

# WOOD VENEER *Matching*.....

2

## BETWEEN LEAVES

**T**HERE are three types of matching in specifying panel products.

- Matching between leaves (page 2)
- Matching within a face (page 3)
- Matching between panels

Each of these must be specified and, when possible, shown on the design drawings.

### BOOK MATCHING

The most commonly used match in the industry is where every other leaf of veneer is turned over, like the pages of a book. Thus the grain is mirrored in each adjacent leaf. The visual effect created is that veneer joints match, creating a symmetrical pattern. This type of matching yields maximum continuity of grain. When sequenced panels are specified, prominent characteristics will “ascend” or “descend” across the match as the leaves progress from panel to panel.

Book matching may be used with plain, quarter or rift sliced veneers. Because the “tight” and “loose” faces alternate in adjacent leaves, they reflect light and accept stain differently, and this may yield a noticeable color variation in some species or fitches.

### SLIP MATCHING

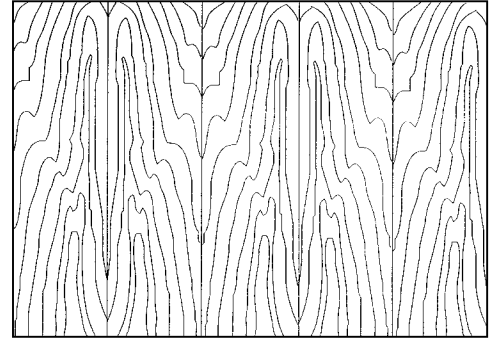
Often used with quarter sliced and rift sliced veneers, this is the process in which a sequence of matching veneer leaves or consecutive sheets of veneer are slipped out one after the next, to form the face of a panel product. This results in all the same face sides being exposed. The visual effect shows a grain figure repeating, but joints do not show grain match.

The lack of grain match at the joints with slip matching can be desirable. The relatively straight grain patterns of quartered and rift veneer generally produce pleasing results and a uniformity of color because all faces have the same light refraction. This is in contrast to book matching where alternating leaves are turned over.

### RANDOM MATCHING

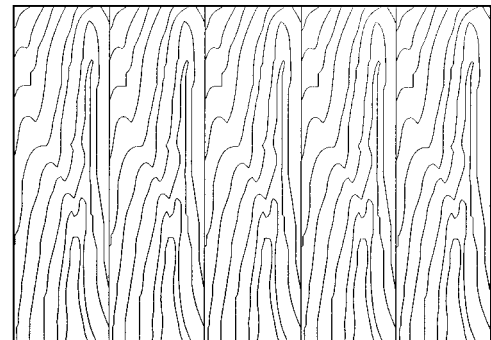
Veneer leaves are placed next to each other in a random order and orientation and randomly spliced edge to edge, producing a “board-by-board” effect in many species. This produces a casual or rustic appearance, as though individual boards from a random pile were applied to the product. Conscious effort is made to mismatch grain at joints.

Degrees of contrast and variation may change from panel to panel. This match is more difficult to obtain than Book or Slip Match, and must be clearly specified and detailed.



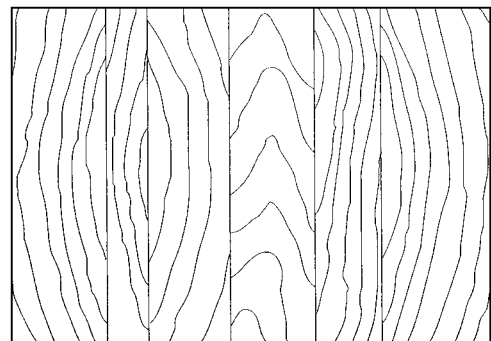
**BOOK MATCHING**

Figure 200-15 from AWI Quality Standards Illustrated, Seventh Edition.



**SLIP MATCHING**

Figure 200-16 from AWI Quality Standards Illustrated, Seventh Edition.



**RANDOM MATCHING**

Figure 200-17 from AWI Quality Standards Illustrated, Seventh Edition.

# WITHIN A FACE

**T**HE individual leaves of veneer in a sliced flitch increase or decrease in width as the slicing progresses. Thus, if a number of panels are manufactured from a particular flitch, the number of veneer leaves per panel face will change as the flitch is utilized. The manner in which these leaves are “laid up” within the panel can be classified as follows:

## RUNNING MATCH

In a Running Match each panel face is assembled from as many veneer leaves as necessary so that the widths and number of matching veneer leaves are not requirements. This can produce a match which appears less even or random and asymmetrical. Running matches are seldom “sequenced and numbered” for use as adjacent panels. Horizontal grain “match” or sequence cannot be expected.

## BALANCE MATCH

In a Balance Match the width of each veneer leaf in a panel face is the same. Panels may contain an even or odd number of leaves, and distribution may change from panel to panel within a sequenced set.

## CENTER BALANCE MATCH

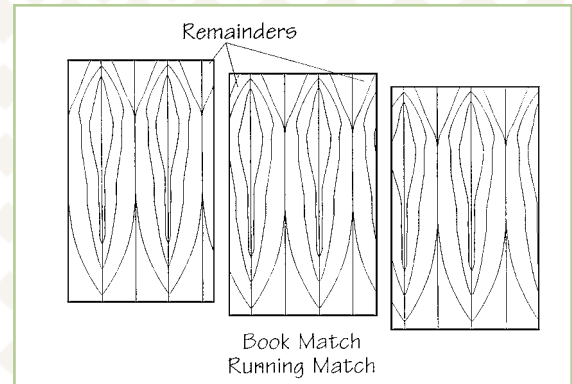
In a Center Balance Match an even number of equal width veneer leaves makes up the panel face. This produces horizontal symmetry. A small amount of figure is lost in the process.

## SPECIAL MATCHES

Special matches can include names such as box, diamond, basket weave, sunburst and reverse diamond, reverse box and checkerboard match. Because there are not standardized names for these matches, it is strongly recommended that the design professional include both names and drawings for the match to be sure the desired match is achieved.

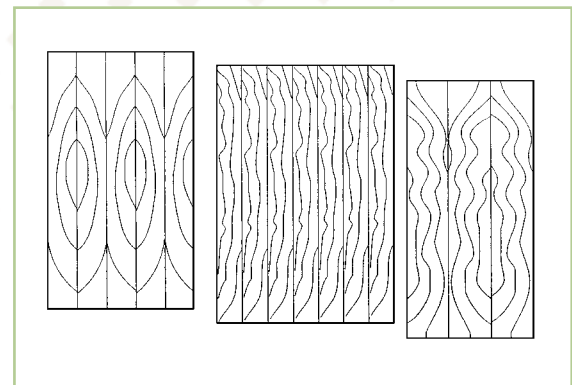
## MATCHING OF SKETCH FACES

In this procedure the layout of veneer follows a sketch or design. These include inlays of various woods, borders, frames, imitations of stiles and rails and curved inlay shapes. The design professional should work closely with the woodworker and veneer supplier to make sure design intentions are realized.



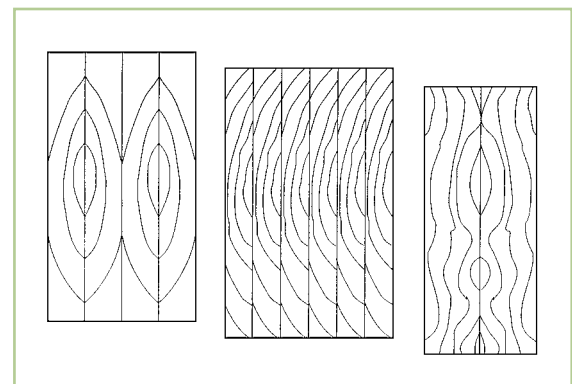
### RUNNING MATCH

Figure 200-20 from AWI Quality Standards, Seventh Edition.



### BALANCE MATCH

Figure 200-21 from AWI Quality Standards, Seventh Edition.



### BALANCE AND CENTER MATCH

Figure 200-22 from AWI Quality Standards, Seventh Edition.



COMMERCIAL AND ARCHITECTURAL  
DOOR MANUFACTURER

10/2008

Used by permission of the  
Architectural Woodwork Institute  
1952 Isaac Newton Square West  
Reston, VA 20190

Phone: 703-733-0600  
Fax: 703-733-0584  
Website: www.awinet.org