

Product Range



The company

The family-owned company, which was founded in Winterberg-Züschen in 1927 by Josef Ante, is now managed in the 3rd and 4th generation. The **ante**-group, employs over 850 employees at four production facilities in Germany and Poland, delivering state-of-the-art products globally.

The **ante** product range is divided into five divisions: into five divisions: sawn timber, engineered wood (glulam beams (BSH) and structural solid timber (KVH®)), precision trimming, and house and garden products, such as playing equipment, furniture, fences or panels. Besides that, **ante** produces wood pellets made of wood shavings and sawdust. In this way, **ante** processes nearly 100% of the sustainable resource wood.

Highly motivated employees and high tech precision machines assure high quality standards in all sectors. With multiple international certificates, such as PEFC, DIN Plus, **CE** etc. **ante** is prepared to meet the demands of the international markets.

Versatility is our strength.

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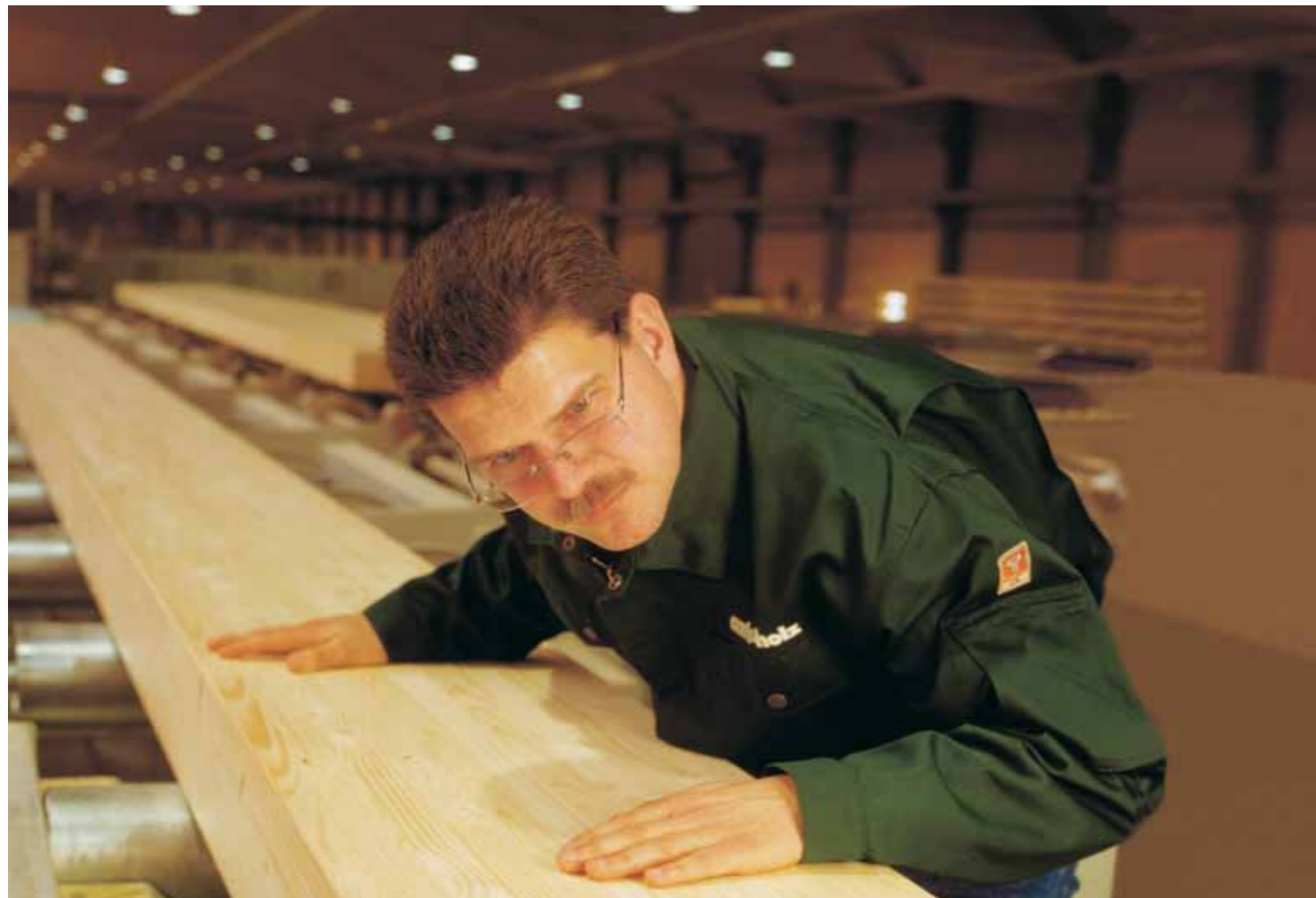
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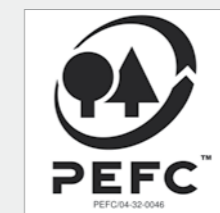
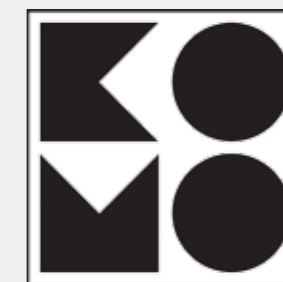
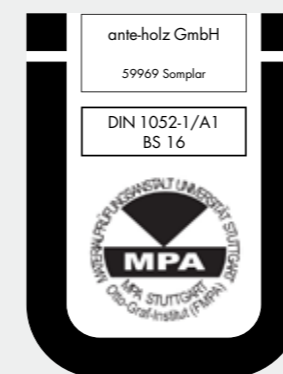
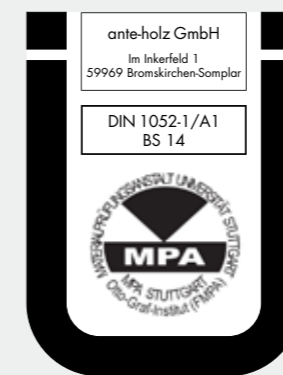
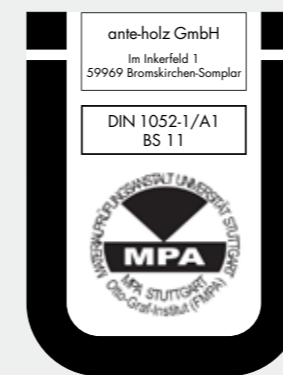


Product description of Glulam beams (BSH)

Glulam grading of commodities:	BS 11/14/16 according to DIN 1052
Glulam strength grade:	GL 24/28/32 according to EN 14080
Production:	according to DIN 1052-1/A1/EN 14080
Finger-joints:	according to DIN 68140/EN 385
Wood sorting grade:	according to DIN 4074/EN 338
Wood species:	Spruce and Pine
Lamella thickness:	40 mm
Glue:	Melamine, clear - the line between lamellas does not darken. Application according to DIN 68141, EN 302, EN 301, Type 1 weather resistance according to usage classification I and II
Surface:	All 4 sides planed twice for an extra smooth surface, visible and non-visible quality
Edges:	chamfered 4 sides
Packaging:	individually wrapped in white shrink wrap, UV resistant
Control agency:	MPA, Stuttgart (Germany), Holzforschung Austria, Vienna (Austria) and KOMO (Netherlands)
Custom-made products:	max. dimension 24 x 60 cm and max. length 18 m



Certificates



Range of glulam beams (BSH)

Stock list glulams, DIN 1052/EN14080
BS 11/GL 24, surface in visible quality

	PPP 12,00 m	PPP 13,50 m	PPP 16,50 m
6 x 12 cm	40	40	-
6 x 14 cm	32	32	-
6 x 16 cm	24	24	-
8 x 10 cm	36	36	-
8 x 12 cm	30	30	-
8 x 14 cm	24	24	-
8 x 16 cm	24	24	-
8 x 20 cm	18	18	-
10 x 10 cm	30	30	-
10 x 12 cm	25	25	-
10 x 14 cm	20	20	-
10 x 16 cm	15	15	-
10 x 20 cm	15	15	15
10 x 24 cm	10	10	10
12 x 12 cm	20	20	-
12 x 14 cm	16	16	-
12 x 16 cm	12	12	-
12 x 20 cm	12	12	12
12 x 24 cm	8	8	8
12 x 28 cm	8	8	8
12 x 32 cm	4	4	4
14 x 14 cm	12	12	-
14 x 20 cm	9	9	9
14 x 24 cm	6	6	6
14 x 28 cm	6	6	6
14 x 32 cm	4	4	4
16 x 16 cm	9	9	-
16 x 20 cm	4	4	4
16 x 24 cm	4	4	4
16 x 28 cm	4	4	4
16 x 32 cm	2	2	2
16 x 36 cm	2	2	2
16 x 40 cm	2	2	2



	PPP 12,00 m	PPP 13,50 m	PPP 16,50 m
18 x 18 cm	4	4	-
18 x 24 cm	4	4	4
18 x 28 cm	4	4	4
18 x 32 cm	2	2	2
18 x 36 cm	2	2	2
18 x 40 cm	2	2	2
20 x 20 cm	4	4	-
20 x 28 cm	4	4	4
20 x 32 cm	2	2	2
20 x 36 cm	2	2	2
20 x 40 cm	2	2	2
20 x 44 cm	2	2	2



Vertical Tongue and Groove glulam beams (BSH)

according to DIN 1052/EN14080



Gross height (mm)	effective height (mm)	width (mm)	length (m)	Tongue and Groove quantity
160	140	100	13,5	2
160	140	120	13,5	3
200	180	100	13,5	2
200	180	120	13,5	3
200	180	140	13,5	3
240	220	120	13,5	3
240	220	140	13,5	3

Horizontal Tongue and Groove glulam beams (BSH)

Gross width non visible +15mm, Gross width visible +20mm

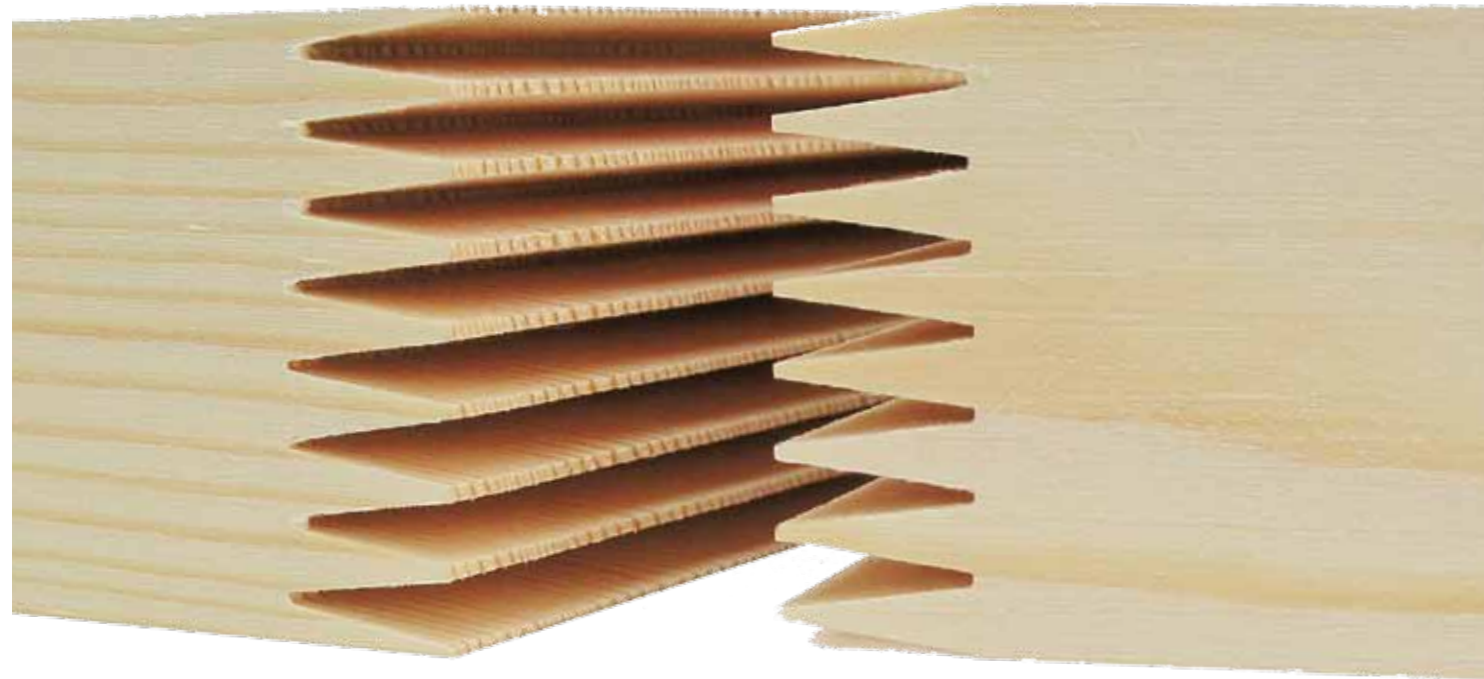
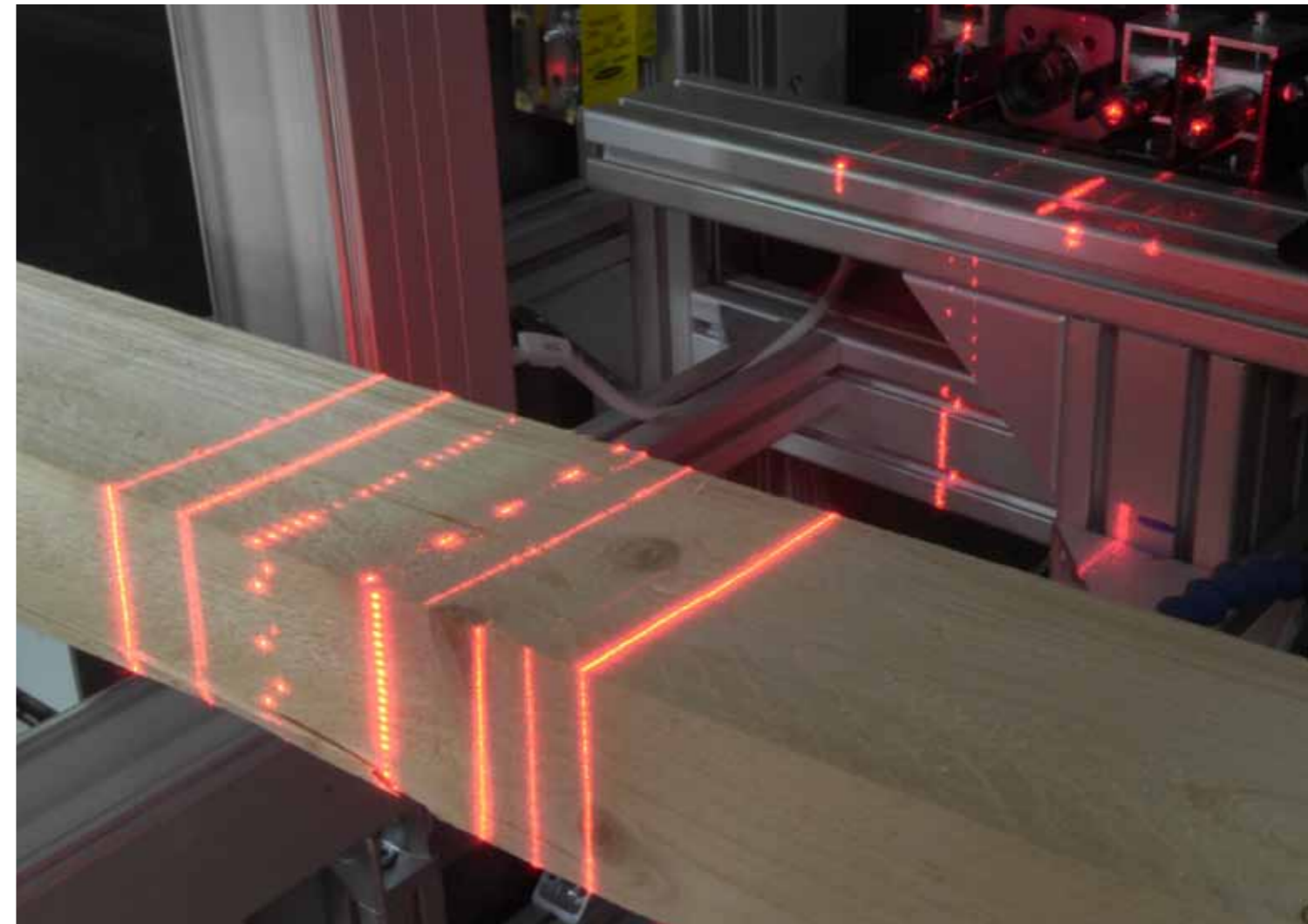


Height (mm)	Effective width (mm)	Length (m)	Tongue and Groove quantity
80	140 – 580	6,00 – 18,00	2
100	140 – 580	6,00 – 18,00	2
120	140 – 580	6,00 – 18,00	3
140	180 – 580	6,00 – 18,00	3
160	180 – 580	6,00 – 18,00	3
180	220 – 580	6,00 – 18,00	3
200	220 – 580	6,00 – 18,00	3
220	260 – 580	6,00 – 18,00	3
240	260 – 580	6,00 – 18,00	3



Product description of structural solid timber (KVH®)

Production:	according to DIN 1052-1
Finger-joints:	according to DIN 68140-1/EN 385
Grading:	machine strength graded according to DIN 4074/EN 338/S10/C 24M
Glue:	finger-joints glued with Polyurethane, according to DIN 68141/EN 302, EN 301, type 1 weather resistance according to usage classification I and II
Wood species:	Spruce and Pine
Surface:	surfaced 4 sides, non-visible quality
Edges:	chamfered 4 sides
Packaging:	Wrapped per package in white shrink wrap, UV resistant
Control agency:	MPA, Stuttgart (Germany), Holzforschung Austria, Vienna (Austria) and KOMO (Netherlands)



Certificates



Range of structural solid timber (KVH®)

DIN 4074/S10/C24/C24M, DIN 1052-1/A1, DIN 68140-1

	PPP 5 m	PPP 7 m + 7,5 m 8 m + 8,5 m	PPP 9 m + 9,5 m 10 m	PPP 13 m
4 x 6 cm	324	-	-	-
4 x 8 cm	252	-	-	-
4 x 10 cm	198	-	-	-
4 x 12 cm	162	-	-	-
4 x 16 cm	126	-	-	-
4 x 20 cm	100	-	-	-
4,5 x 9,5 cm	-	-	-	77
4,5 x 12 cm	-	-	-	63
4,5 x 14,5 cm	-	-	-	56
4,5 x 22 cm	-	-	-	35
6 x 6 cm	216	-	-	-
6 x 8 cm	168	-	-	84
6 x 10 cm	132	-	-	77
6 x 12 cm	108	-	-	63
6 x 14 cm	96	-	-	56
6 x 16 cm	84	63	-	49
6 x 18 cm	72	54	42	42
6 x 20 cm	60	45	35	35
6 x 22 cm	-	-	-	30
6 x 24 cm	-	-	24	24
6 x 26 cm	-	-	-	24
8 x 8 cm	126	-	-	70
8 x 10 cm	99	-	-	55
8 x 12 cm	81	-	-	45
8 x 14 cm	72	-	-	40
8 x 16 cm	63	49	35	35
8 x 18 cm	-	42	30	30
8 x 20 cm	-	35	25	25
8 x 22 cm	-	-	-	25
8 x 24 cm	-	-	20	20
8 x 26 cm	-	-	-	20



	PPP 5 m	PPP 7 m + 7,5 m 8 m + 8,5 m	PPP 9 m + 9,5 m 10 m	PPP 13 m
10 x 10 cm	77	-	-	44
10 x 12 cm	-	-	-	36
10 x 14 cm	-	-	-	32
10 x 16 cm	-	-	-	28
10 x 18 cm	-	-	-	24
10 x 20 cm	-	25	20	20
10 x 22 cm	-	-	-	20
10 x 24 cm	-	-	16	16
10 x 26 cm	-	-	-	16
12 x 12 cm	54	-	-	27
12 x 14 cm	-	-	-	24
12 x 16 cm	-	-	-	21
12 x 18 cm	-	-	-	18
12 x 20 cm	-	-	-	15
12 x 22 cm	-	-	-	15
12 x 24 cm	-	-	-	12
12 x 26 cm	-	-	-	12
14 x 14 cm	-	-	-	21
14 x 16 cm	-	-	-	21
14 x 18 cm	-	-	-	18
14 x 20 cm	-	-	-	15
14 x 22 cm	-	-	-	15
14 x 24 cm	-	-	-	12
14 x 26 cm	-	-	-	12
16 x 16 cm	-	-	-	21



Requirements of structural solid timber (KVH®)

According to the monitoring regulations and the agreement between the federation of German carpenters (BDZ) and the German monitoring community Überwachungsgemeinschaft Konstruktionsvollholz e.V.

Characteristic	KVH® requirements	Comments
Grade/strength class	DIN 4074/EN 338 Minimum grade S 10TS/C 24	The material properties that determine strength are indicated in DIN 1052/EN 14080.
Wood moisture content	15% ± 3%	The defined wood moisture content is the precondition for applications where chemical wood preservative should not be used as far as possible. It can also be the precondition for the production of finger-joint connections.
Type of conversion	heart disjoined	heart disjoined: Since the pith in the clean bole does not always run through the middle, split-heart is defined as follows: In an ideally formed clean bole the pith is cut through when converted from both sides. Free of heart: Core plank of at least 40 mm in thickness.
Wane	Measured at an angle ≤ 10% of the smaller cross section side	–
Dimensional tolerance of the cross section	DIN EN 336 dimensional tolerance class 2	The dimensional tolerance for the longitudinal dimension is to be agreed between the supplier and customer
Knot condition	DIN 4074/EN 338 Grade S 10/C 24	–

Characteristic	KVH® requirements	Comments
Knot size	S 10/C 24: A ≤ 2/5 S 13: A ≤ 1/5 not over 70 mm	Knot size A is determined according to DIN 4074/EN 338 For machine-based grading the following applies: <ul style="list-style-type: none"> • for KVH® NSi (non-visual) the sizes of the knots are irrelevant. • for KVH® Si (visual): A ≤ 2/5
Ingrown bark	DIN 4074/EN 338	–
Splits, radial shrinkage splits (drying splits)	DIN 4074/EN 338	–
Resin pockets	-	–
Discoloration	DIN 4074/EN 338	–
Insect attack	DIN 4074/EN 338	For Si (visual) increased requirements in comparison to grade S 10/C 24 according to DIN 4074/EN 338.
Twisting	–	The permissible degree of Twisting is not defined in any more detail since no unacceptable degrees of twisting are to be expected if all other criteria are met.
Longitudinal Warping	For split-heart cutting ≤ 8 mm/2 m	By comparison: DIN 4074/EN 338, S 10/C 24 and S 13: ≤ 8 mm/2m
Working of the end	trimmed at right angle	–
Surface finish	Sized and chamfered 4 sides	–
Finger-joints	DIN 68140/EN 385	–





Range of DIY

Structural solid timber (KVH®), S4S, chamfered 4 sides

	PPP 2,50 m	PPP 3,00 m	PPP 4,00 m	PPP 5,00 m
40 x 60 mm	–	216	216	216
60 x 60 mm	–	144	144	144
60 x 80 mm	112	112	112	112
60 x 100 mm	88	88	88	88
60 x 120 mm	72	72	72	72
60 x 160 mm	56	56	56	56
60 x 200 mm	–	60	60	60
80 x 120 mm	54	54	54	54
80 x 160 mm	–	42	42	42
100 x 100 mm	55	55	55	55
100 x 140 mm	–	40	40	40
100 x 200 mm	–	–	25	25
120 x 120 mm	36	36	36	36

Framing timber, S4S, chamfered 4 sides, KD

	PPP 2,00 m	PPP 2,50 m	PPP 3,00 m
24 x 45 mm	–	72	72
24 x 75 mm	–	56	56
24 x 95 mm	–	44	44
35 x 55 mm	54	54	54
45 x 45 mm	40	40	40
45 x 75 mm	–	30	30
45 x 95 mm	–	20	20
55 x 55 mm	40	40	40
70 x 70 mm	42	42	42
75 x 75 mm	–	28	28
90 x 90 mm	33	33	33

Planned boards, S4S, chamfered 4 sides, KD

	PPP 2,00 m	PPP 2,50 m	PPP 3,00 m
18 x 80 mm	180	180	180
18 x 100 mm	150	150	150
18 x 120 mm	120	120	120
18 x 140 mm	105	105	105
18 x 200 mm	60	60	–

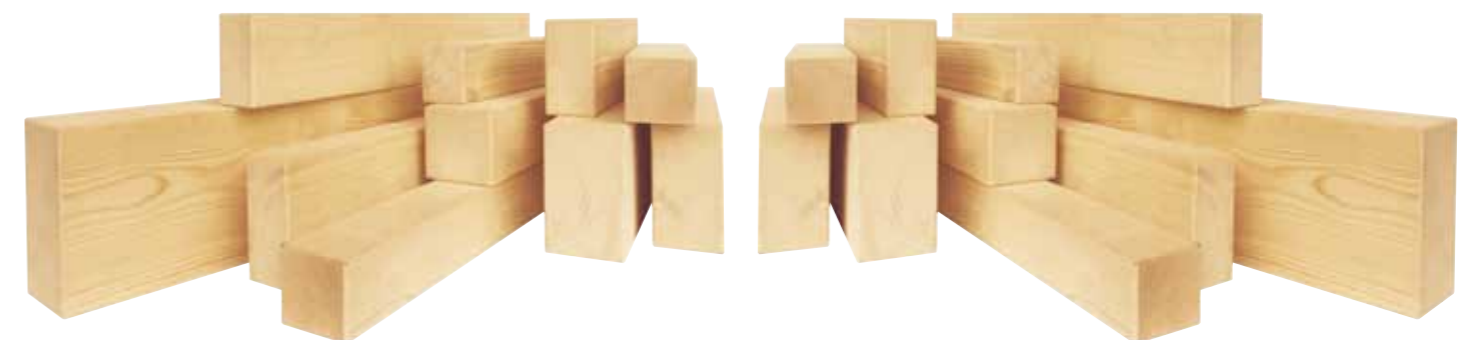
Universally usable boards, S4S, chamfered 4 sides, KD

	PPP 2,00 m	PPP 2,50 m	PPP 3,00 m
27 x 145 mm	49	49	49
27 x 174 mm	60	60	60

Battens, S4S, square edged, KD

	PPP 2,00 m	PPP 2,50 m	PPP 3,00 m
17 x 36 mm	420	420	420

PPP = pieces per package; further dimensions are available upon request



Range of DIY

Framing timber, rough sawn, square edged, KD

	PPP 2,50 m	PPP 3,00 m	PPP 4,00 m	PPP 5,00 m
48 x 78 mm	70	70*	70	70
58 x 58 mm	72	72*	72*	72*
58 x 78 mm	56	56*	56*	56*
78 x 78 mm	56	56	56	56
78 x 98 mm	44	44	44	44
78 x 118 mm	–	36	36	36
78 x 138 mm	–	32	32	32
78 x 158 mm	–	–	28	28
78 x 178 mm	–	–	24	24
78 x 198 mm	–	–	20	20
98 x 98 mm	33	33	33	33
98 x 118 mm	–	27	27	27

*also available with impregnation; PPP = pieces per package; further dimensions are available upon request



Battens & boards, rough sawn, square edged, KD

	PPP 2,50 m	PPP 3,00 m	PPP 4,00 m	PPP 5,00 m
18 x 48 mm	480	480*	480	480
24 x 48 mm	360	360*	360*	360
28 x 48 mm	280	280*	280*	280*
30 x 50 mm	280	280*	280*	280
38 x 58 mm	162	162*	162*	162*
23 x 100 mm	165	165*	165	–
23 x 120 mm	135	135*	135	–
23 x 160 mm	105	105*	105	–

*also available with impregnation

Boards, rough sawn, square edged, KD

	PPP 3,00 m	PPP 4,00 m	PPP 5,00 m
40 x 200 mm	50	50	50
50 x 200 mm	50	50	50
45 x 280 mm	34	34	34
50 x 280 mm	32	32	32

PPP = pieces per package; further dimensions are available upon request



Sawn timber

Battens, rough sawn, KD

	PPP 3,00 m	PPP 4,00 m	PPP 4,50 m	PPP 5,00 m
24 x 48 mm	810	810	810	810
30 x 50 mm	630	630	630	630
40 x 60 mm	432	432	432	432

Tongue and Groove boards, S4S, chamfered 4 sides, KD

	PPP 3,00 m	PPP 4,00 m	PPP 4,50 m	PPP 5,00 m
21 x 140 mm	184	184	184	184
24 x 140 mm	160	160	160	160
28 x 140 mm	144	144	144	144

Boards, rough sawn, KD

	PPP 3,00 m	PPP 4,00 m	PPP 4,50 m	PPP 5,00 m
21 x 80 mm	322	322	322	322
24 x 80 mm	450	450	450	450

PPP = pieces per package; further dimensions are available upon request



Boards, rough sawn, KD

	PPP 3,00 m	PPP 4,00 m	PPP 4,50 m	PPP 5,00 m
23 x 80 mm	672	672	672	672
23 x 100 mm	528	528	528	528
23 x 120 mm	432	432	432	432
23 x 140 mm	384	384	384	384
23 x 160 mm	336	336	336	336

Square edged timber (cross cut), rough sawn, KD

	PPP 3,00 m	PPP 4,00 m	PPP 4,50 m	PPP 5,00 m
58 x 78 mm	255	255	255	255
78 x 78 mm	195	195	195	195
78 x 98 mm	156	156	156	156
98 x 98 mm	132	132	132	132
98 x 118 mm	99	99	99	99

PPP = pieces per package; further dimensions are available upon request



Boards/Planks, rough sawn, basically square edged, KD

	Length 4 m	Length 4,5 m	Length 5 m
32 x 150 mm	*	*	*
32 x 200 mm	*	*	*
32 x 250 mm	*	*	*
38 x 150 mm	*	*	*
38 x 200 mm	*	*	*
38 x 225 mm	*	*	*
50 x 150 mm	*	*	*
50 x 200 mm	*	*	*
50 x 225 mm	*	*	*
75 x 150 mm	*	*	*
75 x 200 mm	*	*	*
75 x 225 mm	*	*	*



Universally usable boards, S4S, round edges, KD

	Length 2,4 m	Length 2,7 m
29 x 124 mm	*	*
29 x 156 mm	*	*

Framing timber , S4S, round edges, KD

Grade: J-Grade

	Length 1,83 m	Length 2,44 m	Length 3,05 m	Length 3,66 m	Length 4,27 m	Length 4,88 m
38 x 89 mm	*	*	*	*	*	*
38 x 140 mm	*	*	*	*	*	*

Framing timber , S4S, round edges, KD

Grade: #2&btr

	Length 92 5/8"	Length 93"	Length 94 1/8"	Length 96"	Length 8'	Length 10'	Length 12'	Length 14'	Length 16'
2 x 4 inch 38 x 89 mm	*	*	*	*	*	*	*	*	*
2 x 6 inch 38 x 140 mm	*	*	*	*	*	*	*	*	*
2 x 8 inch 38 x 184 mm	*	*	*	*	*	*	*	*	*
4 x 4 inch 89 x 89 mm	*	*	*	*	*	*	*	*	*



Framing timber , S4S, round edges, KD
Grade: C16/C24

	Length 2,4 m	Length 2,7 m	Length 3,0 m	Length 3,6 m	Length 3,9 m	Length 4,2 m	Length 4,5 m	Length 4,8 m
38 x 89 mm	*	*	*	*	*	*	*	*
38 x 140 mm	*	*	*	*	*	*	*	*
45 x 70 mm	*	*	*	*	*	*	*	*
45 x 95 mm	*	*	*	*	*	*	*	*
45 x 120 mm	*	*	*	*	*	*	*	*
45 x 145 mm	*	*	*	*	*	*	*	*
45 x 170 mm	*	*	*	*	*	*	*	*
45 x 195 mm	*	*	*	*	*	*	*	*
45 x 220 mm	*	*	*	*	*	*	*	*
70 x 70 mm	*	*	*	*	*	*	*	*
70 x 95 mm	*	*	*	*	*	*	*	*
70 x 140 mm	*	*	*	*	*	*	*	*



Framing timber, rough sawn, basically square edged, KD
Grade: C16/C24 & construction grade

	Length 2,4 m	Length 2,7 m	Length 3,0 m	Length 3,6 m	Length 3,9 m	Length 4,2 m	Length 4,5 m	Length 4,8 m
22 x 95 mm	*	*	*	*	*	*	*	*
22 x 100 mm	*	*	*	*	*	*	*	*
22 x 125 mm	*	*	*	*	*	*	*	*
25 x 38 mm	*	*	*	*	*	*	*	*
25 x 50 mm	*	*	*	*	*	*	*	*
26 x 95 mm	*	*	*	*	*	*	*	*
35 x 45 mm	*	*	*	*	*	*	*	*
35 x 95 mm	*	*	*	*	*	*	*	*
44 x 100 mm	*	*	*	*	*	*	*	*
47 x 50 mm	*	*	*	*	*	*	*	*
47 x 75 mm	*	*	*	*	*	*	*	*
47 x 100 mm	*	*	*	*	*	*	*	*
47 x 125 mm	*	*	*	*	*	*	*	*
47 x 150 mm	*	*	*	*	*	*	*	*
47 x 175 mm	*	*	*	*	*	*	*	*
47 x 200 mm	*	*	*	*	*	*	*	*
47 x 225 mm	*	*	*	*	*	*	*	*
72 x 72 mm	*	*	*	*	*	*	*	*
92 x 92 mm	*	*	*	*	*	*	*	*

Environment

The Environment and ante

Forests are our planet's "green lung". Conserving the forests, for reasons relating to sustained development of the biosphere, is one of society's essential tasks for the 21st century.

The **ante**-group takes this duty very seriously. But conserving the forests is also essential for us from an economical

point of view. Otherwise, we would be "sawing the branch on which we sit". For this reason we from **ante** are particularly indebted and connected to the environment and the forests. It is self-evident that our wood products are an essential part of a contemporary and ecological culture.



ante Bromskirchen-Somplar



ante Winterberg-Züschen



ante Rottleberode



ante Kożuchów



Production sites

- Bromskirchen-Somplar, Germany
- Winterberg-Züschen, Germany
- Rottleberode, Germany
- Kożuchów, Poland

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ante

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