PALETTEN & VERPACKUNGSLÖSUNGEN  
PALLETES & PACKAGING SOLUTIONS  
BANCALI & SOLUZIONI DI IMBALLAGGIO



**100,000 m<sup>3</sup>**  
KONSTRUKTIONSVOLLHOLZ  
FINGER JOINTED STRUCTURAL TIMBER  
LEGNO MASSICCIO DA COSTRUZIONE



**1,500,000 m<sup>2</sup>**  
SCHALUNGSPLATTEN  
SHUTTERING BOARDS  
PANNELLI PER CASSEFORME



**150,000 m<sup>3</sup>**  
BRETTSCHICHTHOLZ  
GLUE LAMINATED TIMBER  
LEGNO LAMELLARE



**90 GWh**  
WÄRME  
HEAT  
CALORE



**45,000 m<sup>3</sup>**  
BRETTSPERRHOLZ  
CROSS LAMINATED TIMBER  
PANNELLI X-LAM



**80 GWh**  
STROM  
ELECTRICITY  
ENERGIA ELETTRICA



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# From Wood to Wonders.



# From Wood ...



*„Fichtenwald bei Spittal“ © Christoph Kulterer*



... to Wonders.



*La Seine Musical" © HESS Timber*



**... to Wonders.**





... to Wonders.





... to Wonders.



„Freisinger Holzbau“ © Frischeis



**... to Wonders.**





# Why Central European Products?

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**NORICA TIMBER**

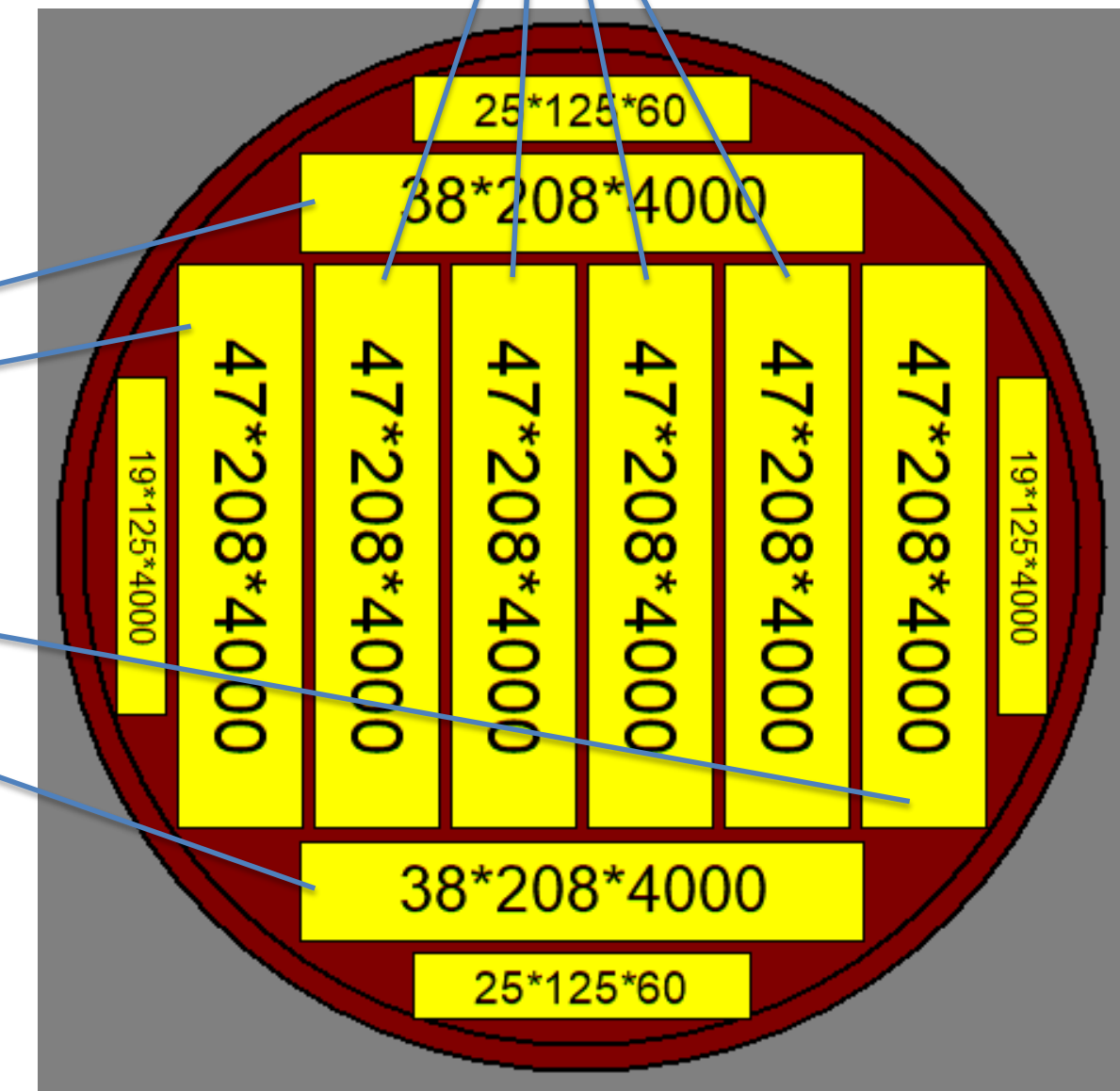
From **wood** to **wonders**.

Log Diameter: average 280 mm/11"

- High yield
- High volume of 200 mm and wider lumber
- Large widths of side boards possible
- Example 380 mm log

CLT

GLULAM





# COMPREHENSIVE PRODUCT RANGE

ALL FROM ONE SOURCE



SCHNITTHOLZ  
SAWN TIMBER  
SEGATI



HOBELWARE  
SURFACED TIMBER  
PERLINE E PIALLATI



KONSTRUKTIONSVOLLHOLZ GLT®  
FINGER JOINTED STRUCTURAL TIMBER  
LEGNO MASSICCIO DA COSTRUZIONE



BALKENSCHICHTHOLZ DUO/TRIO  
LAMINATED BEAMS DUO/TRIO  
TRAVI DUO/TRIO



BRETTSCHICHTHOLZ  
GLUE LAMINATED TIMBER  
LEGNO LAMELLARE



BRETTSTAPELSYSTEMDECKE  
SOLID TIMBER CEILING SYSTEM  
ELEMENTI PER SOLAIO IN LAMELLARE



BRETTSPERRHOLZ NORITEC X-LAM  
CROSS LAMINATED TIMBER  
PANNELLI X-LAM



BRETTSCHICHTHOLZ SONDERBAUTEIL  
GLUE LAMINATED TIMBER SPECIAL COMPONENTS  
LEGNO LAMELLARE ELEMENTI COSTRUTIVI SPECIALI



SPEZIALPRODUKTE  
SPECIAL PRODUCTS  
PRODOTTI SPECIALI



PELLETS  
PELLETS  
PELLET



SCHALUNGSPLETTEN  
SHUTTERING BOARDS  
PANNELLI PER CASSEFORME



PALLETEN & VERPACKUNGSLÖSUNGEN  
PALLETS & PACKAGING SOLUTIONS  
BANCALI & SOLUZIONI DI IMBALLAGGIO



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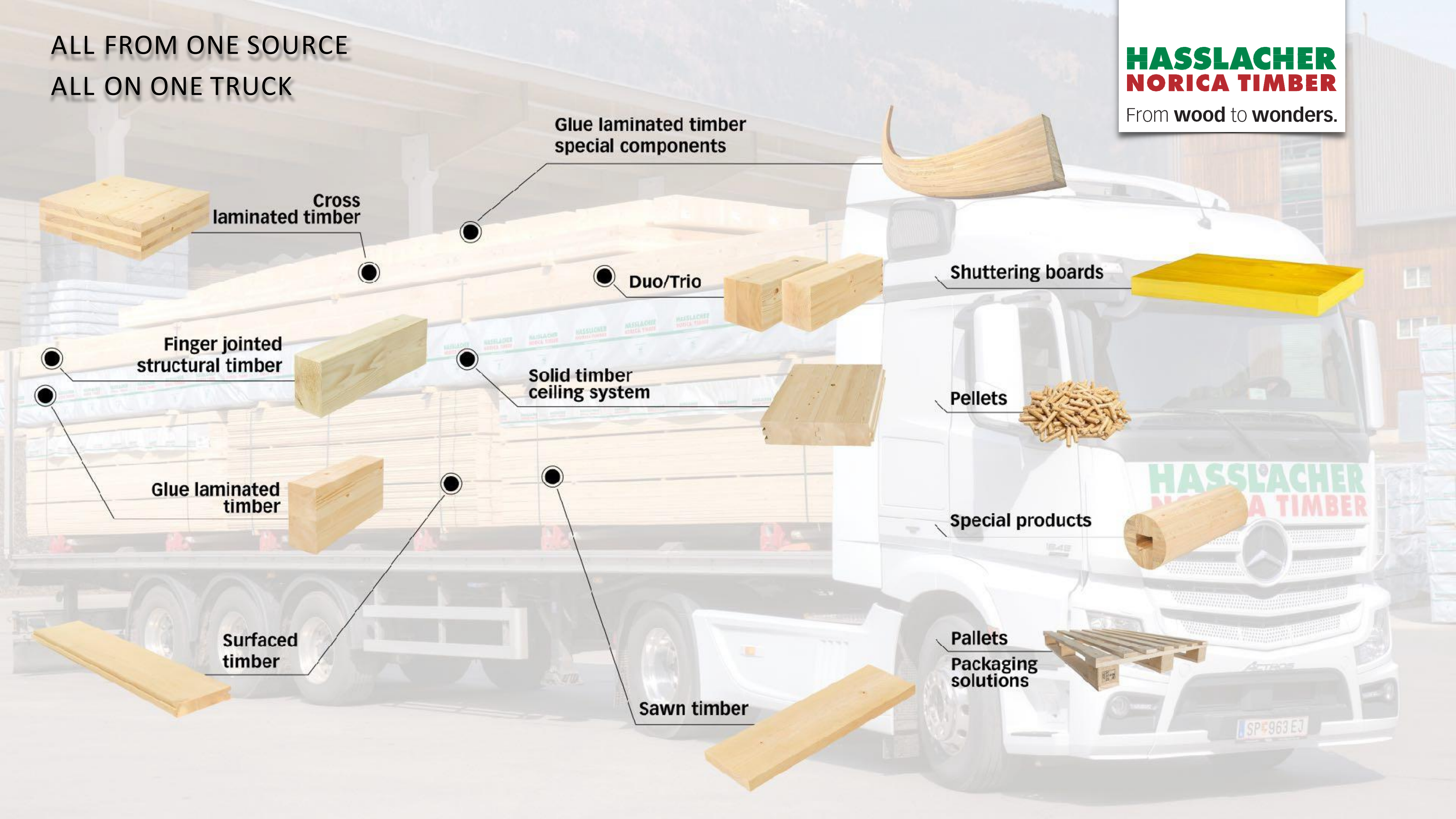




ALL FROM ONE SOURCE  
ALL ON ONE TRUCK

**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.



Cross  
laminated timber

Glue laminated timber  
special components

Duo/Trio

Shuttering boards

Finger jointed  
structural timber

Solid timber  
ceiling system

Pellets

Glue laminated  
timber

Special products

Surfaced  
timber

Pallets  
Packaging  
solutions

Sawn timber



# CROSS LAMINATED TIMBER NORITEC X-LAM

THE CONSTRUCTION MATERIAL OF THE FUTURE

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From **wood** to **wonders**.



From  
wood  
to  
wonders.

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# CROSS LAMINATED TIMBER NORITEC X-LAM

THE CONSTRUCTION MATERIAL OF THE FUTURE

**HASSLACHER**  
**NORICA TIMBER**  
From **wood** to **wonders**.

## ADVANTAGES

- + No modular dimensions, order size = invoiced size
- + Highest precision joinery work
- + Sanded surface with all qualities
- + Flexible sizes up to 3.20 x 20.0 m





# CROSS LAMINATED TIMBER NORITEC X-LAM

THE CONSTRUCTION MATERIAL OF THE FUTURE

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# SOLID TIMBER CEILING SYSTEM

THE HIGH-PERFORMANCE CEILING SYSTEM

**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.



# SOLID TIMBER CEILING SYSTEM

THE HIGH-PERFORMANCE CEILING SYSTEM

## ADVANTAGES

- + Cost-effective system for flat ceilings
- + High load capacity and rigidity
- + Fast delivery times
- + Also available as an acoustic ceiling





# GLUE LAMINATED TIMBER

ENGINEERED WOODEN BEAMS

**HASSLACHER**  
**NORICA TIMBER**

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An aerial photograph of a large-scale timber roof construction. The image shows a complex network of light-colored wooden beams forming a grid-like structure. Two workers wearing yellow hard hats and blue clothing are visible on a blue scissor lift platform, working on the roof. The scene is brightly lit, casting long shadows across the wooden framework.

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# GLUE LAMINATED TIMBER

ENGINEERED WOODEN BEAMS

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# GLUE LAMINATED TIMBER

ENGINEERED WOODEN BEAMS

**HASSLACHER**  
**NORICA TIMBER**

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## ADVANTAGES

- + Broad product range
- + All strength categories
- + Wood types: spruce/fir, pine, larch, birch
- + Widths from 80 mm to 280 mm, block bonding
- + Heights from 80 mm to 4,000 mm
- + Lengths up to 41 m
- + All forms possible, incl. 3-dimensional



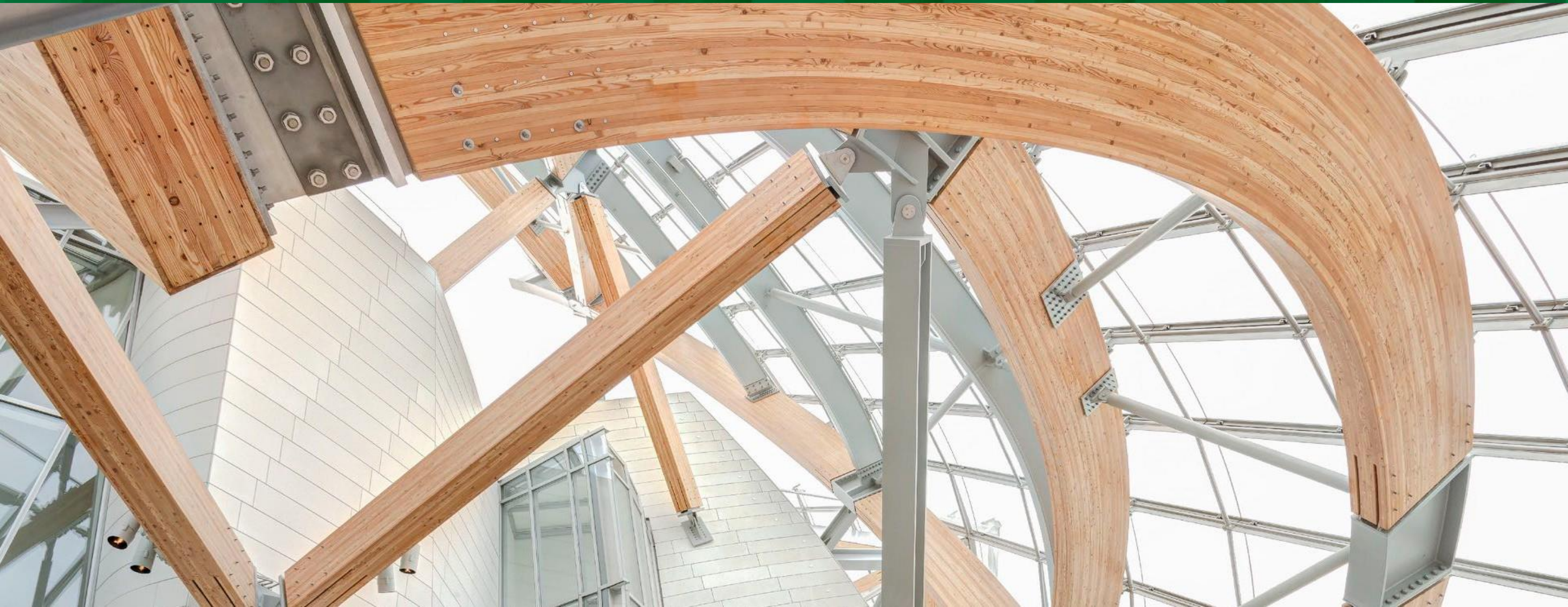


# GLUE LAMINATED TIMBER

ENGINEERED WOODEN BEAMS

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# LAMINATED BEAMS

## DUO/TRIO

DIMENSIONALLY STABLE AESTHETICS

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**NORICA TIMBER**

From **wood** to **wonders**.



# LAMINATED BEAMS

## DUO/TRIO

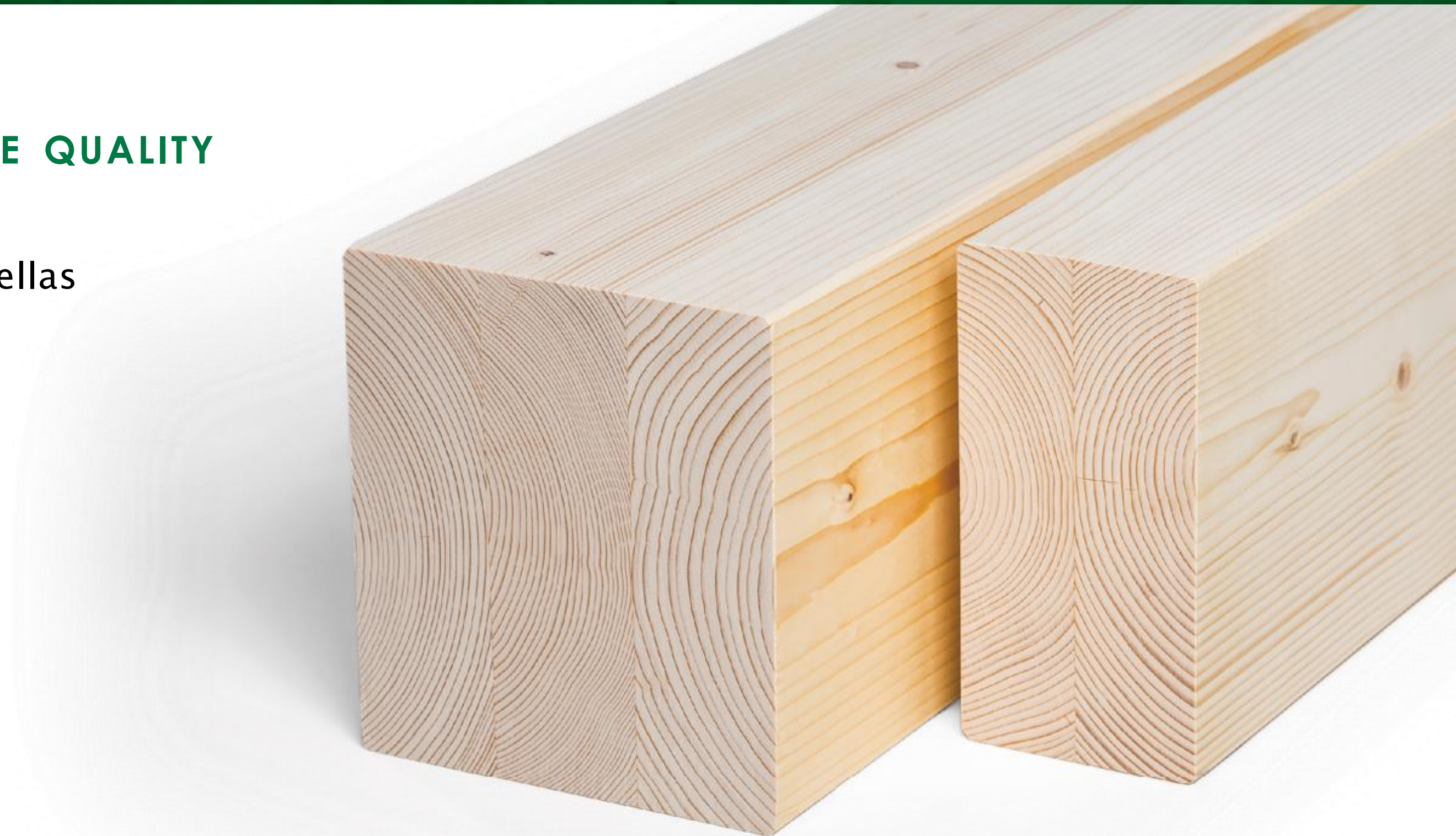
DIMENSIONALLY STABLE AESTHETICS

**HASSLACHER**  
**NORICA TIMBER**

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### LAMINATED BEAMS OF FURNITURE QUALITY

- + Top quality surfaces
- + Use of heartwood-free, cut raw lamellas
- + Wide range of cross-sections
- + Various types of wood possible





# LAMINATED BEAMS DUO/TRIO

DIMENSIONALLY STABLE AESTHETICS

**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.





A wide-angle photograph of a large industrial timber processing facility. In the foreground, a worker in a red shirt and apron stands near a conveyor belt carrying long wooden beams. In the background, another worker is visible near a large yellow and red machine. The facility features high ceilings with red structural beams and various pieces of industrial equipment.

**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.

- + Joinery systems available at all our plants
- + Fast and easy assembly at the construction site
- + Competent contact partners ensure accurate and cost-effective finishing



# FINGER JOINTED STRUCTURAL TIMBER GLUED LAMINATED TIMBER BEAMS

THE INDIVIDUALLY CERTIFIED SECURITY GUARANTEE

**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.



# FINGER JOINTED STRUCTURAL TIMBER GLUED LAMINATED TIMBER BEAMS

THE INDIVIDUALLY CERTIFIED SECURITY GUARANTEE

**HASSLACHER**  
**NORICA TIMBER**

From wood to wonders.

## BROAD PRODUCT RANGE

- + Cross-section heights from 80 mm to 300 mm
- + Cross-section heights from 60 to 160 mm
- + Lengths from 2.5 m to 18.0 m
- + Wood types: spruce/fir, pine, Douglas fir
- + Block profile on request
- + Pressure impregnation possible
- + From spring 2017: joinery work at customer request





# FINGER JOINTED STRUCTURAL TIMBER GLUED LAMINATED TIMBER BEAMS

THE INDIVIDUALLY CERTIFIED SECURITY GUARANTEE

**HASSLACHER**  
**NORICA TIMBER**

From wood to wonders.



- + Each item is checked
- + Online quality assurance instead of random sampling
- + Like glue laminated timber, glue laminated timber beams can be measured and wood construction costs saved



# SURFACED TIMBER

VERSATILITY FOR INSIDE AND OUTSIDE SURFACES

**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.



# SURFACED TIMBER

VERSATILITY FOR INSIDE AND OUTSIDE SURFACES

**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.

## ADVANTAGES

- + Versatile application possibilities for both inside and outside areas
- + The correct sorting and quality for each use, comprehensive product range
- + Can be combined with all other products from the HASSLACHER group
- + Certified product quality: member of the Association of the European Planing Industries





# SURFACED TIMBER

VERSATILITY FOR INSIDE AND OUTSIDE SURFACES

**HASSLACHER**  
**NORICA TIMBER**

From wood to wonders.





# PELLETS

SUSTAINABLE ENERGY FROM NATURE

**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.





# PELLETS

SUSTAINABLE ENERGY FROM NATURE

**HASSLACHER**  
**NORICA TIMBER**  
From **wood** to **wonders**.

## BRINGING NATURE INTO BALANCE WITH PELLETS

- + This natural heating material is made from pure dried sawdust and wood shavings pressed with purely biogenic pressing additives
- + Pellets are carbon-neutral and during the burning process, they release the same quantity of CO<sub>2</sub> as was absorbed by the tree during growth
- + The supply is 100 % guaranteed, independent of oil and gas and always available in sufficient quantities
- + Local softwood from the region based on 100% sustainable forestry





**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.



# SHUTTERING BOARDS

NATURAL BEAUTY FOR CONCRETE SURFACES

**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.





# SHUTTERING BOARDS

NATURAL BEAUTY FOR CONCRETE SURFACES

## ADVANTAGES

- + Low cost due to high level of repeat uses
- + Sanded surfaces for perfect results
- + Closed structure to prevent cracks and ensure dimensional stability
- + High product lifespan thanks to all-round glued border





# SAWN TIMBER

BOARDS WHICH MEAN THE WORLD

**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.



# SAWN TIMBER

BOARDS WHICH MEAN THE WORLD

**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.

## SAWN TIMBER PRODUCTS

- + Lamellas for glue laminated timber
- + Lamellas for laminated beams and finger jointed structural timber, heartwood-separated or heartwood-free
- + Rough-planed timber
- + Window scantlings, window lamellas and finer jointed products
- + Slats, poles and posts
- + Wooden beams
- + Side board products for packers and industrial processors
- + Cm products
- + Sawmill by-products





**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders.**

From  
wood  
to  
wonders.

[hasslacher.com](http://hasslacher.com)



# SPECIAL PRODUCTS

A SOLUTION FOR EVERY CHALLENGE

**HASSLACHER**  
**NORICA TIMBER**

From **wood** to **wonders**.



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## SPECIAL PRODUCTS

- + Large façade elements
- + Edge-glued decking boards with refined surfaces
- + Mini laminated beams
- + Rounded pillars
- + Wood-concrete composite systems





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# FROM WOOD TO WONDERS BY INNOVATION. BIRCH GLUE LAMINATED TIMBER

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# FROM WOOD TO WONDERS BY INNOVATION. BIRCH CROSS LAMINATED TIMBER





FROM WOOD TO WONDERS BY INNOVATION.  
EXCELLENT SURFACE

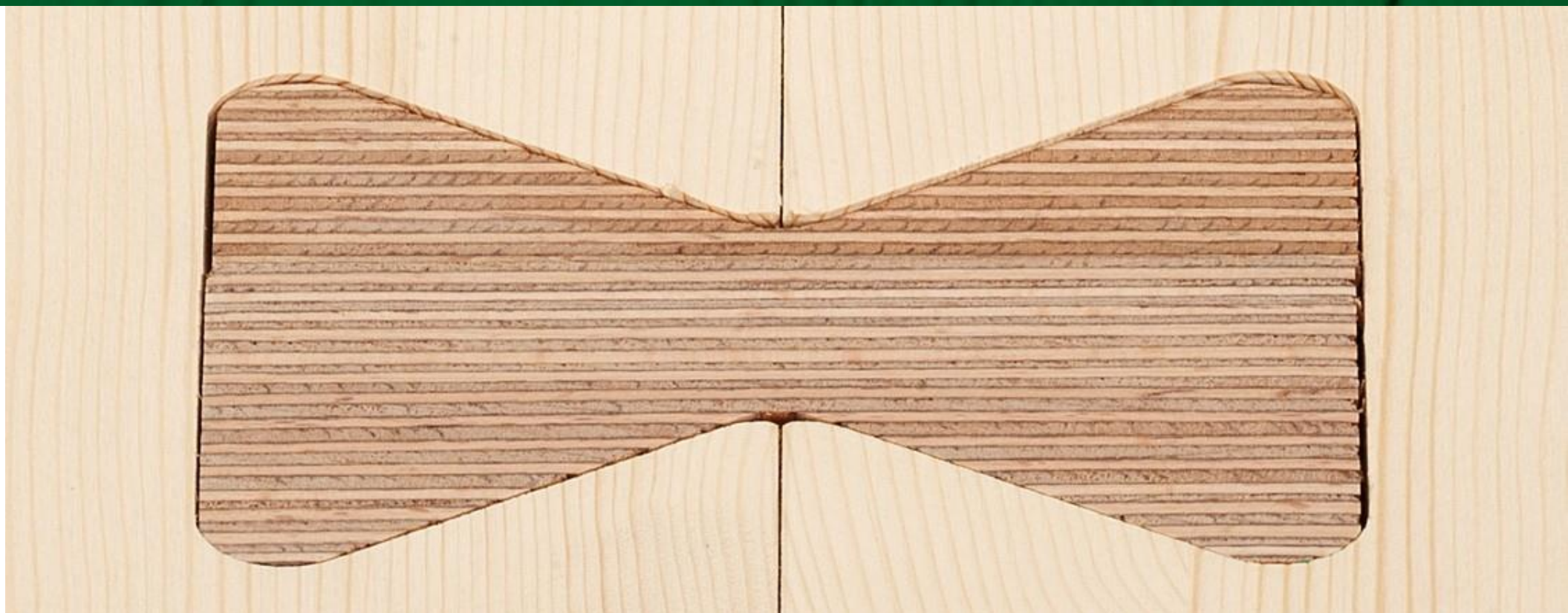
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# FROM WOOD TO WONDERS BY INNOVATION. X-FIX WOOD-WOOD CONNECTOR SYSTEM

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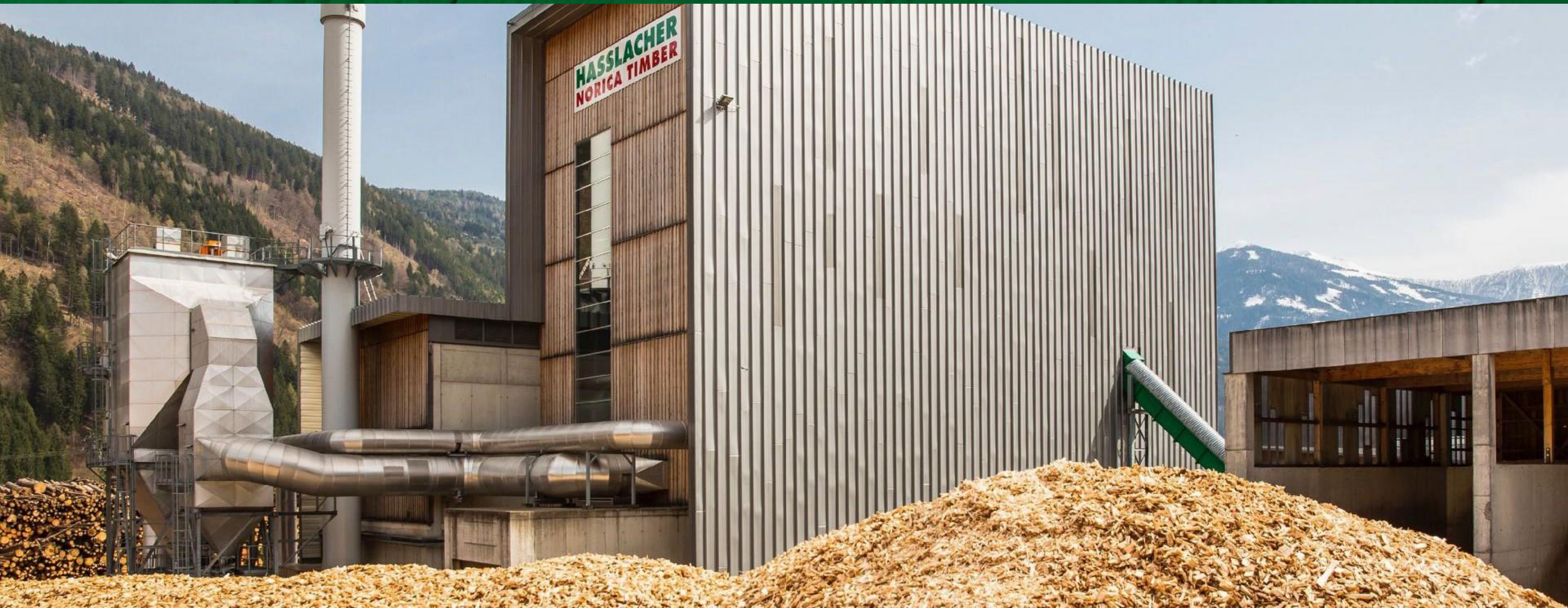


# CONCENTRATED ENERGY

WITH REGIONAL ADDED VALUE FOR THE FUTURE

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HASSLACHER NORICA TIMBER generates 80 GWh from wood fuel. This includes waste wood such as bark, off-cuts, wood chip, branches etc. This corresponds to an electricity consumption of 16,000 households i.e. the size of a town such as Spittal an der Drau.



# SACHSENBURG | CARINTHIA



## Company headquarters

Feistritz 1 | 9751 Sachsenburg | Austria

**T** +43 4769/22 49

**M** [info@hasslacher.com](mailto:info@hasslacher.com)

## Production of:

Glue laminated timber

Laminated beams duo/trio

Surfaced timber

Sawn timber

Sawmill by-products

Electricity and heat from 2 CHP systems

Electricity from photovoltaic plant

HASSLACHER Holding GmbH

Management & administration

HASSLACHER DRAULAND Holzindustrie GmbH

Production sawmill

NORITEC Holzindustrie GmbH

Planing mill & glue laminated timber plant

HASSLACHER Energie GmbH: biomass cogeneration

NORICA TIMBER Vertrieb GmbH: sales

**Employees: approx. 380**





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[www.hasslacher.com](http://www.hasslacher.com)



# Thank You For Your Time

## Any Questions?

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