

Please call or write with all questions to Mr.Svyat Sytin, Moscow Russia by +7(926)444-4862 or svyatoslav.syтин@yandex.ru (English only)



Glued beam

****Distributor's Price for International Markets is 460 USD for CUB.MTR of GLULAM Profiled Timber in Walls Set Completion of a House Design Project & 500 USD for CUB.MTR of GLULAM Planed Beam in Specialized Engineerd Construction Units by bulk/ wholesale supply !!**

Pallada Eco Blockhaus GmbH,
Moscow Russia

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quotes all prefab kits prices per 460 USD for CUB.MTR of lumber volume in walls set completion of a house design-project (in all available GLULAM timber section cut sizes in manufacturing)

Annual production
volume of glulam logs
prefabricated
houses is

26 000 M³

Annual production
volume of glulam
structures is

42 000 M³

Over 20 years of existence
we implemented over

3 500

projects in Russia
and foreign countries

Sokolsky DOK is one of the largest woodworking enterprises in the northwest of Russia. The plant is located in the city of Sokol, Vologda Region and affiliated with Segezha Group holding company with vertically integrated structure performing full cycle timber logging and advanced wood processing.

**Sokolsy DOK was the first
enterprise in the country to develop
glulam logs manufacturing process.**

The whole process flow of glulam products manufacturing is done using in-house facilities and certified in accordance with European standards. Timber logging facilities of the enterprise are located in the northwest of Russia - Karelia, Arkhangelsk and Vologda regions.

As for today Sokolsky DOK produces glulam structures (glulam beam and glulam log), homasotes in the form of prefabricated houses using various technologies – log and timber-framing, export quality timber and wood briquettes.



Woodworking
since **1942**



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History of SDOK

The enterprise was established on April 15, 1942 in the city of Sokol ashore the Sukhon River by order of N. G. Kuznetsov — Commander in Chief of the USSR Navy.

Production of wooden products for military necessity was organized within the shortest possible time. Almost manual production of 2×2,5 m houses for field power plants, baths, communications centers and command posts began in nailed-up sheds and under the shelters.



Woodworking since

1942

After the War the plant produced prefabricated barracks, storages and houses. Products of DOZ-21 contributed a lot to building of spaceport in Plesetsk and also were supplied to the Arctic and to border troops.

30Over its semicentennial history the plant expanded its product range from prefabricated panelboard structures to products of advanced wood processing. Sokolsky DOK raised a number of labor dynasties, children and grandchildren of veterans of the enterprise work at the plant to the present time.

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Enterprise at the present time

Log yard, saw mill plant, timber drying and processing shop, log house-building shop, frame house and panel house-building shop is located in the area of 23 hectares. Main products at the present time are:

- Glulam structures
- Glulam log houses
- Timber-framing and frame-panel houses
- Timber and planed products for wooden house-building



Perfect quality gluing using modern equipment HFC-press Kallesoe (Denmark), which provides glue line heating at molecular level.



The process flow was modernized in 2012 within the framework of investment project. Modern equipment from Germany, Denmark and Canada is used for the production.

Technology



EN 14080

European certificate

EN 14081

European certificate

High-grade timber is produced on HewSaw R250 series line. The equipment allows performing strict grading, debarking and regular-shaped sawing providing maximum effective use of the wood.

Manufacturing process is in accordance with European certificate EN 14080 and standards GL 24, GL 28, GL 32, and also certificate EN 14081.

MPA certificate granted by the European center in Stuttgart confirms the fact that manufacturing process is not just followed, but constantly monitored by the center specialists.

Materials

WHITE wood

The enterprise uses in-house logging northern pine wood from Vologda, Arkhangelsk regions and Karelia with further reforestation, which is approved by FSC certificate.

RED wood

For the customer it means that only legally cut, high-quality, ecological wood was used for production of glulam.

Short vegetation period is typical for northern latitude makes the wood dense, strong and lightly hygroscopic, which is high value in wood house-building.



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Glulam beam

		width, mm							
		60	80	100	120	140	160	180	200
height, mm	120								
	160								
	200								
	240								
	280								
	320								
	360								
	400								



Maintaining temperature at the level of +20°C and humidity of 60% provides the best conditions for gluing.

Lamellas are glued by length using finger joint (16 mm or 20 mm), which provides «closed joint» – outer side of the workpiece. Lamella may reach 13,5 m/12 m in length.

Shorter workpieces with the length of 5, 6 and 7 meters are also available

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Glulam beam /packing/

GOST 10354

Unitized loads are covered from 6 sides with waterproof polyethylene film (GOST 10354).

Products are shipped in containers by motor and railway transport. Part length at shipping in containers is 12 m, by motor transport – 13.5 m.

Load volume of one eighteen-wheeler or container is 42-43 m³, one railway gondola wagon – 65 m³.



Industrial and visual quality

Quality of external surfaces for glulam beams EN 14080 (machine grading EN 4074)

Criteria	Industrial quality	Visual quality
Healthy knots	Admissible without restrictions	Admissible without restrictions
Light and black knots	Admissible with a diameter of less than 20 mm	Admissible with a diameter less than 5 mm on edges
Knots surrounded with bark	Admissible	Admissible
Pitch pocket	Admissible	Admissible
Wormholes (on the surface)	Admissible	Inadmissible
Pith	Admissible	Admissible
Cracks lengthwise up to 1 m wide	Admissible	Admissible totally up to 1/10 of the board length
Cracks lengthwise more than 1 m wide	Admissible	Inadmissible
Blue stains	Admissible without restrictions	Admissible up to 5% of the visible surface
Chemical colouring	Admissible	Admissible up to 10% of the visible surface
Sprout	Admissible without restrictions	Admissible up to 50 mm long
Rot (hard on the surface)	Admissible	Inadmissible
Mechanical damage	Admissible	Admissible up to 5 mm wide, 50 mm long, not more than 2 for a board
Knots and defects closed with plugs or "boats"	Admissible	Admissible
Cutting quality	Nicks from planning are admissible up to 2 mm	Nicks from planning are admissible deep up to 1 mm deep
	Roughness (partial unplanning) is admissible	Unplaned places are inadmissible

Criteria are based on the surface quality during the delivery
Appropriate storage and logs assembly after the delivery should be guaranteed by the customer
As timber is a natural building material the changes of the above mentioned criteria are possible because of the climatic conditions

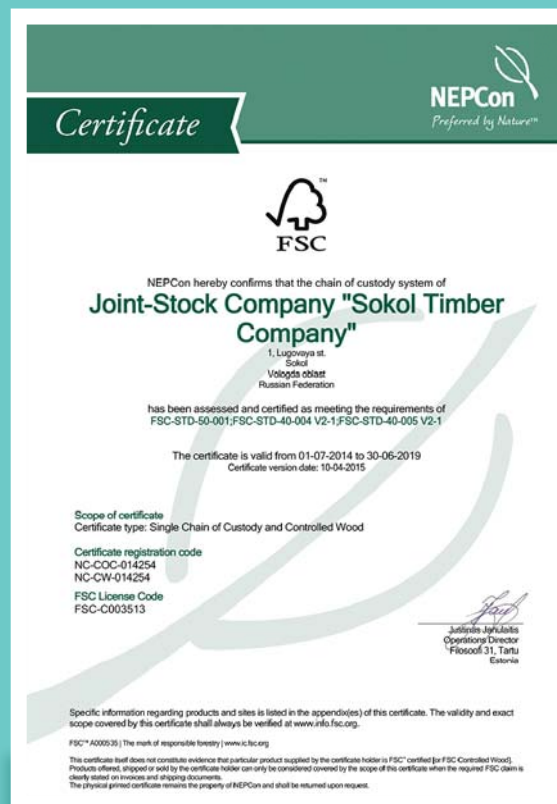
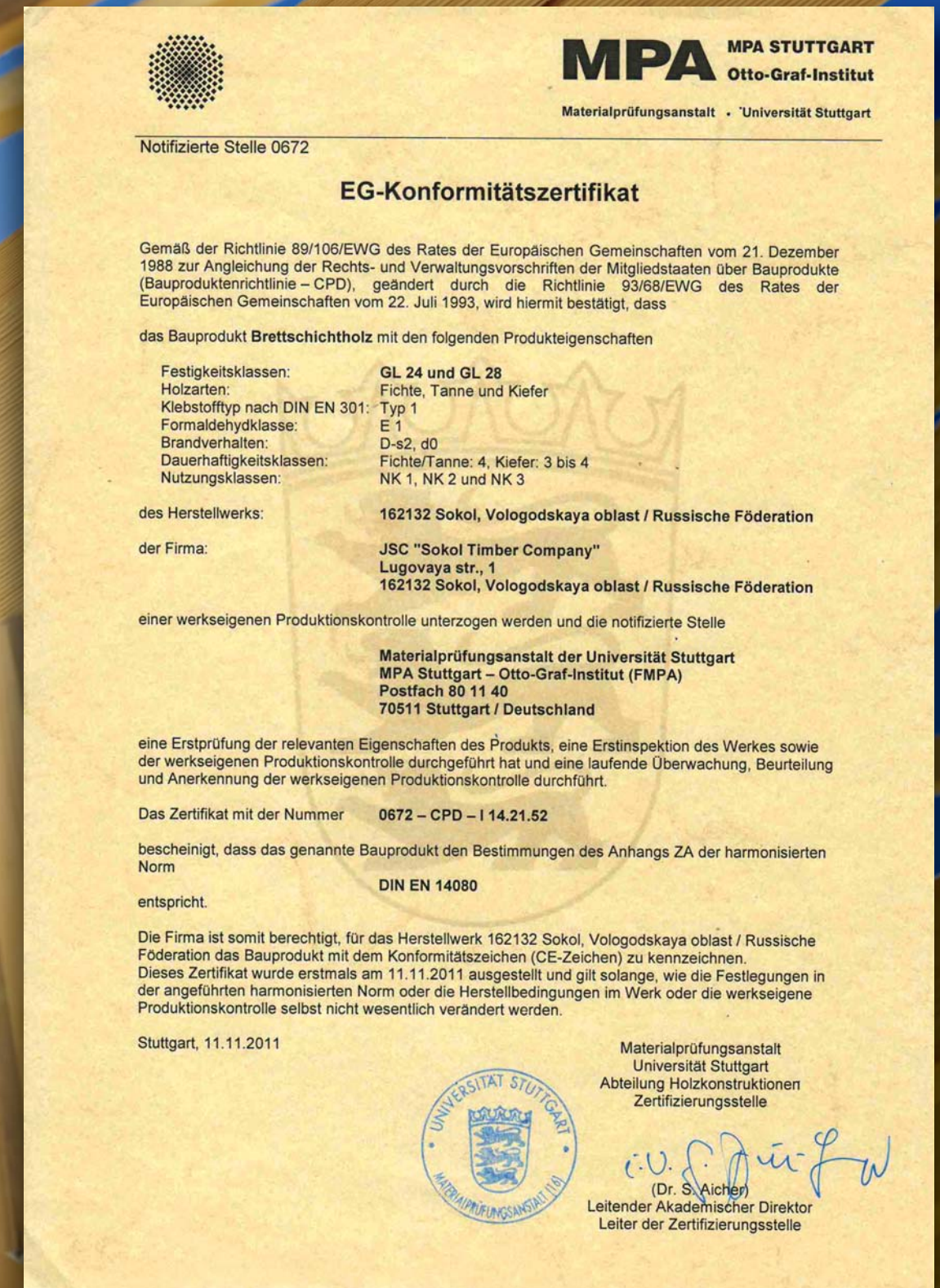
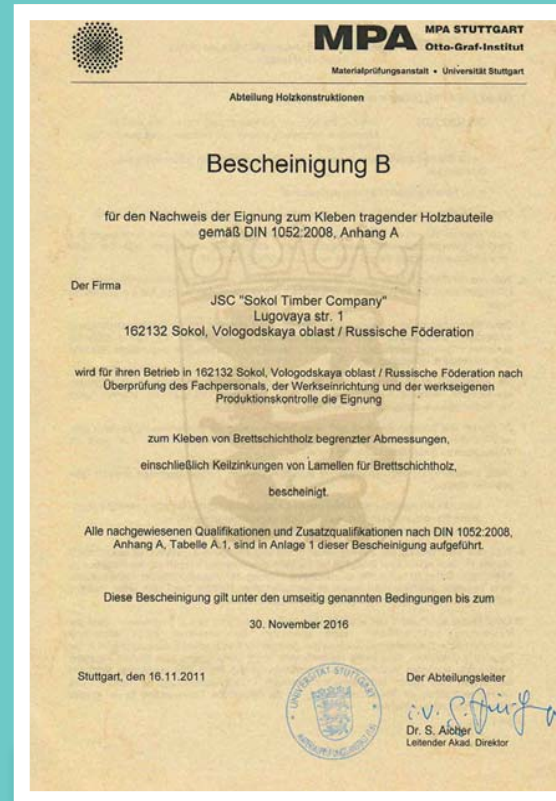
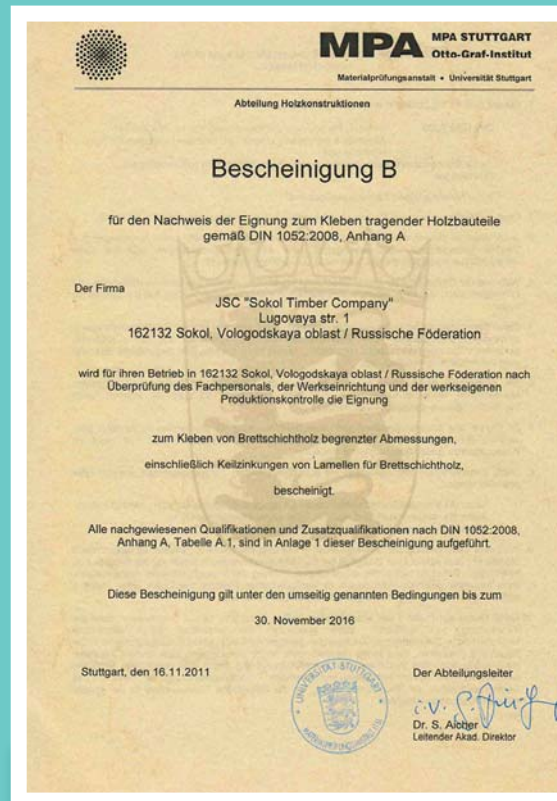
Quality inspection



Timber moisture content and crook check is done using Golden Eay 702 Microtech system with XR module, which performs automatic wood grading by color, laser and X-ray scanning and separates the material by strength grade from C16 to C45 and by visual class.



Certificates



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Russia www.palladaeco.com***

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