A Stride towards industrialization of Tripura

PILAK DOOR FACTORY
Anandanagar, West Tripura.
A Unit of TFDPC Ltd.
(Government of Tripura Undertaking)

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TFDPC Bhavan
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Introduction:-

Rubber plantations have existed for hundreds of years in Tropical countries. These Plantations have been used mainly for the production of latex. After the economic life of the rubber tree, which is generally 30 years, the latex yields become extremely low and the planters then fell the rubber trees and plant new ones. Previously the felled trees were used only as a firewood. But recently it has been found that the rubber wood (*Hevea brasiliensis*) if properly processed can become an excellent substitute for traditional timber. This rubber wood obtained from plantation forestry reduces demand of timber from natural forests. That’s why it is sometimes called “eco-friendly timber”. Treated rubber wood rivals any conventional wood in strength, finish and durability. TFDPC in its modern Plant based on latest technology, adds the advantages of Finger Joining Technology to process the eco-friendly rubber wood, making furniture and finger jointed edge glued panel boards. The panels are manufactured using the sophisticated process of finger jointing and edge gluing. Finger jointing is a modern technology wherein fingers cut at a fibre slop of 1:6 are glued with special resins and then interlocked with pressure. Since the glue area is 6 times the cross section area of the timber, superior strength is achieved. The Panels have uniform texture, clear fibre and unmatched smoothness. They are easy to saw, drill, bore or stain and have excellent nail holding capacity, machinability and glueability.

Physical Properties :-

Rubber wood is a light hardwood. The wood is whitish yellow or pale cream when freshly cut and seasons to light straw or light brown. It is a moderately hard and ‘light to moderately heavy’ timber with density ranging from 435 to 626 kg/m³ at 12% moisture content. It is a diffuse porous wood with medium texture and straight grain. Sapwood and heartwood are not distinct. Occurrence of tension wood seen as white lustrous zones when freshly cut is a characteristic feature of rubber wood.

Weight and Specific Gravity of Rubber Wood:-

Most of the strength properties of wood are related to its specific gravity.

<table>
<thead>
<tr>
<th></th>
<th>Rubber Wood</th>
<th>Standard Teak</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Specific Gravity</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>= Wt. oven dry/Vol. at Test</td>
<td>0.521 Green</td>
<td>0.596 Green</td>
</tr>
<tr>
<td></td>
<td>0.557 Dry</td>
<td>0.604 Dry</td>
</tr>
<tr>
<td><strong>Moisture content, %</strong></td>
<td>81.2</td>
<td>12</td>
</tr>
<tr>
<td></td>
<td>12</td>
<td>76.6</td>
</tr>
<tr>
<td><strong>Weight, kg/m³ at corresponding moisture</strong></td>
<td>944</td>
<td>1056</td>
</tr>
<tr>
<td></td>
<td>624</td>
<td>676</td>
</tr>
</tbody>
</table>
### Tensile Strength:

<table>
<thead>
<tr>
<th>Perpendicular to grain Max. tensile stress, radial</th>
<th>Unit</th>
<th>Rubber Wood M.C. 12%</th>
<th>Average teak from India, M.C. 12%</th>
</tr>
</thead>
<tbody>
<tr>
<td>Neat</td>
<td>kg/cm²</td>
<td>56.7</td>
<td>57.6</td>
</tr>
<tr>
<td>Max. tensile stress, tangential</td>
<td>kg/cm²</td>
<td>62.8</td>
<td>66.4</td>
</tr>
</tbody>
</table>

### Shear Strength:

<table>
<thead>
<tr>
<th>Condition of material (M.C.%)</th>
<th>Maximum Shear strength (kg/cm²)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Radial</td>
<td>Tangential</td>
</tr>
<tr>
<td>Rubberwood Dry (12%)</td>
<td>107.7</td>
</tr>
<tr>
<td></td>
<td>119.5</td>
</tr>
<tr>
<td></td>
<td>113.1</td>
</tr>
<tr>
<td>Teak Dry (12%)</td>
<td>96.6</td>
</tr>
<tr>
<td></td>
<td>108.0</td>
</tr>
<tr>
<td></td>
<td>102.3</td>
</tr>
</tbody>
</table>

### Bending Properties:

<table>
<thead>
<tr>
<th>Units</th>
<th>Dry M.C.12%</th>
</tr>
</thead>
<tbody>
<tr>
<td>Rubber Wood</td>
<td>Indian Teak</td>
</tr>
<tr>
<td>STATIC CONDITION - Fibre stress at elastic limit</td>
<td>Kg/cm²</td>
</tr>
<tr>
<td>Modulus of Elasticity</td>
<td>1000 kg/cm²</td>
</tr>
<tr>
<td>Modulus of Rupture</td>
<td>Kg/cm²</td>
</tr>
<tr>
<td>DYNAMIC CONDITION - Fibre stress at elastic limit</td>
<td>kg/cm²</td>
</tr>
<tr>
<td>Modulus of Elasticity</td>
<td>1000 kg/cm²</td>
</tr>
<tr>
<td>Max. height of drop of 25 kg hammer</td>
<td>Cm</td>
</tr>
</tbody>
</table>
Hardness on Different Surfaces:-

Hardness of the wood is very important for applications like flooring and decking where abrasion of surfaces is taking place. The table below gives the hardness as measured by indentation of a steel ball. It can be seen that dry rubber wood has better hardness than teak.

<table>
<thead>
<tr>
<th>Species and locality</th>
<th>Condition of material (M.C.%)</th>
<th>Radial</th>
<th>Tangential</th>
<th>End</th>
<th>Average</th>
</tr>
</thead>
<tbody>
<tr>
<td>Rubber Wood</td>
<td>Dry (12%)</td>
<td>549</td>
<td>526</td>
<td>627</td>
<td>567</td>
</tr>
<tr>
<td>Teak</td>
<td>Dry (12%)</td>
<td>502</td>
<td>524</td>
<td>488</td>
<td>505</td>
</tr>
</tbody>
</table>

Note: Indentation is measured as load in kg required to embed a steel ball of diameter 1.28 cm to a depth equal to half its diameter.

Sawing, Machining, Working and Finishing Properties:-

Rubber wood is easy to work in sawing and machining. Rubber wood has good machining and working qualities. It can be finished to a very glossy look on polishing and can be given ammonia fumigation cum bark extract -quenching treatment to obtain golden to dark brown hues and decorative figures. Rubber wood can be bent in steam or in ammonia to make curved items. It takes up stains well and being light in color, it can be stained to the shades of teak, rosewood, mahogany, beech, cherry etc.

Working Qualities:-

<table>
<thead>
<tr>
<th>Species</th>
<th>Overall performance</th>
<th>Ease of working</th>
<th>Working quality index</th>
<th>Comparative performance in turning</th>
</tr>
</thead>
<tbody>
<tr>
<td>Rubber Wood</td>
<td>194</td>
<td>100</td>
<td>131</td>
<td>101</td>
</tr>
<tr>
<td>Teak</td>
<td>100</td>
<td>100</td>
<td>100</td>
<td>100</td>
</tr>
</tbody>
</table>

Nail and Screw Holding Strength:-

Rubber wood offers good resistance to Screw and Nail withdrawal forces as can be seen below.

<table>
<thead>
<tr>
<th>Species and locality</th>
<th>Testing Condition</th>
<th>Radial Surface</th>
<th>Tangential Surface</th>
<th>Average on side</th>
<th>End Surface</th>
</tr>
</thead>
<tbody>
<tr>
<td>Average teak from India</td>
<td>Green</td>
<td>116</td>
<td>135</td>
<td>126</td>
<td>81</td>
</tr>
</tbody>
</table>
Comparative Suitability Analysis of Rubber Wood with Teak:-

**Rubberwood & Teakwood - Comparative Table**

<table>
<thead>
<tr>
<th></th>
<th>Teak Wood</th>
<th>Treated Rubber wood</th>
</tr>
</thead>
<tbody>
<tr>
<td>Specific gravity</td>
<td>0.604</td>
<td>0.557</td>
</tr>
<tr>
<td>Weight (kg / cum)</td>
<td>676</td>
<td>624</td>
</tr>
<tr>
<td>Compression</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Perpendicular to the</td>
<td>101</td>
<td>101</td>
</tr>
<tr>
<td>Grains (Kg / Cm²)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Permissible stress</td>
<td>153</td>
<td>126</td>
</tr>
<tr>
<td>Along the grains</td>
<td></td>
<td></td>
</tr>
<tr>
<td>(Kg / cm²)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Rate per Cu. Ft (Rs)</td>
<td>1500</td>
<td>720</td>
</tr>
</tbody>
</table>

**Comparative cost of rubber wood doors and teak doors**

<table>
<thead>
<tr>
<th>Type of Door</th>
<th>Rate per piece of different sizes</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>7ft x 2.25ft</td>
</tr>
<tr>
<td>Teak solid door</td>
<td>Rs 13000-</td>
</tr>
<tr>
<td></td>
<td>Rs 16500</td>
</tr>
<tr>
<td>Rubber solid door</td>
<td>Rs 8500-</td>
</tr>
<tr>
<td></td>
<td>Rs 10500</td>
</tr>
<tr>
<td>Rubber Skin door</td>
<td>Rs 3300-</td>
</tr>
<tr>
<td></td>
<td>Rs 6000</td>
</tr>
</tbody>
</table>
Advantages of using rubber wood doors from TFDPC Ltd.

- The rubber wood is chemically treated through boric acid and borax in chemical treatment plant which makes the rubber wood resistant to attack of termites and borers.

- The rubber wood is heat treated in seasoning kilns thus reducing the moisture content to desired minimum levels.

- CNC (Computer Numerically Controlled) Router is a most equipped and modernized router which is well designed for wood cutting, routing, engraving, sawing and planning as per loaded programmes and designs. It is also equipped with 3D linear interpolation and 3D circular interpolation. The machine is equipped with selective router heads to satisfy customer production requirements and provides excellent finishing which is far superior than manual finishing.

- The doors and panels are manufactured using the latest technologies and upgraded machines.

- Though of superior quality, the doors and panels manufactured from treated rubber wood are far cheaper than doors made of traditional timber species like teak, gamair etc.

- The rubber wood is obtained from plantation forestry and as such it reduces demand of timber from natural forests. That’s why it is sometimes also called “eco-friendly timber”.

THE MANUFACTURING PROCESS
Production of solid and skin doors from treated and seasoned rubber wood boards.

Treated Rubber wood lamina and boards

Double side planner  Chain Cheil  Single end Tenoning Machine  Moulding machine

Cutting, Framing & Moulding unit

Assembled Doors & Windows

Wide Belt Sanding Machine

Assembling Machine

Final sanding and Polishing

CNC (Computer Numerically Controlled) Router
Most equipped & modernised router.
Well designed for wood cutting, routing, boring, engraving, sawing & planning as per loaded programme & designs. 3D linear interpolation & 3D circular interpolation present. The machine is equipped with selected router heads to satisfy customer production requirements.

Uneven Sanding Machine  Beam Saw

Spray Painting (Spray Booth)

Finished Skin Doors and Solid Doors
  - High quality
  - Superior Machine finishing
  - Long lasting & Durable
  - Low cost & Eco-friendly
  - Wide range of colours & designs
**Model**: SKIN-MMP3P-O-2.25. **Finish**: TEAK SAPELI. **Description**: Skin door MELAMINE moulded 3 panel oval shape teak/sapeli colour 2.25 ft x 7 ft height of thickness 35 mm filled with treated and seasoned rubber wood. **Rate**: Rs 3,306/ piece, Rs 210/sq ft.
2.75 ft x 7 ft height of thickness 35 mm - Rate Rs 3,746/ piece, Rs 195/sq ft.
3.25 ft x 7 ft height of thickness 35 mm - Rate Rs 4,141/ piece, Rs 182/sq ft.
3.5 ft x 7 ft height of thickness 35 mm - Rate Rs 4,361/ piece, Rs 178/sq ft.

*Price is Ex-factory price.
*Tax will be realized as applicable during the time of sale.
*The rate is only indicative. It can vary at the time of sale.
Model- SKIN-PT3P-O-2.75. Finish-BI-COLOUR. Description-skin door 2.75 ft x 7 ft height of thickness 35 mm filled with treated and seasoned rubber wood. Rate- Rs 7,123/ piece, Rs 370/sq ft.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
**Model:** SKIN-MF2P-C-2.75. **Finish:** Wenge & Dougluspine. **Description:** skin door MELAMINE flush 2 panel combo wenge & dougluspine colour 2.75 ft x 7 ft height of thickness 35 mm filled with treated and seasoned rubber wood. **Rate:** Rs 3,715/ piece, Rs 193/sq ft.

3.25 ft x 7 ft height of thickness 35 mm - Rate Rs 4,130/ piece, Rs 182/sq ft.
3.5 ft x 7 ft height of thickness 35 mm - Rate Rs 4,298/ piece, Rs 175/sq ft.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
Model- SKIN-MM4P-C- 2.75. Finish- Mehagoni. Description- 2.75 ft x 7 ft height of thickness 35 mm filled with treated and seasoned rubber wood. Rate- Rs 3,746/ piece, Rs 195/sq ft.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
Model: SKIN-PT3P-O-M 2.25. Finish: White primer. Description: Veener Skin Door 3 panel without varnish 2.25 ft x 7 ft height of thickness 35 mm filled with treated and seasoned rubber wood. Rate: Rs 4,454/piece, Rs 283/sq ft.

2.75 ft x 7 ft height of thickness 35 mm - Rate Rs 5,123/piece, Rs 266/sq ft.
3.25 ft x 7 ft height of thickness 35 mm - Rate Rs 5,804/piece, Rs 255/sq ft.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
**Model**- SKIN-PT3P-O-M 2.75. **Finish**- Mehagoni. **Description**- Veener Skin Door 3 panel Mehagoni 2.75 ft x 7 ft height of thickness 35 mm filled with treated and seasoned rubber wood. **Rate**- Rs 4,454/ piece, Rs 283/sq ft.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
Model-SKIN-FLUSH-2.75. Finish-RAW. Description- Raw Flush Skin Door 2.75 ft x 7 ft height of thickness 35 mm filled with treated and seasoned rubber wood. Rate- Rs 3,088/ piece, Rs 160/sq ft.

3.25 ft x 7 ft height of thickness 35 mm - Rate Rs 3,421/ piece, Rs 150/sq ft.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
Model-SKIN-MM2P 2.75 x 7 ft of thickness. Finish- White primer. Description- Veener Skin Door 2 panel without varnish 2.75 ft x 7 ft height of thickness 35 mm filled with treated and seasoned rubber wood. Rate- Rs 5,123/ piece, Rs 266/sq ft.

*L Price is Ex-factory price.
*Tax will be realized as applicable during the time of sale.
*The rate is only indicative. It can vary at the time of sale.
Model-SKIN-MM6P 2.75 X7 ft of thickness 35 mm. **Finish**- Mehagoni. **Description**- 2.75 ft x 7 ft height of thickness 35 mm filled with treated and seasoned rubber wood. **Rate**- Rs 3,746/ piece, Rs 195/sq ft.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
Model-SKIN-MMP3P-O-3.25. Finish-TEAK SAPELI. Description- skin door MELAMINE moulded 3 panel oval shape teak/sapeli colour 3.25 ft x 7 ft height of thickness 35 mm filled with treated and seasoned rubber wood. Rate- Rs 4,141/ piece, Rs 182/sq ft.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
Model-SKIN-MMP3P-O-2.75. Finish-TEAK SAPELI. Description- skin door MELAMINE moulded 3 panel oval shape teak/sapeli colour 2.75 ft x 7 ft height of thickness 35 mm filled with treated and seasoned rubber wood. Rate- Rs 3,746/ piece, Rs 195/sq ft.

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Model-Solid-S-C-35-2.75. Finish- Bi colour Mehagoni. Description- 35 mm panel en grooved in 35 mm frame 7 ft x 2.75 ft single shutter double side design colour varnish. Rate- Rs 8,650/piece & Rs 449/Sq ft + Rs 2000 (for Bi-colour).

2.25 ft x 7 ft height of thickness 35 mm - Rate Rs 7,300/ piece, Rs 463/sq ft + Rs 2000 (for Bi-colour)
3.25 ft x 7 ft height of thickness 35 mm - Rate Rs 10,060/ piece, Rs 442/sq ft + Rs 2000 (for Bi-colour)
3.75 ft x 7 ft height of thickness 35 mm - Rate Rs 11,470/ piece, Rs 437/sq ft + Rs 2000 (for Bi-colour)

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Model-Solid-S-C-35-2.75. Finish- Bi colour Mehagoni. Description- 35 mm panel en grooved in 35 mm frame 7 ft x 2.75 ft single shutter double side design colour varnish. Rate-Rs 8,650/piece & Rs 449/Sq ft + Rs 2000 (for Bi-colour).

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* Price is Ex-factory price.
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Model-Solid-S-C-25-2.75. Finish- Mehagoni. Description- 25 mm panel en grooved in 35 mm frame 7 ft x 2.75 ft single shutter single side design colour varnish. Rate-Rs 7,440/piece & Rs 386/Sq ft.
2.25 ft x 7 ft height of thickness 35 mm - Rate Rs 6,320/ piece, Rs 401/sq ft.
3.25 ft x 7 ft height of thickness 35 mm - Rate Rs 8,620/ piece, Rs 379/sq ft.
3.75 ft x 7 ft height of thickness 35 mm - Rate Rs 9,810/ piece, Rs 374/sq ft.

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Model-Solid-S-C-35-3.25. **Finish**- Mehagoni Bi-colour. **Description**- 35 mm panel en grooved in 35 mm frame 7 ft x 3.25 ft single shutter double side design colour varnish. **Rate**- Rs 10,060/piece & Rs 442/Sq ft. + Rs 2000 (for Bi-colour).

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* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
Model-Solid-S-C-25-2.75. Finish- Mehagoni. Description- 25 mm panel en-grooved in 35 mm frame 7 ft x 2.75 ft single shutter single side design colour varnish. Rate-Rs 7,440/piece & Rs 386/Sq ft.

2.25 ft x 7 ft height of thickness 35 mm - Rate Rs 6,320/piece, Rs 401/sq ft.
3.25 ft x 7 ft height of thickness 35 mm - Rate Rs 8,620/piece, Rs 379/sq ft.
3.75 ft x 7 ft height of thickness 35 mm - Rate Rs 9,810/piece, Rs 374/sq ft.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
Model-Solid-S-C-35-2.75 (Bi colour) with frame DF-M-3 Finish- Black. Description- 35 mm panel en-grooved in 35 mm frame 7 ft x 2.75 ft single shutter double side design colour varnish. Rate - Rs 8,650/piece, Rs 449/Sq ft + Rs 2000 (for Bi-colour)

Frame-DF-M-3.5-Mehagoni-Door frame with mehagoni colour 7ft x 3.5 ft made of 3 inches x 4 inches treated rubber timber – Rs 2416.00/piece.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
Model-Solid-S-C-35-3.75. Finish- Black. Description- 35 mm panel en-grooved in 35 mm frame 7 ft x 3.75 ft single shutter double side design colour varnish. Rate- Rs 11,470/piece & Rs 437/Sq ft + Rs 2000 (for Bi-colour).

2.25 ft x 7 ft height of thickness 35 mm - Rate  Rs 7,300/ piece, Rs 463/sq ft + Rs 2000 (for Bi-colour)
2.75 ft x 7 ft height of thickness 35 mm - Rate  Rs 8,650/piece , Rs 449/Sq ft + Rs 2000 (for Bi-colour)
3.25 ft x 7 ft height of thickness 35 mm - Rate  Rs 10,060/ piece, Rs 442/sq ft + Rs 2000 (for Bi-colour)

* Price is Ex-factory price.
*Tax will be realized as applicable during the time of sale.
*The rate is only indicative. It can vary at the time of sale.
Model-Solid-S-C-25-2.75. Finish- Mehagoni. Description- 25 mm panel en-grooved in 35 mm frame 7 ft x 2.75 ft single shutter single side design colour varnish. Rate- Rs 7,440/piece & Rs 386/Sq ft.

Frame-DF-M-3.5-Mehagoni-Door frame with mehagoni colour 7ft x 3.5 ft made of 3 inches x 4 inches treated rubber timber – Rs 2416.00/piece.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
Model- SKIN-PT3P-O-M 2.75. Finish- Mehagoni. Description- Veener Skin Door 3 panel Mehagoni 2.75 ft x 7 ft height of thickness 35 mm filled with treated and seasoned rubber wood. Rate- Rs 4,454/piece, Rs 283/sq ft.

Frame-DF-M-3.5-Mehogoni- Door frame with Mehogoni colour 7ft x 3ft made of 3 inches x 4 inches treated rubber timber- Rs 2,343/piece.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
Model-Frame-DF-P-3-Primer- Door frame with one coat of primer 7ft x 3ft made of 3 inches x 4 inches treated rubber timber. Rate - Rs 2,088/piece.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.
Model-Frame-DF-M-3.5-Mehogoni- Door frame with Mehogoni colour 7ft x 3ft made of 3 inches x 4 inches treated rubber timber. Rate - Rs 2,343/piece.

* Price is Ex-factory price.
* Tax will be realized as applicable during the time of sale.
* The rate is only indicative. It can vary at the time of sale.

Prepared and designed by Sumit Deb (ACF), TFDPC Ltd, Agartala, Tripura West.