

surface & panel

UNITING MATERIALS, TECHNOLOGY AND DESIGN

2011 BUYERS GUIDE

A GUIDE TO SOURCING AND
SPECIFYING COMPOSITE PANELS
AND DECORATIVE SURFACES



Composite panel substrates and decorative surfaces provide limitless options for design and downstream applications.

The *2011 Surface & Panel Buyers Guide*, sponsored by the Composite Panel Association (CPA), provides the most comprehensive product information available about North American composite panel and decorative surfacing products. The Guide includes in-depth descriptions of the various types of composite panels and decorative surfaces, as well as the many standard and specialty products available.

COMPOSITE PANELS

There are three types of wood-based composite panels: particleboard, medium density fiberboard (MDF), engineered wood siding and trim (EWST) and hardboard. These panels can be engineered to the customer's specific physical/mechanical properties and surface characteristics to create durable, functional end products. By their very nature, wood-based composite panels are among the greenest materials in the world, and a great choice for environmentally conscious consumers.

All particleboard and MDF facilities in this Guide offer third party certified products to meet the California Air Resources Board (CARB) Airborne Toxic Control Measure (ATCM 93120) regulation. CPA maintains a current list of CARB certified and exempt facilities at www.pbmdf.com.

DECORATIVE SURFACES

Decorative surfaces are used in a wide variety of wood-based applications including: cabinets, mouldings, flooring, furniture, countertops, store fixtures, doors and shelving. Composite panels provide an ideal substrate for decorative surfaces – affordable, consistent, uniform in strength and free of defects.

Decorative surfaces are broadly separated into overlays and coatings. Overlays include decorative foils, high pressure laminates, light basis weight papers, thermally fused melamine (TFM), film overlays, wood veneer and heat transfer foils. Coatings are utilized in both liquid and powder forms.

SECTIONS OF THE GUIDE

- **PRODUCT DESCRIPTIONS** detail the characteristics of the materials, common applications and key physical properties.
- **PRODUCT GUIDES** provide company specific product information for the major manufacturers and suppliers of these panel and surfacing products, including designations for environmentally-certified, CARB exempt and no added urea-formaldehyde (NAUF) products.
- **SALES CONTACT INFORMATION** is provided for each producer to help customers locate products.
- **GLOSSARY OF TERMS** offers help for customers unfamiliar with industry terms.

CPA offers an extensive online library of articles and technical bulletins on products referenced in this Guide at www.pbmdf.com.

ENVIRONMENTAL AND GREEN BUILDING PROGRAMS

The following programs are designed to recognize the environmental efficacy and/or green building claims of composite panel products available in the marketplace.

EPP Programs

CPA sponsors an Environmentally Preferable Product (EPP) certification program to highlight composite panel products that contain 100% recycled or recovered fiber and meet low formaldehyde emission limits. EPP-certified mills have also achieved compliance with California's regulation on formaldehyde emissions.



The EPP program includes manufacturers of finished products. Products carrying the EPP Downstream logo were manufactured by a company that has demonstrated its environmental commitment by purchasing EPP-certified composite wood panels.

Visit the CPA's web site for a list of EPP-certified companies.

Other Green Building Programs

The most prominent US green building certifications are the National Association of Home Builders' (NAHB) Model Green Home Building Guidelines and U.S. Green Building Council's (USGBC) The Leadership in Energy and Environmental Design (LEED) Green Building Rating System.

EPP-certified products are eligible for the following NAHB Model Green Home Building Guidelines Credits:

- Recycled-Content, Section 2.4.1 = 3 points
- Renewable Materials, Section 2.6.1 = 3 points
- Minimize Potential Sources of Pollutants, Section 5.1.5 = 6 points

Composite Wood Products are eligible for the following U.S. Green Building Council's Leadership in Energy and Environmental Design (LEED) Credits:

- Recycled Content MR Credit 4
- Regional Materials MR Credit 5
- Certified Wood MR Credit 7
- Low Emitting Material EQ Credit 4.4

Composite Wood Products are also used in downstream systems eligible for:

- Low Emitting Materials EQ Credit 4.5 (LEED-CI)
- Environmentally Preferable MR Credit 5 Products (LEED-H)

CONTINUING EDUCATION UNITS (CEUs)

CPA develops continuing education units (CEUs) on the array of decorative surface and wood-based composite panel options available for residential and commercial applications. In this edition, CPA is publishing the fourth in a series of CEUs approved by the American Institute of Architects, titled *Thermally Fused Melamine: Where ecology, economy, aesthetics and performance meet*.



ABOUT THE COMPOSITE PANEL ASSOCIATION

Founded in 1960, the Composite Panel Association (CPA) is dedicated to advancing the North American wood-based panel and decorative surfacing industries. CPA represents both industries on technical, public policy, quality assurance and product acceptance issues.

CPA General Members include the leading manufacturers of particleboard, MDF, EWST and hardboard, representing over 95% of North American manufacturing capacity.

CPA Associate Members include manufacturers of decorative surfaces, furniture, cabinets, mouldings, doors and equipment, along with laminators, distributors, industry media and adhesive suppliers. All are committed to product advancement and industry competitiveness.

CPA is a vital resource for both manufacturers and users of industry products. As a highly-regarded and accredited standards developer, CPA publishes and maintains the industry's ANSI product standards.

CPA operates an International Testing and Certification Center (ITCC) and manages the Grademark Certification Program, the largest and most stringent testing and certification program for North American composite panel products. The association helps manufacturers create in-plant quality control programs through educational programs and on-site assistance.

CPA also compiles and publishes the most definitive industry economic performance data, as well as technical bulletins on the use of industry products and other educational materials. The association partners with *Surface & Panel* magazine in publishing this Guide and regular editions of the magazine.

MORE INFORMATION

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INNOVATIVE PRODUCTS FOR A SUSTAINABLE FUTURE

2011 BUYERS GUIDE

[TABLE OF CONTENTS]

3 About this Guide and the Composite Panel Association

6 A Message from CPA's President

8 Continuing Education Unit

Thermally Fused Melamine: Where ecology, economy, aesthetics and performance meet.

16 Product Descriptions

Characteristics of the materials, common applications and physical properties.

16 Particleboard

22 MDF

28 Hardboard

30 Engineered Wood Siding and Trim

34 High Pressure Laminates

38 Thermally Fused Melamine

42 Decorative Foils

42 Heat Transfer Foils

44 Film Overlays

50 Light Basis Weight Papers

52 Veneer

54 Liquid Coatings

55 Powder Coatings

56 Product Guides

Company specific product information for manufacturers and suppliers of panel and surfacing products, including designations for environmentally-certified (EPP) and no added urea-formaldehyde products.

56 Particleboard

58 MDF

60 Hardboard

60 Engineered Wood Siding and Trim

62 Overlay Manufacturers

64 Laminators

66 Coaters

67 Coating Manufacturers

68 Sales Contact Information

Listings provided for each producer to help customers locate products.

68 Particleboard

69 MDF

69 Hardboard

69 Engineered Wood Siding and Trim

70 Overlay Manufacturers

71 Laminators

72 Coaters

72 Coating Manufacturers

74 Associate Member Directory

78 Specifying Surfaces

80 Glossary of Terms

82 Advertiser Index



On the cover: Consistent and durable composite panels combined with fashionable decorative surfaces offer infinite design possibilities in residential and commercial applications. The *Surface & Panel Buyers Guide* is your complete source for specifying the right materials for any application.



Surface & Panel magazine and the Composite Panel Association thank the following organizations who contributed images for the production of this issue:

Abet Laminati, American Renolit, Arborite, B+N, Bausch Linneman, Boltaron, BT Powder Coating, Busch Industries, ClosetMaid, Columbia Forest Products, Coveright, Dackor, DVUV, Eggersman, Flakeboard, Foliot, Formica, Harston-Kennedy, Henry Built, Herman Miller, Interlam, KML-Kustom Material Laminates, Louisiana Pacific, Klockner, Northern Contours, Omnova, Ralpha Stone, Sauder, Schattdecor, Sesa, Sports Authority, Stevens Industries, Suddekor, Sun Mountain Doors, Surface Source International, Tafisa, Temple-Inland, Tiger Drylac, Uniboard, Valspar, Veneer Art, Wilsonart International, WTP.



Surface & Panel is published quarterly by Bedford Falls Communications, Inc., 1617 Country Club Lane, Watertown, Wisconsin 53098, telephone 920-206-1766, fax 920-206-1767. John Aufderhaar, President, Christine Aufderhaar, CFO. All rights reserved. No part of this publication may be reproduced or transmitted in any form, electronic or mechanical without written permission from the publisher. Subscription policy: Individual subscriptions are available, without charge, to manufacturers who engage in panel processing, qualified service providers and suppliers. Publisher reserves the right to reject non-qualified subscribers. One year subscription to non-qualified individuals: U.S. \$50, Canada/Mexico \$75, all other countries \$100, payable in U.S. funds. Single issues are \$15, and must be prepaid. Bedford Falls Communications, Inc., does not assume and hereby disclaims any liability to any person for any loss or damage caused by errors or omissions in the material contained herein, regardless of whether such errors result from negligence, accident, or any other cause whatsoever. Printed in the U.S.A.

Postmaster: Send address changes to *Surface & Panel*, 1617 Country Club Lane, Watertown, WI 53098.

Please direct all subscription questions and mail to:
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 Watertown, WI 53098
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“The economic recovery will be especially good news for specifiers of composite panel products and wood-based decorative surfaces, since so many innovative products are now available and itching to find a consumer market.”

One good thing we can say about 2010 is that the economic free fall is over and we've begun what could be a long, slow and tenuous come-

back. A year from now we may be smiling, but not just yet.

The economic recovery will be especially good news for specifiers of composite panel products and wood-based decorative surfaces, since so many innovative products are now available and itching to find a consumer market.

This 2011 Buyer's Guide to Composite Panels and Decorative Surfaces (a special edition of *Surface & Panel* magazine) is your roadmap to finding these products and putting them to use in your residential, commercial or architectural project – or in the manufacture of furniture, cabinets, doors, flooring, mouldings and other products.

Make sure this Guide is a keeper for your office, and bookmark the Composite Panel Association (CPA) web site at www.pbmdf.com to access the electronic version that will be updated throughout the year. You'll also find a wide range of technical bulletins and industry standards there.

And if you want to enhance your professional credentials or are just curious, read CPA's latest Continuing Education Unit (CEU). This time you'll test your knowledge and learn about the wide-ranging attributes of Thermally Fused Melamine (TFM) surfaces. This CEU and others like it are also available on the CPA web site, and a new unit on Green Surfaces and Substrates will be published in the spring.

When it comes to “being green”, CPA members are proud of their leadership in offering innovative products and supporting forward-looking environmental policies. Recent events speak louder than words.

More than a year ago, CPA and the Sierra Club joined to form a broad coalition of industry, environmental, labor and health-focused groups to support a federal standard that limits the formaldehyde emissions from composite wood products. Modeled on California's so-called “CARB Rule” that is embraced by responsible manufacturers around the world, the legislation

passed by Congress last year gives certainty and structure to a complex regulatory landscape while also making important refinements to California's law. It also calls for a level playing field when it comes to regulating composite wood products sold in the U.S., regardless of where they are made.

The federal legislation directs the path of a pending regulation by the U.S. Environmental Protection Agency (EPA) that now has explicit boundaries and must be enacted by 2013. CPA is actively participating in this EPA rulemaking process and we are determined to make sure it stays true to the wishes of Congress; that it does not create new, unnecessary burdens for small business; that rigorous third party product testing and certification is maintained so consumers have full confidence in what they buy; and that domestic and offshore manufacturers are treated the same when it comes to enforcement.

But don't take my word for it. If you really want to see industry's commitment to making low-emitting, innovative products, then read the product listings in this 2011 Buyer's Guide. You will see a showcase of CARB Phase 2, ultra low emitting, and no added urea-formaldehyde particleboard and MDF products.

Builders and remodelers should also pay close attention to this year's section on Engineered Wood Siding and Trim, to help you distinguish these construction products from traditional hardboard applications.

Then it's on to the many decorative surfaces available for composite wood-based products, and in these pages you'll find options for every need.

Tough times bring out the best, and sometimes the worst, in all of us. When we're at our best we embrace change, continuous improvement and innovation. We work even harder to understand the needs of our customers, and provide exceptional service. I'm proud to represent an industry that is showcasing its best, and offering a value proposition that can't be beat.

A handwritten signature in blue ink that reads "T. Julia".

Tom Julia | President, Composite Panel Association
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Thermally Fused Melamine

Where ecology, economy, aesthetics and performance meet

This CEU provides an introduction to thermally fused melamine (TFM), a decorative surfacing material that is sometimes called melamine or low pressure laminate.

In addition to addressing the definition of TFM and how it is made, this unit will explore the history of the surface treatment as well as design and end-use considerations.



TFM is a decorative surface and a building material that requires no additional substrate, adhesive or laminating equipment prior to processing into a finished product. The panel's durability, design versatility and ease of use make it a common specification across many market segments, including case goods, furniture, store fixtures, home organization, flooring and institutional applications. It is often used in conjunction with other materials to value engineer projects by reducing costs while maintaining design integrity.





TFM is made from three primary ingredients: décor paper, melamine based resin system and a substrate, typically medium density fiberboard (MDF) or particleboard. An additional overlay may also be used for performance or aesthetic characteristics. The décor paper is impregnated with a melamine resin then laminated directly to the substrate without the need for additional adhesive. When pressed under heat and pressure the melamine resin creates a cross-linked thermoset bond between the décor paper and the substrate resulting in a homogenous decorative panel.

HISTORY/TECHNICAL DEFINITION

The TFM story is about refining the use of wood for machinability, conservation, economic and aesthetic precision. Wood has always played an important role as a building material in solid and plank form, however in its natural form, wood varies dramatically in terms of species, availability, performance and aesthetics. Craftsmen have compensated for these variations in many cases by hand-cutting veneers from rare species and using them as a decorative layer on top of more stable or readily available species. This practice uses resources efficiently and reduces materials costs. Yet it still leaves wood susceptible to scratching and warping, especially in moist environments.



The capacity for improving the performance of wood products while conserving resources grew exponentially in the 20th century due in large part to the development of two seemingly unrelated technologies. The first is synthetic plastics, which advanced around the turn of the century. The resulting artificial resins were defined as thermoplastic (which turn to liquid when heated, then solidify when sufficiently cooled) and thermosets (which irreversibly cure under heat and pressure to make a material that is resistant to heat, water, chemicals and electrical current). The second is high speed printing technology, which also advanced in the early part of the century, making it possible to print large rolls of décor paper with high-fidelity photorealistic designs such as wood grains. Generally a décor paper is printed with water-based pigments. The use of décor papers allows designers to achieve any visual effect, such as rare stone or endangered wood species without negatively impacting the environment.

These two technologies became increasingly important when resources became more



scarce during World War II. Innovative manufacturers began combining resins with wood waste (sawdust, wood chips and refined cellulose) and pressing the mix to make composite panels. The resulting panel substrates (including hardboard, MDF and particleboard) were not only structurally sound and predictable in their performance, but also valuable for their ecological contribution to making optimal use of wood residuals.

FACING PAGE: TFM IS A DECORATIVE PANEL THAT REQUIRES NO FURTHER LAMINATING BEFORE PROCESSING.

THIS PAGE: BECAUSE OF THEIR BEAUTY, DURABILITY AND EASE OF USE, TFM DECORATIVE PANELS ARE USED IN A WIDE VARIETY OF APPLICATIONS.





The classic laminating process, developed in the first third of the 20th century, uses heat and pressure to press a layer of décor paper onto a stack of layered kraft paper (similar to brown bag paper). The kraft paper layers are saturated with an inexpensive, dark phenolic resin, while the decorative layer is saturated with melamine resin, which produces a clear surface. The resulting high pressure laminate (HPL) material is then glued to the substrate using a contact adhesive and pressing equipment.

By the middle of the last century a whole new generation of high-performance wood-based products, created from rapidly renewable wood species, readily available materials and pre-consumer recycled waste was born. Some years later manufacturers in Europe realized that by eliminating the kraft paper layers, melamine impregnated décor paper could be pressed directly to the substrate. The resulting TFM material is a homogenous, ready-to-use decorative panel that requires no further laminating prior processing. TFM offers excellent aesthetics, as well as scratch and wear resistance. Today, TFM is manufactured in state-of-the-art facilities throughout North America.

PRODUCT DESCRIPTION, SUSTAINABILITY AND ADHESION TO SUBSTRATE

In addition to visual appeal and performance criteria, contemporary specifiers must respond to client demands for sustainable and environmentally friendly products. So it is important to understand the basic science and technology behind the component parts of TFM: substrate, melamine resin and décor paper.

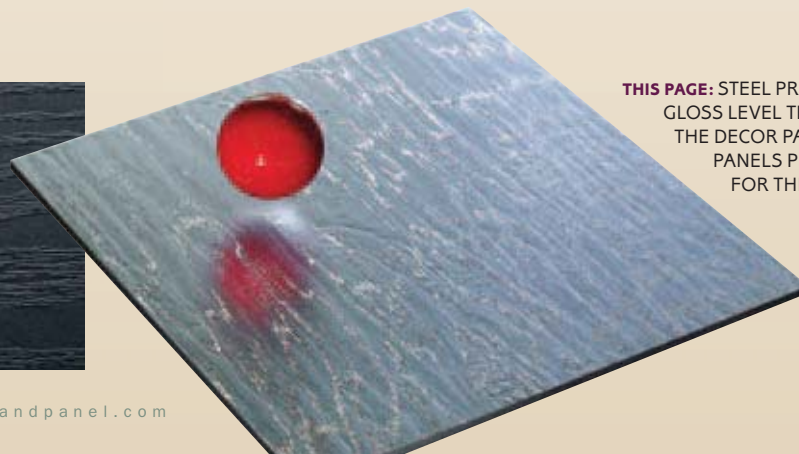
It is generally accepted that the use of reclaimed wood and paper is good, and that the adhesives used to produce composite panels should be as benign as possible.

North American composite panel manufacturers offer boards produced with different adhesive formulations to meet today's stringent requirements for indoor air quality such as the California Air Resources Board (CARB) formaldehyde emissions rule, the CPA Environmentally Preferable Product (EPP) specification and others. All Composite Panel Association member board manufacturers offer CARB Phase 2 formaldehyde emission compliant products, and many also produce ultra low-emitting formaldehyde (ULEF) and/

or no-added formaldehyde (NAF) products. The CARB emission ceilings are among the most stringent anywhere in the world for composite wood panels, and are complimented by a rigorous third party testing and certification program and extensive chain of custody requirements. Additionally, reclaimed wood sequesters carbon, making composite panels a more ecologically-sound use of fiber than if it's landfilled or burned as biomass.



THIS PAGE: STEEL PRESS PLATES ADD TEXTURE AND GLOSS LEVEL THAT ENHANCE THE FIDELITY OF THE DECOR PAPER DESIGN. TFM DECORATIVE PANELS PROVIDE HIGH-END AESTHETICS FOR THE MODERN KITCHEN AND BATH.





END USE APPLICATIONS AND DESIGN CONSIDERATIONS:

TFM is a cost-effective material that is highly resistant to warping, bowing, moisture, scratching, staining and abrasion due to wear. It is easily fabricated and as a result is widely used in the following applications:

- Flooring
- Case goods
- Store fixtures
- Organization systems and closets
- Kitchen and bath cabinets
- Wood paneling
- Office, residential and healthcare furniture
- Architectural accents

Enhanced performance characteristics, such as microbial resistance and super-durability can also be achieved by increased paper thickness and specialized saturation techniques. Overlays can be added during the pressing process to enhance surface performance or aesthetic appeal. The use of specialized steel

press plates can add dimensional characteristics (matte, gloss, ticking, texture) to the surface finish.

From its early aesthetic roots of white and solid colors, TFM has matured to offer a broad range of designs. Almost any design that can be printed can be made into TFM, and with modern rotogravure and digital printing technologies the possibilities are endless. Popular designs include contemporary wood grains, exotics and abstracts, though whimsical and custom designs are increasingly specified in retail, commercial and hospitality applications.

TFM is often used in conjunction with other decorative surfacing materials to engineer products that precisely meet design criteria. Décor matching programs across engineered materials allow designers to specify panels to the exact requirements of the application with a consistent visual. TFM panels typically require a decorative edge treatment and can be specified with or without edge, and with single or opposite-side face treatments.

LEED CREDITS & FSC CERTIFICATION

TFM is an excellent product to specify for residential, commercial and healthcare interior applications. Non-porous hard surfaces are easy to clean and do not harbor dirt or contaminants. No-added formaldehyde (NAF) substrates support improved indoor air quality. TFM can contribute to as many as six LEED credits depending on sourcing and substrate.

Also, increasingly the décor paper used in the production of TFM is available with FSC-chain of custody certification. To fuse the decorative layer and composite substrate the paper must first be impregnated with a melamine formaldehyde resin system. After saturation the paper is partially cured to a B-stage, at which point it must be stored within specific temperature and moisture parameters to prevent curing. B-stage papers have a finite shelf life. When the saturated paper is pressed to the substrate a complete cross-linked bond is created between the melamine and formaldehyde minimizing potential emissions. Once the décor paper is fused to the substrate it effectively seals the composite panel, reducing substrate emissions by nearly 98 percent.



THIS PAGE: ONCE CURED, TFM IS A HOMOGENOUS DECORATIVE PANEL WITH EXCELLENT SCRATCH, STAIN AND WEAR RESISTANCE. IT IS A POPULAR MATERIAL IN COMMERCIAL, HOSPITALITY AND FURNITURE APPLICATIONS.

Case Studies:

PREMIUM DESIGN

Technology drives design, and design depends on technology to satisfy the wants and needs of the consumer market. Many firms specializing in premium residential development and retail spaces use TFM decorative panels for kitchen cabinetry as well as built-in furniture and store fixtures. Modern architects design with modern materials, methods and means. TFM is a decorative panel that requires no further laminating before processing, making it a trouble free material for fabricators. Plus it has excellent aesthetics wear and scratch resistance. For any big development project anything that can reduce cost and production time is very beneficial. Beyond ease of use, TFM is recognized for its aesthetic value. TFM designs come from printed décor paper, allowing professionals to provide their clients with the increasingly popular look of exotic or rare minerals and wood species, but without exploiting precious resources or breaking the bank. The consistent visual of TFM designs means professionals can specify for a big job and not worry about panel matching. The other benefit there is of course value-engineering. TFM designs match other materials that have different performance characteristics, so pieces can be built with a uniform look inside and out.

THE FIFTH WALL

Advanced printing technology produces décor paper, the decorative layer of TFM decorative panels, with unprecedented realism. Improved



print fidelity combined with specialized surface treatments and overlay techniques results in a consumer product that designers can stand behind, or rather, on. Ninety-five percent of laminate flooring is made from TFM decorative panels. Laminate flooring is specified for applications where the design calls for a hard surface with the warmth of real wood, that won't scratch, dent or warp. Laminate flooring

is a common specification for both residential and commercial applications. TFM is used in healthcare applications because it is a hard surface that is easy to clean and does not harbor dirt or allergens. It also has excellent scratch, dent and wear-resistance, making it a popular choice for hotel and restaurant environments. Because laminate flooring has limitless design possibilities and low life-time cost of maintenance it is an efficient solution for a wide variety of projects. Professionals working toward sustainable objectives can earn up to six LEED credits by specifying TFM decorative panels. ■

RESOURCES

The Composite Panel Association (CPA) is the trade association representing the North American wood-based composite panel and decorative surfacing industries. Manufacturers and processors of surface materials may reference the Voluntary Compendium of Standards for Decorative Overlays. The standards outline the attributes of each type of decorative overlay, including TFM, decorative foils, 3D overlays, light basis weight papers, oriented polypropylene films (OPP), and vinyl films. The Compendium provides information and industry-accepted test methods to determine the performance and physical characteristics of the different overlays, and allows product identification for a particular application. For more information visit the Composite Panel Association at www.DecorativeSurfaces.org or www.pbmdf.com.





Thermally Fused Melamine: Where ecology, economy, aesthetics and performance meet.

Circle the letter of the correct answer for each question below.

1. **What two technologies lead to the development of TFM?**
 - A. Synthetic plastics and high speed printing of paper
 - B. Nanotechnology and high speed printing of paper
 - C. High speed printing of paper and hydroelectric power
 - D. Hydroelectric power and nanotechnology
2. **Which of the following is NOT used in making TFM decorative panels?**
 - A. Substrate
 - B. Kraft paper
 - C. Resin
 - D. Décor paper
3. **Specialty overlays give TFM decorative panels certain performance characteristics, including all of the following EXCEPT:**
 - A. Stain resistance
 - B. Moisture resistance
 - C. Impact resistance
 - D. Anti-microbial qualities
4. **Saturated décor paper that is partially cured is referred to as:**
 - A. B-stage
 - B. A-game
 - C. Immature
 - D. Holding
5. **After resin-saturated décor paper is pressed to a substrate to make TFM:**
 - A. It must be adhered to a panel for processing.
 - B. It is ready to use as a decorative panel.
 - C. It must be dried in an oven at low heat for a long period.
 - D. It must be stored at a specific temperature and humidity to fully cure.
6. **TFM designs match other designs available in which of the following:**
 - A. HPL
 - B. 3D Laminates
 - C. Low basis weight papers
 - D. All of the above
7. **The visual design for TFM decorative panels comes from:**
 - A. Kraft paper
 - B. HPL
 - C. Wall paper
 - D. Décor paper
8. **TFM decorative panels can contribute to up to how many LEED credits?**
 - A. 0
 - B. 2
 - C. 4
 - D. 6
9. Circle True or False: **Steel press plates emboss both texture and gloss level to the surface of TFM decorative panels.** TRUE FALSE
10. **TFM decorative panels are routinely specified for all of the following applications EXCEPT:**
 - A. Exterior siding
 - B. Flooring
 - C. Cabinetry
 - D. Case goods
 - E. Furniture

You will earn one (1) Learning Unit by answering at least 80% of the questions on this page correctly and submitting the responses with your contact information below. A certificate of completion will be sent to you upon receipt of a satisfactory submission. There is no fee.

Take this quiz online at www.DecorativeSurfaces.org

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STORE FIXTURES



Particleboard is a composite panel product consisting of cellulosic particles of various sizes that are bonded together with a synthetic resin or binder under heat and pressure. Particle geometry, resin levels, board density and manufacturing processes may be modified to produce products suitable for specific end uses. At the time of manufacture additives can be incorporated to impart specific performance enhancements including greater dimensional stability, increased fire retardancy and moisture resistance.



Today's particleboard gives industrial users the consistent quality and design flexibility needed for fast, efficient production lines and quality consumer products. Particleboard panels are manufactured in a variety of dimensions with a wide range of physical properties that provide maximum design flexibility for specifiers and end users.



PARTICLEBOARD IS CONSISTENT, DURABLE AND PRODUCED TO PRECISE THICKNESSES IN A VARIETY OF PANEL SIZES ❶.

PARTICLEBOARD IS FOUND IN FURNITURE, FLOORING AND CABINETS IN BOTH RESIDENTIAL AND COMMERCIAL SETTINGS, INCLUDING HOSPITALS ❷ AND KITCHENS ❸.





PARTICLEBOARD CAN BE PRODUCED TO BE MOISTURE RESISTANT OR AS A FIRE RETARDANT MATERIAL.

PARTICLEBOARD HAS EXCELLENT MACHINING CHARACTERISTICS, WHICH IS IMPORTANT WHEN POST-FORMING HIGH PRESSURE LAMINATE COUNTERTOPS 4 AND FOR PREFABRICATED EDGE APPLICATIONS 5.

THE STABILITY AND CONSISTENCY OF THE MATERIAL LENDS ITSELF FOR USE AS WORK SURFACES 4, AND THE CORE FOR INTERIOR DOORS 6.

PRODUCT STANDARDS AND CERTIFICATION

The American National Standard for Particleboard (ANSI A208.1) is the North American industry voluntary standard. It classifies particleboard by density and strength and covers physical, mechanical and dimensional characteristics as well as formaldehyde levels. The Standard was developed through the sponsorship of the Composite Panel Association (CPA) in conjunction with producers, users and general interest groups. A summary of the ANSI Property Requirements is included in this Guide and copies of the Standard are available from CPA.

Third-party certification to ANSI Standards is required for many applications of composite panels. For example, the US Department of Housing and Urban Development (HUD) requires the physical properties of manufactured home decking to be third-party certified. In addition, many building code jurisdictions require the physical properties of particleboard underlayment and stair treads to be third-party certified. HUD and the states of California and Minnesota also require third-party certification of formaldehyde emissions for nearly all particleboard and MDF under their jurisdiction.

FORMALDEHYDE EMISSION LIMITS

The standard has a tiered system of emission levels allowing either a maximum of 0.18 ppm or 0.09 ppm for industrial grades or 0.20 ppm for manufactured home decking. To meet the needs of the market many particleboard manufacturers have voluntarily developed ultra low-emitting and no added urea-formaldehyde (NAUF) products, so there are a wide variety of products available today with reduced formaldehyde levels, as well as a growing number of non-formaldehyde alternatives. Those companies currently producing NAUF products are identified in the product listings in this Guide.

In addition, CPA's Environmentally Preferable Product (EPP) program (to which a majority of the North American producers subscribe) requires emission limits no higher than the California Air Resources Board (CARB) Airborne Toxic Control Measure ("CARB Rule").

Finally, various overlays and surface treatments have been shown to significantly reduce product emissions. For additional information about emissions, see the CPA Technical Bulletin "VOC Emission Barrier Effects."

PARTICLEBOARD CONTINUED ON PAGE 20 >



PARTICLEBOARD IS MADE IN A WIDE RANGE OF PROPERTIES TO SUIT JUST ABOUT ANY PURPOSE. IN VERTICAL APPLICATIONS ❶, A LOW DENSITY PRODUCT MAY BE THE PERFECT CHOICE. IN DEMANDING APPLICATIONS LIKE OFFICE FURNITURE WORK SURFACES ❷, A HIGHER DENSITY PRODUCT MAY BE INDICATED.



❶

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Table A: REQUIREMENTS FOR GRADES OF PARTICLEBOARD

ANSI 208.1-2009 Particleboard

Grade	Dimensional Tolerances			Physical and Mechanical Properties								
	Length & Width mm (inch)	Thickness Tolerance		Modulus of Rupture N/mm ² (psi)	Modulus of Elasticity N/mm ² (psi)	Internal Bond N/mm ² (psi)	Screw-holding		Linear Expansion max. avg. percent			
		Panel Average from Specified mm (inch)	Variance from Panel Average mm (inch)				Face N (pounds)	Edge N (pounds)				
H-1	±2.0 (0.080)	±0.200 (0.008)	±0.100 (0.004)	14.9 (2161)	2160 (313300)	0.81 (117)	1600 (360)	1200 (270)	NS			
H-2	±2.0 (0.080)	±0.200 (0.008)	±0.100 (0.004)	18.5 (2683)	2160 (313300)	0.81 (117)	1700 (382)	1400 (315)	NS			
H-3	±2.0 (0.080)	±0.200 (0.008)	±0.100 (0.004)	21.1 (3060)	2475 (359000)	0.90 (131)	1800 (405)	1400 (315)	NS			
M-0	±2.0 (0.080)	±0.200 (0.008)	±0.100 (0.004)	7.6 (1102)	1380 (200200)	0.31 (45)	NS	NS	NS			
M-1	±2.0 (0.080)	±0.200 (0.008)	±0.100 (0.004)	10.0 (1450)	1550 (224800)	0.36 (52)	NS	NS	0.40			
M-S	±2.0 (0.080)	±0.200 (0.008)	±0.100 (0.004)	11.0 (1595)	1700 (246600)	0.36 (52)	800 (180)	700 (157)	0.40			
M-2	±2.0 (0.080)	±0.200 (0.008)	±0.100 (0.004)	13.0 (1885)	2000 (290100)	0.40 (58)	900 (202)	800 (180)	0.40			
M-3i	±2.0 (0.080)	±0.200 (0.008)	±0.100 (0.004)	15.0 (2176)	2500 (362600)	0.50 (73)	1000 (225)	900 (202)	0.40			
LD-1	±2.0 (0.080)	+0.125 (0.005) -0.375 (0.015)	±0.125 (0.005)	2.8 (406)	500 (72500)	0.10 (15)	360 (81)	NS	0.40			
LD-2	±2.0 (0.080)	+0.125 (0.005) -0.375 (0.015)	±0.125 (0.005)	2.8 (406)	500 (72500)	0.14 (20)	520 (117)	NS	0.40			

Table B: REQUIREMENTS OF PARTICLEBOARD FLOORING PRODUCTS AND BUILDING CODE GRADES

Grade	Dimensional Tolerances			Physical and Mechanical Properties								
	Length & Width mm (inch)	Thickness Tolerance		Modulus of Rupture N/mm ² (psi)	Modulus of Elasticity N/mm ² (psi)	Internal Bond N/mm ² (psi)	Hardness N (pounds)	Concentrated ⁶ Loading N (pounds)	Thickness Swell max. avg. mm (inch) percent	Linear Expansion max. avg. percent		
		Panel Average from Specified mm (inch)	Variance from Panel Average mm (inch)									
PBU	+0 (0) -4.0 (0.160)	±0.375 (0.015)	±0.250 (0.010)	11.0 (1595)	1725 (250200)	0.40 (58)	2225 (500)	NS ⁷	1.6 (0.063) NS	0.35		
D-2	±2.0 (0.080)	±0.375 (0.015)	±0.250 (0.010)	16.5 (2393)	2750 (398900)	0.55 (80)	2225 (500)	2670 (600)	NS 8	0.30		
D-3	±2.0 (0.080)	±0.375 (0.015)	±0.250 (0.010)	19.5 (2828)	3100 (449600)	0.55 (80)	2225 (500)	2670 (600)	NS 8	0.30		

Grade	Dimensional Tolerances			Physical and Mechanical Properties								
	Length & Width mm (inch)	Thickness Tolerance		Modulus of Rupture N/mm ² (psi)	Modulus of Elasticity N/mm ² (psi)	Internal Bond N/mm ² (psi)	Hardness N (pounds)	Screw-holding		Linear Expansion max. avg. percent		
		Panel Average from Specified mm (inch)	Variance from Panel Average mm (inch)					Face N (pounds)	Edge N (pounds)			
M-3	±2.0 (0.080)	±0.200 (0.008)	±0.100 (0.004)	16.5 (2393)	2750 (398900)	0.55 (80)	2225 (500)	1100 (270)	1000 (225)	0.35		

PARTICLEBOARD

COMPOSITE PANEL ASSOCIATION



COMPANY AND MILL LOCATION	BRAND NAME	WOOD SPECIES	CERTIFIED WOOD	EPP CERTIFIED	NAUF (NO ADDED UREA-FORMALDEHYDE)*	CARB EXEMPT (ULEF / NAF)**	INDUSTRIAL GRADES					FLOOR UNDERLAYMENT (PBU)	MFD HOME DECKING D-2, D-3	DOOR CORE LD-1, LD-2	SPECIAL ITEMS AND TREATMENTS (SEE LEGEND BELOW)	PRESS SIZE (FT.)	THICKNESS RANGE (IN.)	DENSITY RANGE (LBS/FT ³)
							M-0	M-1	M-S	M-2	M-3i							
BOISE CASCADE, LLC La Grande, Oregon	Boise Select, Boise Evergreen, Anchor™	Western Pine, Mixed Softwoods	FSC	•	•				•	•	•				BE C CS EF HD LD MR S ST	5x18, 4x24	3/8 – 1-1/4	41 – 50
COLLINS PRODUCTS, LLC Klamath Falls, Oregon	Collins Pine Particleboard, Free Form	Western Pine	FSC	•	•				•	•	•				C CS MR S	5x24	3/8 – 1-1/4	42 – 47
DURAPLAY DE PARRAL, S.A. DE C.V. Parral, Chihuahua	Duraplay Supremo, Duramel, Duracore, Duralam	Pine		•					•	•	•				BE C CS EF ET FO LP M MN MR PA S ST W	8x48 Single Opening, 4' Mende	1/8 – 1-1/8	40 – 55
FLAKEBOARD Albany, Oregon	Duraflake®, Vesta	Douglas Fir, Hemlock	FSC	•	•				•	•	•	•		•	C CS DC FR HD M MR S ST	4x24, 6x26	3/8 – 1-15/16	42 – 55
Bennettsville, South Carolina	UltraPine®, UltraPine® Plus, Vesta	Pine	FSC	•	•				•	•	•	•		•	C CS DC LD M MR S	10xContinuous	9/32 – 1-1/2	41 – 46
Simsboro, Louisiana	UltraPine®, UltraPine® Plus, Vesta	Pine	FSC	•	•				•	•	•	•		•	C CS DC LD M MR S	10xContinuous	1/4 – 1-1/2	41 – 46
St. Stephen, New Brunswick	Rezflake, Vesta	Spruce	FSC	•	•				•	•	•	•		•	B F FO LP M MN P PA PF PR T	4xContinuous, 8x32	3.0mm – 1-1/8	42 – 47
FLORIDA PLYWOODS, INC. Greenville, Florida		Southern Yellow Pine													BE CS PA S V W	5x12, 5x24	5/16 – 5/8	50
MARSHFIELD DOORSYSTEMS, INC. Marshfield, Wisconsin	Uni-Cor ST, Uni-Cor ST Lite, Uni-Cor FR	Aspen, Basswood, Northern Hardwoods	FSC	•	•									•	CS DC SR FR LB LD	7x9	1-1/8 – 2-1/4	28 – 37
Maderas Conglomeradas S.A. de C.V. Tlalnepantla, Mexico	MACOPAN	Pine / Softwood													CS LP P W	4 X Continuous 8 X Continuous	1/12 – 5/16	46-49
Maderas Sintéticos de México, S.A. de C.V. (MASISA) Durango, Mexico	Placa Masisa, MDF Masisa, Melamina, Masisa	Duranguense Pine												•	CS FO LP LD M	4x8, 5x8, 8x8	3/8 – 1-3/8	35 – 50
NORTHERN ENGINEERED WOOD PRODUCTS, INC. Smithers, British Columbia	NEWPRO Blonde	Pine, Spruce		•	•				•	•	•				M	8x48	1/4 – 1	38 – 50
PANOLAM INDUSTRIES INTERNATIONAL, INC. Huntsville, Ontario	Panolam, Pionite, Conolite	Canadian Wood Mixture		•	•										C FR LP M MR	5x18, 8xContinuous	1/4 – 1-1/2	42 – 45
PLUMMER FOREST PRODUCTS Post Falls, Idaho	EnStron, EnStron Plus, Terramica	Western Softwoods	FSC / SCS	•	•	•	•	•	•	•	•				CS MR	4x8	1/4 – 1-1/8	42 – 48
PPM PACIFIC PANELS MEXICO, S.A. DE C.V. Tijuana, Mexico	Best Board	Pine (Some Recycled)		•											C CS FO LP LD M MR P S V W	4x40	3/8 – 1-3/8	42 – 47

REXCEL S.A. DE C.V.																		
Chihuahua, Chihuahua Zitacuaro, Michoacan		Ponderosa Pine Wood Mixture																
ROSEBURG																		
Dillard, Oregon	UltraBlend™, SkyBlend™	Fir, Pine Blend	FSC															
Louisville, Mississippi Missoula, Montana	UltraBlend™ UltraBlend™, SkyBlend™	Southern Pine Western Pine, White Fir	FSC															
Russellville, South Carolina Taylorsville, Mississippi Vienna, Georgia	UltraBlend™, SkyBlend™ UltraBlend™, SkyBlend™ UltraBlend™	Southern Pine Southern Pine Southern Pine	FSC FSC FSC															
SIERRAPINE																		
Adel, Georgia	ENCORE™, ENCORE™ MR	Southern Pine	FSC															
Martell, California	Ampine™, ENCORE™	Western Pine	FSC															
Springfield, Oregon	ENCORE™, ENCORE™ FR, ENCORE™ MR	Western Softwoods	FSC															
TAFISA CANADA INC.																		
Lac-Megantic, Quebec	Tafipan	Spruce, Pine, Fir, Maple, Birch, Aspen																
TEMPLE-INLAND																		
Diboll, Texas	Temstock	Southern Pine																
Hope, Arkansas	Temstock	Southern Pine																
Monroeville, Alabama	Temstock	Southern Pine																
Thomson, Georgia	Temstock	Southern Pine																
TIMBER PRODUCTS COMPANY																		
Medford, Oregon		Fir, Pine																
UNIBOARD																		
Moncure, North Carolina	Uniboard PB	Southern Pine, Soft Hardwood	FSC															
Sayabec, Quebec	Uniboard PB	Softwood, Hardwood	FSC															
Val-d'Or, Quebec	Uniboard PB	Softwood, Hardwood	FSC															
WEBB FURNITURE ENTERPRISES, INC.																		
Galax, Virginia	Webb Particleboard	Pine																

Special Items and Treatments: Base Coat (B), Bullnose Edge (BE), Countertop (C), Concrete Form (CF) Cut to Size (CS), Door Core (DC), Door Stiles and Rails (SR), Edge Fill (EF), Edge Tape (ET), Fill (F), Fire Retardant (FR), Flush Door Skins (FD), Foil (FO), High Density (HD), Hot Melt Wax (H), Laminate Flooring Substrate (LF), Laminated Products (LP), Lockblocks (LB), Low Density (LD), Melamine (M), Mende (MN), Moisture Resistant (MR), Moulding (MO), Moulded Door Skins (MDS), Paint (P), Paper (PA), Perforated (PE), Prefinished (PF), Print (PR), Shelving (S), Smooth Siding (SS), Stair Tread (ST), Textured Siding (TS), Topcoat (T), Tongue and Groove (TG), Turning and Moulding (TM), Vinyl (V), Wood Veneer (W)

All particleboard and MDF facilities in this Guide offer third party certified products to meet the California Air Resources Board (CARB) Airborne Toxic Control Measure (ATCM 93120) regulation. Some facilities may also have been issued a NAF or ULEF Exemption Executive Order from the State of California. CPA maintains a current list of CARB certified and exempt facilities at www.pbmfd.com.

* "No added urea-formaldehyde" (NAUF) and NAF panel products may be eligible for low-emitting materials credit under LEED for Commercial Interiors and LEED for New Construction and Major Renovations

** CARB exempt (NAF/ULEF) manufacturers offer composite wood product categories that have no added formaldehyde (NAF) and/or ultra-low emitting formaldehyde (ULEF), and have been exempted from third party certification requirements of the California Air Resources Board (CARB) ATCM 93120.

PARTICLEBOARD

PARTICLEBOARD

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twparticleboardsales@bc.com
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COLLINS PRODUCTS, LLC

PO Box 16, 6410 Highway 66
Klamath Falls, Oregon 97601
(800) 547-1793 Fax (541) 882-8671
dbarnes@collinsco.com
www.collinswood.com

DURAPLAY DE PARRAL, S.A. DE C.V.

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Barrio de Espana
Parral, Chihuahua Mexico 33870
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FLAKEBOARD

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Markham, Ontario L3R 0G4
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customer.service@flakeboard.com
www.flakeboard.com

Western US Sales
PO Box 428
Albany, Oregon 97321
(888) 650-6302 Fax (541) 928-4116
customer.service@flakeboard.com
www.flakeboard.com

Eastern US Sales
515 River Crossing Drive, Suite 110
Fort Mill, South Carolina 29715-7900
(877) 273-7680 Fax (800) 808-1454
customer.service@flakeboard.com
www.flakeboard.com

FLORIDA PLYWOODS, INC.

PO Box 458, 1228 NW US 221
Greenville, Florida 32331
(850) 948-2211 Fax (850) 948-4616
info@flply.com
www.flply.com

MARSHFIELD DOORSYSTEMS, INC.

1401 East Fourth Street
Marshfield, Wisconsin 54449
(800) 826-4020 Fax (715) 387-4218
www.customdoorcomponents.com

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NORTHERN ENGINEERED WOOD PRODUCTS, INC.

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PLUMMER FOREST PRODUCTS

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P.O. Box 788
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ROSEBURG

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US Sales
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WEBB FURNITURE ENTERPRISES, INC.

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Galax, Virginia 24333
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MEDIUM DENSITY FIBERBOARD



1



2

Medium Density Fiberboard (MDF) is widely used in the manufacture of furniture, kitchen cabinets, door parts, mouldings, millwork and laminate flooring. MDF panels are manufactured with a variety of physical properties and dimensions, providing the opportunity to design the end product with the specific MDF needed.

MDF is a composite panel product typically consisting of cellulosic fibers combined with a synthetic resin or other suitable bonding system and joined together under heat and pressure. Additives may be introduced during manufacturing to impart additional characteristics.

The surface of MDF is flat, smooth, uniform, dense and free of knots and grain patterns. The homogeneous density profile of MDF allows intricate and precise machining and finishing techniques for superior finished products. Trim waste is significantly reduced when using MDF compared to other substrates. Stability and strength are important assets of MDF, which can be machined into complex patterns that require precise tolerances.



3



4

COMMON USES

- DOORS, JAMBS & MILLWORK
- LAMINATING & FINISHING
- EDGE SHAPING & MACHINING
- MOULDING
- EMBOSSING
- OFFICE & RESIDENTIAL FURNITURE
- KITCHEN CABINETS
- PANELING
- LAMINATE FLOORING
- STORE FIXTURES



5



6



7

MDF IS THE PERFECT SOLID WOOD SUBSTITUTE. THE STABILITY, STRENGTH AND HOMOGENEITY OF MDF ALLOW FOR AN INCREASING NUMBER OF APPLICATIONS. INTERIOR MDF MOULDINGS 1 ARE EASILY MACHINED AND LAMINATED OR PAINTED. IT IS WIDELY USED IN THE MANUFACTURE OF KITCHEN CABINETS 2. INTERIOR DESIGNERS FIND NEW AND EXCITING WAYS TO USE MDF SUCH AS DECORATIVE SURFACE PANELING 3. MDF IS USED AS THE CORE MATERIAL IN STORE FIXTURES AND LAMINATE FLOORING 4. MDF CAN BE MACHINED WITH VERY TIGHT TOLERANCES AND IS USED FREQUENTLY IN INTERIOR DOORS 5, OFFICE FURNITURE 6, AND PANELING 7.

ECO-GOLD™

ENGINEERED FOR THE FUTURE

West Fraser's **ECO-GOLD** is a premium quality MDF panel, manufactured by WestPine MDF, that meets the environmental demands required for today's market.

- No Added Formaldehyde
- Manufactured from 100% recycled wood fiber
- Using these products earns green project points
- Ultra low emissions - CARB Certified

West Fraser is committed to producing MDF panels and programs designed to meet the changing needs of today's customers.



West Fraser MDF Sales & Marketing
 9919 - 65 Avenue, Alberta Canada T6E 0L1
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 e-mail: mdf@westfraser.ca
www.westfraser.com/products/panels/panels.asp





Third-party certification to ANSI A208.2 is required for many applications of composite panels. For example, HUD and the states of California and Minnesota require third-party certification of formaldehyde emissions for nearly all MDF and particleboard under their jurisdiction.

FORMALDEHYDE EMISSION LIMITS

The standard has a tiered system of emission levels allowing either a maximum of 0.21 ppm or 0.11 ppm for panels thicker than 8 mm. Panels 8 mm and thinner shall conform to either the 0.21 ppm or 0.13 ppm maximum limit. To meet the needs of the market many MDF manufacturers have voluntarily developed ultra low-emitting and no added urea-formaldehyde (NAUF) products, so there are a wide variety of products available today with reduced formaldehyde levels, as well as a growing number of non-formaldehyde alternatives. Those companies currently producing NAUF products are identified in the product listings in this Guide.

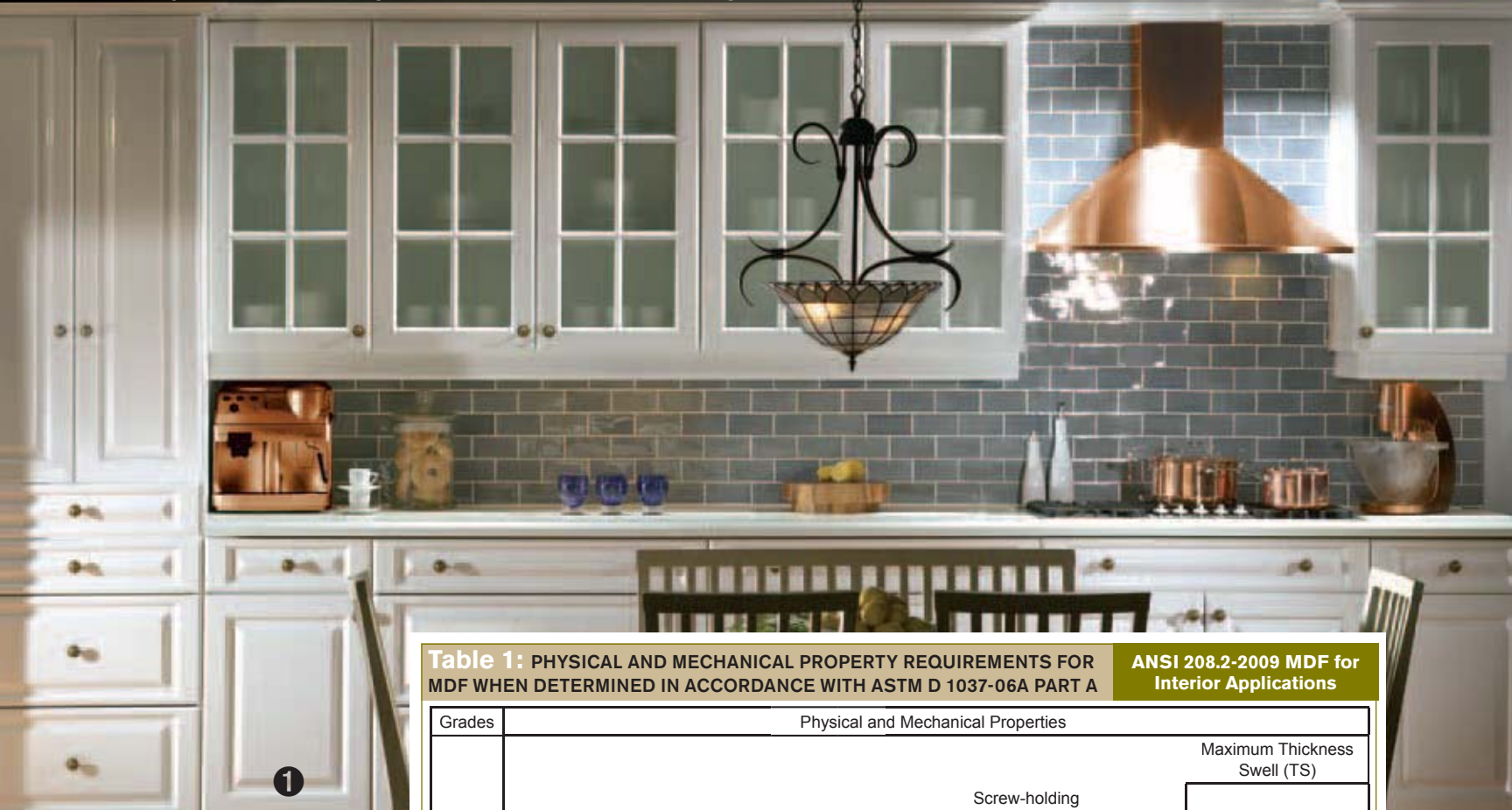
MDF CONTINUED ON PAGE 26 >

PRODUCT STANDARDS AND CERTIFICATION

The American National Standard for Medium Density Fiberboard (ANSI A208.2) is the North American industry voluntary standard. It classifies MDF by physical and mechanical properties and identifies product grades. Specifications identified in the Standard include physical and mechanical properties, dimensional tolerances and formaldehyde emission limits. The Standard was developed through the sponsorship of the Composite Panel Association (CPA), in conjunction with producers, users and general interest groups. A summary of the ANSI Property Requirements are included in this Guide, and copies of the Standard are available from CPA.



THE SMOOTHNESS AND STABILITY OF MDF ENSURES ITS SPECIFICATION IN CUSTOM SHELVING FOR DEMANDING RETAIL ENVIRONMENTS ❶. MDF IS WELL SUITED FOR RESIDENTIAL CONSTRUCTION OF MODERN HOMES ❷, WHERE CLEAR-COATED MDF WAS USED FOR INTERIOR WALLS, DOORS AND CASEWORK IN THIS DESIGNER HOME ❸, AS WELL AS IN MORE TRADITIONAL HOMES ❹, WHERE CABINETS AND BUILT-INS SHOWCASE THE PERFORMANCE OF MDF BEAUTIFULLY.



1

2

Table 1: PHYSICAL AND MECHANICAL PROPERTY REQUIREMENTS FOR MDF WHEN DETERMINED IN ACCORDANCE WITH ASTM D 1037-06A PART A **ANSI 208.2-2009 MDF for Interior Applications**

Grades	Physical and Mechanical Properties											
									Screw-holding		Maximum Thickness Swell (TS)	
	Modulus of Rupture (MOR)		Modulus of Elasticity (MOE)		Internal Bond (IB)		Face		Edge		Panel Thickness	
	N/mm ²	(psi)	N/mm ²	(psi)	N/mm ²	(psi)	N	(pounds)	N	(pounds)	≤15 mm	>15 mm
										mm (inch)	percent	
115	12.4	1800	1241	180000	0.47	68	703	158	601	135	1.65 (0.065)	11%
130	21.6	3130	2160	313000	0.54	78	988	222	787	177	1.65 (0.065)	11%
155	27.9	4050	2792	405000	0.81	117	1201	270	1001	225	1.65 (0.065)	11%



Table 2: PHYSICAL AND MECHANICAL PROPERTY REQUIREMENTS FOR MDF WHEN DETERMINED IN ACCORDANCE WITH ASTM D 1037-06a PART B TEST METHODS FOR HARDBOARD

Grades	Physical and Mechanical Properties					
	Modulus of Rupture (MOR)		Internal Bond (IB)		Maximum Thickness Swell (TS)	
	N/mm ²	(psi)	N/mm ²	(psi)	mm	(inch)
210	18.9	2741	0.32	46	2.2	(0.087)
220	28.9	4192	0.54	78	2.2	(0.087)
230	28.9	4192	0.90	131	2.2	(0.087)

In addition, CPA's Environmentally Preferable Product (EPP) program (to which a majority of the North American producers subscribe) requires emission limits no higher than the California Air Resources Board (CARB) Airborne Toxic Control Measure ("CARB Rule").

Finally, various overlays and surface treatments have been shown to significantly reduce product emissions. For additional information about emissions, see the CPA Technical Bulletin VOC Emission Barrier Effects. ■

PROPERTY REQUIREMENTS COMMON TO ALL MDF

Properties	Tolerance Limits
Panel Length or Width ≥ 0.61 m (2 feet)	± 2.0 mm (0.080 inch)
Panel Average from Specified Thickness	± 0.125 mm (0.005 inch)
Variance from Panel Average Thickness	± 0.125 mm (0.005 inch)
Linear Expansion (LE)	≤ 0.33 percent
Formaldehyde Emissions	See below

Formaldehyde Emissions ≤ 0.21 ppm or ≤ 0.11 ppm for MDF with a minimum thickness greater than 8mm.
 Formaldehyde Emissions ≤ 0.21 ppm or ≤ 0.13 ppm for MDF with a maximum thickness ≤ 8mm.

MDF IS THE MATERIAL OF CHOICE IN HOME INTERIORS 1 AND COMMERCIAL SPACES 2, WHERE TIGHT TOLERANCES, SMOOTH SURFACES AND INTRICATE MACHINING ARE CRITICAL.

MEDIUM DENSITY FIBERBOARD

COMPOSITE PANEL ASSOCIATION



COMPANY AND MILL LOCATION	BRAND NAME	WOOD SPECIES	CERTIFIED WOOD	EPP CERTIFIED	NAUF (NO ADDED UREA-FORMALDEHYDE)*	CARB EXEMPT (ULEF / NAF)**	LOW DENSITY	STANDARD DENSITY	HIGH DENSITY	MOISTURE RESISTANT	SPECIAL ITEMS AND TREATMENTS (SEE LEGEND BELOW)	PRESS SIZE (FT.)	THICKNESS RANGE (IN.)	DENSITY RANGE (LBS/FT ³)
CLARION BOARDS, INC.														
Clarion, Pennsylvania	Standard Premium, Flooring Premium, Standard Premium High Density	Hardwoods Northern Softwoods	FSC	•	•	•	•	•	•	•	HD LD LF LP M MO MR	10xContinuous	3/16 – 1-1/8	38 – 57
DEL-TIN FIBER, LLC														
El Dorado, Arkansas	Solidium, Solidium Free	Southern Pine			•	•	•	•	•	•	CS LF LD MO MR S	9xContinuous	3/16 – 1	40 – 60
FLAKEBOARD														
Bennettsville, South Carolina	Premier®, Premier® Plus, Premier® HD, Premier® MR, Vesta	Pine	FSC	•	•		•	•	•		CS FR HD LD	5x18	3/8 – 2	39 – 55
Eugene, Oregon	Premier®, Premier® Plus, Premier® FR, Premier® MR, Vesta, elite™, Evo	Douglas Fir, Hemlock	FSC	•	•		•	•	•		C-MDF FR HD LD	4x16	1/4 – 1-1/4	32 – 55
Malvern, Arkansas	Premier®, Premier® Plus, Premier® MR, Vesta	Pine		•	•		•	•	•		CS HD S	5x18, 5x24	3/8 – 1-1/2	41 – 46
Sault Ste. Marie, Ontario	Superior MDF, Superior Plus MDF, Superior SW, Superior Lite, Vesta	Spruce, Pine, Fir	FSC	•	•		•	•	•		LP LD M PF	10xContinuous	3/16 – 1-1/2	40 – 48
St. Stephen, New Brunswick	FibreX®, Fibrex Vesta	Mixed Hardwoods	FSC	•	•				•		B CS F FR FO HD LF M MR P PA PE	5xContinuous, 5xContinuous	1/16 – 5/16	55 – 62
GEORGIA-PACIFIC WOOD PRODUCTS LLC														
Monticello, Georgia	InfiniCor	Southern Pine		•				•			B CS F FD FO MN P PA PE PF PR T	4xContinuous	1/10 – 1/4	50 – 56
KRONOSPAN LLC														
Eastaboga, Alabama	Krono-light, Krono-med, Krono-DR Krono-dur, Krono-dur plus	Southern Pine, Light Hardwood					•	•	•		CS HD LF LD MR	10xContinuous	1/8 – 1-1/2	32 – 62
LANGBOARD, INC.														
Willacoochee, Georgia	Langboard MDF, Elite®	Southern Yellow Pine		•			•	•	•		BE CS DC MO S ST TM	5x18	3/8 – 1-1/2	41 – 52
MADERAS CONGLOMERADAS S.A. DE C.V.														
Tlalnepantla, Mexico	MACOCELL	Pine						•			CS LP P W	4 X Continuous 7 X Continuous	1/12 – 7/32	48-51
PAN PACIFIC PRODUCTS, INC.														
Broken Bow, Oklahoma	Megaboard	100% Pine			•		•	•	•		DC SR HD LD	8x20	3/4 – 4	22 – 65

PLUM CREEK MDF, INC.														
Columbia Falls, Montana	Super Refined MDF2®, Thin HDF, Glacier Green™ and Glacier Clear™	Western Softwoods	SFI / SCS	•	•	•	•	•	•	CS FD HD LD LF MR	5x18, 10xContinuous	1/16 – 1-1/2	40 – 60	
SIERRAPINE														
Medford, Oregon	ARREIS, Medex, Medite, Medite II	Western Softwoods	FSC	•	•	•	•	•	•	CS DC EXT FR HD LD LP MR MO	5x18	1/4 – 1-1/2	40 – 55	
Rocklin, California	Medite FR, Medite 3D, Permacore Rock-Top	Western Pine	FSC	•	•	•	•			PF PR S TM W CS FD LD MN MO P PF PR S SR T	8xContinuous	2mm – 7mm	45 – 50	
TEMPLE-INLAND														
Mt. Jewett, Pennsylvania	ULTRASTOCK	Mixed Hardwoods	FSC	•	•	•	•	•	•	BE CS HD LD LF MO MR S	9x25	7/32 – 1-5/16	40 – 55	
UNIBOARD														
Moncure, North Carolina	Uniboard MDF	Southern Pine	FSC	•			•	•	•	HD LD M MO	10xContinuous	5.6 – 9.8mm	33 – 57	
Mont-Laurier, Quebec	Uniboard MDF	Softwood, Hardwood	FSC	•	•	•	•	•	•	HD LD MO	9xContinuous	9.53 – 28.58		
UNILIN US MDF														
Mt. Gilead, North Carolina		Southern Yellow Pine		•				•	•	CS FD HD LF MR PR	9xContinuous	1/16 – 3/8	45 – 62	
WEST FRASER MILLS LTD.														
Quesnel, British Columbia	WestPine MDF, EcoGold™	Spruce, Pine, Fir		•	•	•	•	•	•	HD LF LD	10xContinuous	3mm – 3/4	41 – 60	
White Court, Alberta	Ranger Board	Spruce, Pine, Fir		•			•	•	•	HD LF LD	6x24	3/8 – 1-1/2	41 – 60	

Special Items and Treatments: Base Coat (B), Bullnose Edge (BE), Countertop (C), Concrete Form (CF), Colored MDF (C-MDF), Cut to Size (CS), Door Core (DC), Door Stiles and Rails (SR), Edge Fill (EF), Edge Tape (ET), Fill (F), Fire Retardant (FR), Flush Door Skins (FD), Foil (FO), High Density (HD), Hot Melt Wax (H), Laminate Flooring Substrate (LF), Laminated Products (LP), Lockblocks (LB), Low Density (LD), Melamine (M), Mende (MN), Moisture Resistant (MR), Moulding (MO), Moulded Door Skins (MDS), Paint (P), Paper (PA), Perforated (PE), Prefinished (PF), Print (PR), Shelving (S), Smooth Siding (SS), Stair Tread (ST), Textured Siding (TS), Topcoat (T), Tongue and Groove (TG), Turning and Moulding (TM), Vinyl (V), Wood Veneer (W)

All particleboard and MDF facilities in this Guide offer third party certified products to meet the California Air Resources Board (CARB) Airborne Toxic Control Measure (ATCM 93120) regulation. Some facilities may also have been issued a NAF or ULEF Exemption Executive Order from the State of California. CPA maintains a current list of CARB certified and exempt facilities at www.pbmdf.com.

* "No added urea-formaldehyde" (NAUF) and NAF panel products may be eligible for low-emitting materials credit under LEED for Commercial Interiors and LEED for New Construction and Major Renovations.

** CARB exempt (NAF/ULEF) manufacturers offer composite wood product categories that have no added formaldehyde (NAF) and/or ultra-low emitting formaldehyde (ULEF), and have been exempted from third party certification requirements of the California Air Resources Board (CARB) ATCM 93120.

MDF/HARDBOARD/ ENGINEERED WOOD SIDING AND TRIM

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HARDBOARD



Hardboard is used in a variety of applications including furniture components, moulded door skins, wall paneling, underlayment and perforated boards.

Hardboard is a composite panel manufactured primarily from inter-felted ligno-cellulosic fibers consolidated under heat and pressure. Other materials may be added during the manufacturing process to improve certain properties, such as resistance to abrasion and moisture, and to increase strength and durability.

Hardboard has a uniform thickness, density and appearance and has no grain. It resists marring, scuffing and abrasion, as well as changes in temperature and humidity. Hardboard can be cut, routed, shaped and drilled with standard woodworking tools. In addition, hardboard can be securely glued or fastened with screws, staples or nails. Hardboard panels can be laminated with paper overlays, plastic laminates and veneers.



HARDBOARD'S LIGHT WEIGHT, THIN PROFILE AND STRUCTURAL INTEGRITY MAKE IT THE RIGHT CHOICE FOR BACKING MATERIAL ON HOUSEHOLD FURNITURE ①, INTERIOR WALL PANELING ④ AND DRAWER BOTTOMS. ② PERFORATED HARDBOARD HAS LONG BEEN A STAPLE IN HOME ORGANIZATION AND STORAGE ②, ⑤.



COMMON USES

- PREFINISHED PANELING
- OFFICE & RESIDENTIAL FURNITURE
- PERFORATED BOARD
- DOOR SKINS
- UNDERLAYMENT



4

PRODUCT STANDARDS AND CERTIFICATION

The American National Standard for Basic Hardboard (ANSI A135.4) is the North American industry standard. It classifies hardboard by thickness and physical properties, and includes five classes: Tempered, Standard, Service-Tempered, Service and Industrialite. Copies of the Standard are available from the Composite Panel Association (CPA).

The American National Standard for Prefinished Hardboard Paneling (ANSI A135.5) establishes the property requirements for dimensional tolerances and moisture content, along with resistance to abrasion, fading, heat, humidity, scrape, steam and stain. Requirements for washability, gloss, workmanship and flame spread are also specified. ■



5

Hardboard: THICKNESS & PHYSICAL PROPERTIES

ANSI A135.4-2004 Basic Hardboard		MOISTURE RESISTANCE (MAX. AVERAGE PER PANEL)			MODULUS OF RUPTURE (MINIMUM AVERAGE PER PANEL)		TENSILE STRENGTH (MIN. AVERAGE PER PANEL)			
CLASS	NOMINAL THICKNESS		WATER ABSORPTION BASED ON	THICKNESS SWELLING			PARALLEL TO SURFACE		PERPENDICULAR TO SURFACE	
	mm	inch	percent	percent	MPa	psi	MPa	psi	MPa	psi
1 TEMPERED	2.1	1/12	30	25	41.4	6000	20.7	3000	0.90	130
	2.5	1/10	25	20						
	3.2	1/8	25	20						
	4.8	3/16	25	20						
	6.4	1/4	20	15						
	7.9	5/16	15	10						
2 STANDARD	2.1	1/12	40	30	31.0	4500	15.2	2200	0.62	90
	2.5	1/10	35	25						
	3.2	1/8	35	25						
	4.8	3/16	35	25						
	6.4	1/4	25	20						
	7.9	5/16	20	15						
3 SERVICE-TEMPERED	3.2	1/8	35	30	31.0	4500	13.8	2000	0.52	75
	4.8	3/16	30	30						
	6.4	1/4	30	25						
	9.5	3/8	20	15						
4 SERVICE	3.2	1/8	45	35	20.7	3000	10.3	1500	0.34	50
	4.8	3/16	40	35						
	6.4	1/4	40	30						
	9.5	3/8	35	25						
	11.1	7/16	35	25						
	12.7	1/2	30	20						
5 INDUSTRIALITE	6.4	1/4	50	30	13.8	2000	6.9	1000	0.17	25
	9.5	3/8	40	25						
	11.1	7/16	40	25						
	12.7	1/2	35	25						
	15.9	5/8	30	20						

ENGINEERED WOOD SIDING AND TRIM

COMMON USES

INTERIOR TRIM

SIDING

EXTERIOR TRIM

Engineered Wood Siding and Trim (EWST) are categories of composite panels that have been designed and manufactured to perform in interior and exterior exposure applications with the appearance of traditional wood. These advanced composites can be engineered with enhanced resistance to moisture, dimensional stability and protection against fungal decay and termites. The engineered properties translate into long-lasting durability allowing for decades of service life while maintaining their attractive appearance. Today's engineered wood siding and trim products are highly versatile and come in many forms including sophisticated woodgrains and embossed surfaces.

ENGINEERED WOOD SIDING CONTINUED ON PAGE 32 >



ENGINEERED WOOD SIDING AND TRIM ARE MANUFACTURED TO WITHSTAND THE RIGORS OF SEASONAL WEATHER EXPOSURE.





The American National Standard for Hardboard Siding (ANSI A135.6), now referred to as the Engineered Wood Siding standard, covers requirements and methods of testing for exterior durability, dimensions, straightness, squareness, physical properties and surface characteristics. It also includes trade terms and methods of identifying engineered wood siding. Third-party certification to the ANSI Standards is required for many applications of siding panels. Many building code jurisdictions require the physical properties of engineered wood siding to be third-party certified. CPA's accredited certification program is recognized and approved by building code officials to evaluate siding products for code compliance. ■

TODAY'S SIDING AND TRIM PRODUCTS ARE OFFERED IN A WIDE RANGE OF TEXTURES, WIDTHS AND PROFILES THAT CAN CREATE ENDLESS STYLES AND THEMES.



HARDBOARD

ENGINEERED WOOD SIDING AND TRIM

COMPANY AND MILL LOCATION		BRAND NAME	WOOD SPECIES	CERTIFIED WOOD	EPP CERTIFIED	NAUF (NO ADDED UREA-FORMALDEHYDE)*	SURFACES		CLASS		APPLICATION					SPECIAL ITEMS AND TREATMENTS (SEE LEGEND BELOW)	PRESS SIZE (FT.)	THICKNESS RANGE (IN.)	DENSITY RANGE (LBS/FT ³)	
						TWO-SIDED (S2S)	ONE-SIDED (S1S)	TEMPERED	UN-TEMPERED	INDUSTRIAL	DOOR SKIN/FACE	TILEBOARD	INTERIOR PANELING	SIDING	TRIM					
COLLINS PRODUCTS, LLC																				
Klamath Falls, Oregon	TruWood Siding & Trim	Western Softwoods	FSC /SCS	•	•	•	•	•	•					•	•	•	B BE CF CS LP MR P PM SS TS TG UP	4x16	7/16 – 5/4	47
CMI/CRAFTMASTER MANUFACTURING, INC.																				
Towanda, Pennsylvania	CraftMaster molded door designs	Hardwoods	SCS	•	•	•	•	•	•		•						MDS	5x7, 5x14	1/8	60
	Extira panels	Hardwoods	SCS	•	•	•	•	•	•	•							MR UP	4x16	1/2 – 1-1/4	45 - 49
	MiraTEC trim	Hardwoods	SCS	•	•	•	•	•	•								MR PM	4x16	4/4, 5/4	47
GEORGIA-PACIFIC WOOD PRODUCTS LLC																				
Duluth, Minnesota	SuperWood	Aspen, Mixed Hardwoods	SFI	•	•	•	•	•	•	•	•						B CS GD F P PE PF PR T	4x16, 5-1/2x16	1/16 – 9/32	60 - 65
Phillips, Wisconsin	Jubilee, Lionite, UltraStrate	Aspen, Mixed Hardwoods	SFI	•	•	•	•	•	•	•		•	•				B CS F P PE PF PR T	4x8	1/10 – 1/4	62 - 66
LOUISIANA-PACIFIC CORPORATION																				
East River, Nova Scotia	Canexel	Hardwood	ISO-9001 SFI	•	•	•	•	•	•					•			PF TS	7x16, 4x24	3/8 – 7/16	58 - 65
Roaring River, North Carolina	SmartSide	Mixed Hardwoods	SFI	•	•	•	•	•	•					•	•		PF PM SS TS UP	4x16, 4x18	7/16 – 1/2	47-52
SACOPAN, INC.																				
Sacre-Coeur, Quebec	SACOPAN	SPF, Sawmill Residuals									•						MDS	65x90	1/8	60 - 65
STIMSON LUMBER COMPANY																				
Forest Grove, Oregon	Stimson Hardboard Duratrim	Douglas Fir	SFI	•	•	•	•	•	•	•	•						B CS HD LD M P PE PF PM TS	4x16	1/10 – 5/8	50 - 70

Special Items and Treatments: Base Coat (B), Bullnose Edge (BE), Countertop (C), Concrete Form (CF) Cut to Size (CS), Door Core (DC), Door Stiles and Rails (SR), Edge Fill (EF), Edge Tape (ET), Fill (F), Fire Retardant (FR), Flush Door Skins (FD), Foil (FO), Garage Door Panels (GD), High Density (HD), Hot Melt Wax (H), Laminate Flooring Substrate (LF), Laminated Products (LP), Lockblocks (LB), Low Density (LD), Melamine (M), Mende (MN), Moisture Resistant (MR), Moulding (MO), Moulded Door Skins (MDS), Paint (P), Paper (PA), Perforated (PE), Prefinished (PF), Primed (PM), Print (PR), Shelving (S), Smooth Siding (SS), Stair Tread (ST), Textured Siding (TS), Topcoat (T), Tongue and Groove (TG), Turning and Moulding (TM), Unprimed (UP), Vinyl (V), Wood Veneer (W)

* "No added urea-formaldehyde" (NAUF) panel products may be eligible for low-emitting materials credit under LEED for Commercial Interiors and LEED for New Construction and Major Renovations.

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ENGINEERED WOOD SIDING AND TRIM

COMMON USES

INTERIOR TRIM

SIDING

EXTERIOR TRIM

Engineered Wood Siding and Trim (EWST) are categories of composite panels that have been designed and manufactured to perform in interior and exterior exposure applications with the appearance of traditional wood. These advanced composites can be engineered with enhanced resistance to moisture, dimensional stability and protection against fungal decay and termites. The engineered properties translate into long-lasting durability allowing for decades of service life while maintaining their attractive appearance. Today's engineered wood siding and trim products are highly versatile and come in many forms including sophisticated woodgrains and embossed surfaces.

ENGINEERED WOOD SIDING CONTINUED ON PAGE 32 >



ENGINEERED WOOD SIDING AND TRIM ARE MANUFACTURED TO WITHSTAND THE RIGORS OF SEASONAL WEATHER EXPOSURE.





The American National Standard for Hardboard Siding (ANSI A135.6), now referred to as the Engineered Wood Siding standard, covers requirements and methods of testing for exterior durability, dimensions, straightness, squareness, physical properties and surface characteristics. It also includes trade terms and methods of identifying engineered wood siding. Third-party certification to the ANSI Standards is required for many applications of siding panels. Many building code jurisdictions require the physical properties of engineered wood siding to be third-party certified. CPA's accredited certification program is recognized and approved by building code officials to evaluate siding products for code compliance. ■

TODAY'S SIDING AND TRIM PRODUCTS ARE OFFERED IN A WIDE RANGE OF TEXTURES, WIDTHS AND PROFILES THAT CAN CREATE ENDLESS STYLES AND THEMES.



HARDBOARD

ENGINEERED WOOD SIDING AND TRIM

COMPANY AND MILL LOCATION		BRAND NAME	WOOD SPECIES	CERTIFIED WOOD	EPP CERTIFIED	NAUF (NO ADDED UREA-FORMALDEHYDE)*	SURFACES		CLASS		APPLICATION					SPECIAL ITEMS AND TREATMENTS (SEE LEGEND BELOW)	PRESS SIZE (FT.)	THICKNESS RANGE (IN.)	DENSITY RANGE (LBS/FT ³)	
						TWO-SIDED (S2S)	ONE-SIDED (S1S)	TEMPERED	UN-TEMPERED	INDUSTRIAL	DOOR SKIN/FACE	TILEBOARD	INTERIOR PANELING	SIDING	TRIM					
COLLINS PRODUCTS, LLC																				
Klamath Falls, Oregon	TruWood Siding & Trim	Western Softwoods	FSC /SCS	•	•	•	•	•	•					•	•	•	B BE CF CS LP MR P PM SS TS TG UP	4x16	7/16 – 5/4	47
CMI/CRAFTMASTER MANUFACTURING, INC.																				
Towanda, Pennsylvania	CraftMaster molded door designs	Hardwoods	SCS	•	•	•	•	•	•		•						MDS	5x7, 5x14	1/8	60
	Extira panels	Hardwoods	SCS	•	•	•	•	•	•	•							MR UP	4x16	1/2 – 1-1/4	45 - 49
	MiraTEC trim	Hardwoods	SCS	•	•	•	•	•	•								MR PM	4x16	4/4, 5/4	47
GEORGIA-PACIFIC WOOD PRODUCTS LLC																				
Duluth, Minnesota	SuperWood	Aspen, Mixed Hardwoods	SFI	•	•	•	•	•	•	•	•						B CS GD F P PE PF PR T	4x16, 5-1/2x16	1/16 – 9/32	60 - 65
Phillips, Wisconsin	Jubilee, Lionite, UltraStrate	Aspen, Mixed Hardwoods	SFI	•	•	•	•	•	•	•		•	•				B CS F P PE PF PR T	4x8	1/10 – 1/4	62 - 66
LOUISIANA-PACIFIC CORPORATION																				
East River, Nova Scotia	Canexel	Hardwood	ISO-9001 SFI	•	•	•	•	•	•					•			PF TS	7x16, 4x24	3/8 – 7/16	58 - 65
Roaring River, North Carolina	SmartSide	Mixed Hardwoods	SFI	•	•	•	•	•	•					•	•		PF PM SS TS UP	4x16, 4x18	7/16 – 1/2	47-52
SACOPAN, INC.																				
Sacre-Coeur, Quebec	SACOPAN	SPF, Sawmill Residuals									•						MDS	65x90	1/8	60 - 65
STIMSON LUMBER COMPANY																				
Forest Grove, Oregon	Stimson Hardboard Duratrim	Douglas Fir	SFI	•	•	•	•	•	•	•	•						B CS HD LD M P PE PF PM TS	4x16	1/10 – 5/8	50 - 70

Special Items and Treatments: Base Coat (B), Bullnose Edge (BE), Countertop (C), Concrete Form (CF) Cut to Size (CS), Door Core (DC), Door Stiles and Rails (SR), Edge Fill (EF), Edge Tape (ET), Fill (F), Fire Retardant (FR), Flush Door Skins (FD), Foil (FO), Garage Door Panels (GD), High Density (HD), Hot Melt Wax (H), Laminate Flooring Substrate (LF), Laminated Products (LP), Lockblocks (LB), Low Density (LD), Melamine (M), Mende (MN), Moisture Resistant (MR), Moulding (MO), Moulded Door Skins (MDS), Paint (P), Paper (PA), Perforated (PE), Prefinished (PF), Primed (PM), Print (PR), Shelving (S), Smooth Siding (SS), Stair Tread (ST), Textured Siding (TS), Topcoat (T), Tongue and Groove (TG), Turning and Moulding (TM), Unprimed (UP), Vinyl (V), Wood Veneer (W)

* "No added urea-formaldehyde" (NAUF) panel products may be eligible for low-emitting materials credit under LEED for Commercial Interiors and LEED for New Construction and Major Renovations.

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Fax +52 (55) 57155960
ranzjorge@yahoo.com
www.macosa.com.mx

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waynes@panpacificproducts.com
www.panpacificproducts.com

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will.warberg@plumcreek.com
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gconnolly@stimsonlumber.com
www.stimsonlumber.com

HIGH PRESSURE LAMINATES

COMMON USES

- TABLETOPS
- COUNTERTOPS
- FURNITURE
- CABINERY
- CASE GOODS
- FLOORING



HPL is the direct descendent of the original plastic laminate. It is considered to be one of the most durable decorative surface materials and is available with special performance properties including chemical, fire and wear resistance. Special grades of HPL can be postformed around curved edges by application of heat and restraint.

HPL is produced by saturating multiple layers of kraft paper with phenolic resin. A layer of printed décor paper is placed on top of the kraft paper before pressing. The resulting sandwich is fused together under heat and pressure (more than 1,000 PSI). Because phenolic and melamine resins are thermoset plastics, the curing process transforms the resin into plastic by a cross linking process that converts the paper sheets into a single, rigid laminated sheet. Thermosetting creates strong, irreversible bonds that contribute to HPL's durability.

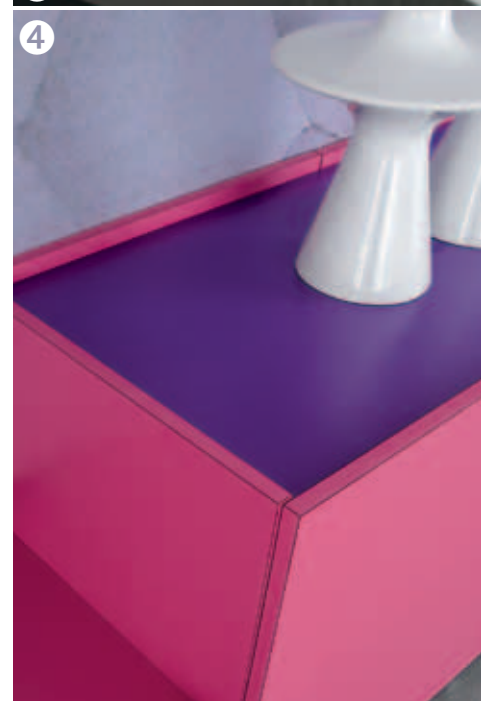
HPL is laminated to a panel utilizing a variety of adhesives. Particleboard or MDF are the preferred substrate because they provide a stable, durable, consistent and economical foundation.

Due to its durability, HPL is a common choice for horizontal surfaces including flooring, countertops and desktops. It also performs well in horizontal and vertical applications for high traffic settings such as hospitality, office furniture, healthcare, retail casework, commercial interiors and educational facilities.

A relatively new development in HPL technology is Double Belt Press (DBP) for the production of Continuous Pressed Laminate (CPL). CPL is decorative paper impregnated with resins and fused under heat and high pressure with resin-impregnated backer(s). Laminate properties are similar to standard HPL and typical thickness range is .4 mm to 1mm. CPL is available in desired sheet lengths or continuous rolls.

Flexible CPL is decorative paper impregnated with flexible thermosetting resins and fused under heat and high pressure with resin-impregnated backer(s). This engineered CPL offers a unique range of formable decorative laminates suitable for profile wrapping and edgbanding applications. Common thickness range is .2 mm through .4 mm. Surface properties are similar to vertical grade HPL and are used significantly to complement HPL and TFM laminates.

HPL CONTINUED ON PAGE 36 >



SPECIAL CUSTOM LAMINATES ① CAN BE PRODUCED TO MATCH THE THEME OR DÉCOR OF ANY ENVIRONMENT. DESIGNERS AND ARCHITECTS OFTEN SPECIFY THEM FOR RESTAURANT SETTINGS ②. HIGH PRESSURE LAMINATE IS CONSIDERED ONE OF THE MOST DURABLE DECORATIVE SURFACE MATERIALS AND PERFORMS VERY WELL FOR HORIZONTAL APPLICATIONS SUCH AS COUNTERTOPS ③ AND FURNITURE ④.



ITS DURABILITY MAKES HPL PERFECT FOR LAMINATE FLOORING AND OFFICE FURNITURE ①. HPL COUNTERTOPS AREN'T JUST FOR KITCHENS; THEY CAN STAND UP TO THE RIGOROUS DEMANDS OF SCIENCE LABS AND CLASSROOMS ②.

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Website: www.hopewellplastics.com

There are many types or grades of high pressure laminates engineered for specific performance requirements:

GENERAL PURPOSE: Most widely used HPL and suitable for horizontal and vertical surface applications. Typical thickness range from 0.028" to 0.048" (0.71 to 1.22 mm).

POSTFORMING: Can be formed around curved edges by application of heat and restraint. Maximum thickness is approximately 0.038" (0.97 mm) and can normally be formed to radii as small as 3/8" (9.5 mm).

BACKER: HPL produced without a decorative face. Available as standard (most common; slightly thinner than decorative HPL) or regrind (reclaimed HPL with decorative sheet sanded off).

SPECIAL PRODUCTS: Special purpose high pressure laminates include cabinet liners, high-wear, fire-rated, electrostatic dissipative and chemical resistant laminates.

In addition to aesthetic attributes, the lamination of particleboard or MDF with HPL can improve the physical performance of the substrate. For example, a shelf of 3/4" industrial (M-2) particleboard that is 24" long will carry 45 lbs per square foot (psf) of uniform loading with 0.133" deflection. The same shelf can carry 85 lbs psf before reaching the same deflection if overlaid with HPL. ■



THERMALLY FUSED MELAMINE

COMMON USES

LAMINATE FLOORING

CABINETS

COUNTERTOPS

SHELVING

STORE FIXTURES

HOME OFFICE FURNITURE

1



TFM or thermally fused melamine is made by fusing a resin-impregnated sheet of décor paper directly to a substrate. There is no kraft paper used in TFM, and the resulting panel is ready for finishing. The décor paper generally weighs between 60 and 130 g/m² and is the same as the paper used in the production of HPL, making for easy matching across materials. Heat and pressure activate the resin in the saturated TFM sheet, creating a cross-linked bond with the substrate. This effectively seals the substrate. Particleboard and MDF are ideal substrates for TFM because they are consistent, uniform in strength and free of defects.

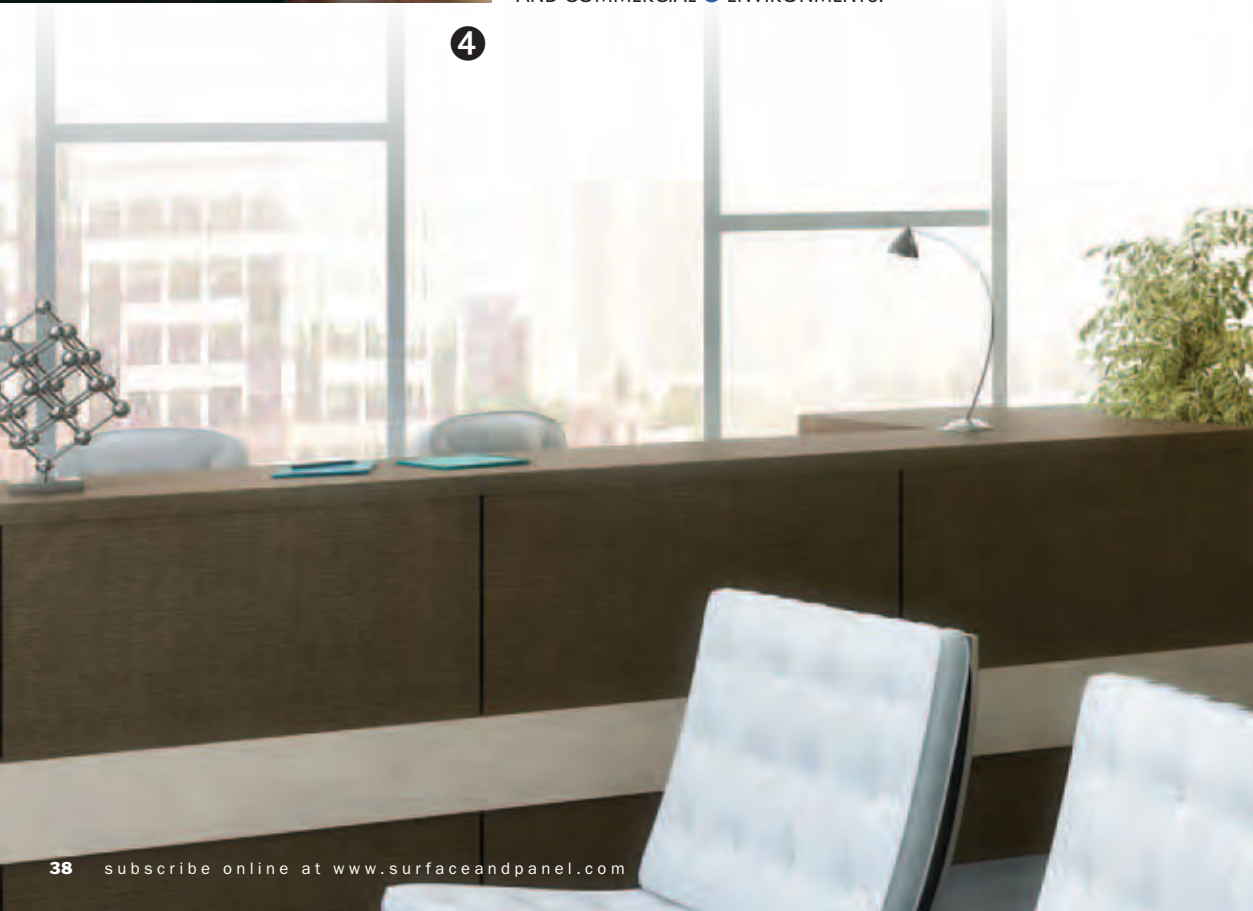
TFM CONTINUED ON PAGE 40 >

DECORATIVE PAPERS SATURATED WITH REACTIVE RESINS, CURED UNDER HEAT OR PRESSURE AND PERMANENTLY FUSED TO A SUBSTRATE SUCH AS PARTICLEBOARD AND MDF BECOME BOTH A DECORATIVE AND A CONSTRUCTION MATERIAL 1. THESE PANELS ARE OFTEN REFERRED TO AS THERMALLY FUSED MELAMINE (TFM) AND ARE USED EXTENSIVELY IN THE PRODUCTION OF CABINETS AND COUNTERTOPS IN RESIDENTIAL 2, 3 AND COMMERCIAL 4 ENVIRONMENTS.



2

4





1



2

TFM decorative panels can be manufactured with enhanced visual and performance characteristics. Surface textures are created with steel press plates that emboss the decorative overlay to heighten the realism of wood grain, stone or abstract designs. Steel press plates can also be used to create or control the gloss level of the surface.

TFM decorative panels have excellent scratch and wear resistance. They are widely used in laminate flooring, office furniture, closet system components, store fixtures and cabinets. It is also an appropriate spec in healthcare, hospitality, commercial and retail settings. TFM decorative panels typically require a decorative edge treatment and can be specified with or without edge, and with single or opposite-side face treatments. Due to the performance, design flexibility and cost advantages, TFM offers an excellent option for designers and specifiers.

NAVIGATING THE WAY

FUNDER
AMERICA, INC.

TRADITION MEETS INNOVATION



Since 1973, Funder America (FAI) has drawn from its century-old Austrian heritage to bring vertically integrated innovation, technology and flexibility to customers throughout the U.S. Three strategically located TFM panel and component-manufacturing facilities include the Mocksville, N.C., headquarters, which houses Funder's exclusive saturation business, large-volume panel lamination and full component capabilities. It's also home to a recently added state-of-the-art powder-coating facility; MDF powder coating is a cost-efficient and environmentally friendly technology that offers design flexibility, seamless edges and an unlimited range of shapes.



Whatever your decorative surface needs, Funder has an innovative cost-effective solution. Funder's own Navigator Collection of 10 on-trend woodgrain designs brings excellent realism and rich character to panel-based furniture, fixtures and casework.

FUNDER AMERICA AT A GLANCE

- Largest component fabricator in North America.
- Vertically integrated company with a packaging division for labeling and assembly
- Surface Synergies partner to provide exact matches for various laminates (TFM, HPL, thermofoil, edgebanding)

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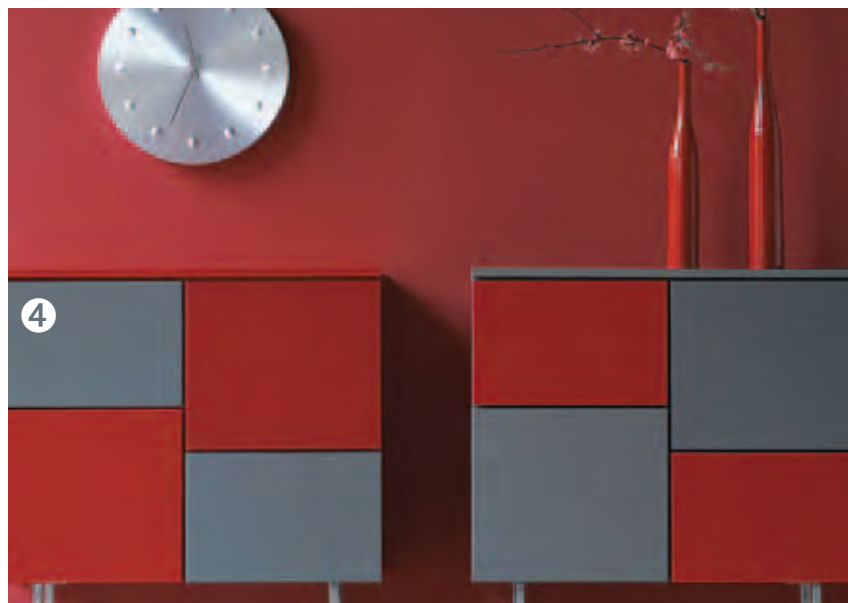


The two most common thermoset resin systems used in TFM decorative panels:

MELAMINE: The resin is introduced into the paper during an impregnating operation. After the paper is impregnated it is partially cured (B stage) using curing ovens. The melamine resin is fully cured under heat and pressure during hot press lamination. The B staged paper has a definite shelf life that varies with temperature and humidity. Melamine resins are fully cured at 300-400 psi and 300-400 F. They are noted for their hardness, scratch resistance and color stability and are the most commonly used resin in saturated paper overlays.

THERMALLY FUSED MELAMINE PROVIDES EXCELLENT HARDNESS AND SCRATCH RESISTANCE, SUFFICIENTLY DURABLE FOR COMMERCIAL INTERIORS ❶, LAMINATE FLOORING APPLICATIONS ❷, MODERN KITCHENS ❸ AND OFFICE FURNITURE ❹.

POLYESTER: The resin is introduced into the paper during an impregnating operation. After the paper is impregnated it is partially cured (B stage) using curing ovens. Polyester resin is fully cured at 175-200 psi and 275-350 F during hot press lamination. The B staged paper has a definite shelf life that varies with temperature and humidity. Polyester resins are noted for their chemical, stain, water and impact resistance, color clarity and machinability. ■



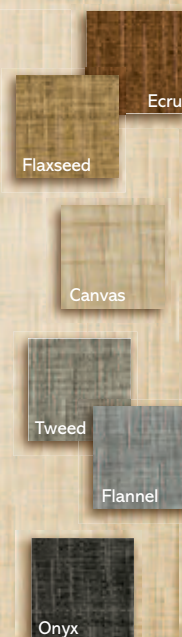
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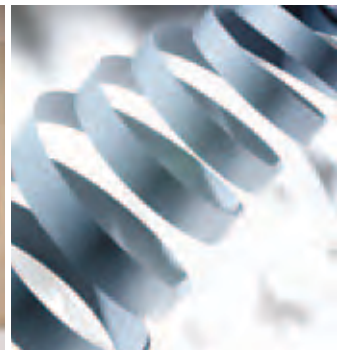
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DECORATIVE FOILS



Decorative foils are an intermediate-range paper-based overlay and are also called impregnated papers. They are generally pre-impregnated with a blend of melamine, acrylic and urea resins during the paper-manufacturing process or post-impregnated after the paper is fully cured. Decorative foils weigh between 40 and 200 grams/m² untreated. During the impregnation process, the cellulose papers typically gain between 20 and 50 percent of their base weight. Those between 100 and 200 grams are dubbed specialty papers and are more likely than lighter-weight varieties to be used for exposed decorative surfaces.



HEAT TRANSFER FOILS

Heat transfer foils involve the transfer of a complete coating system from a carrier film to a substrate by means of heat and pressure. When transferred at point of contact between heated roller and substrate, the coating system provides both a decorative effect and a protective layer to provide specified end use properties.

The foils are gravure printed in reverse sequence on a copolymer film. That is, the release coat is applied first followed by a protective coating, the decorative pattern, the base coat and finally, the heat-activated adhesive. These foils can be applied vertically or horizontally to flat surfaces, curves, edges and contoured profiles. They are thermoformable, making them ideal for applications with doors or decorative trim, and can be restamped after application to correct defects or damage.

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COMMON USES

CABINETS & DOORS

FURNITURE & CABINET SURFACES

CLOSET SYSTEMS

STORE FIXTURES

READY TO ASSEMBLE FURNITURE

PICTURE FRAMES



2

The impregnated foils are bonded with an adhesive system to a substrate (ex: MDF or particleboard). Quantity, method and type of impregnation and the type of adhesive system and substrate will have a direct effect on the finished product. These qualities will be demonstrated in cutting and machining performance. Although impregnated papers do not require a topcoat to be considered a foil, most foils receive a finished topcoat for increased durability and scratch-resistance.



Due to substrate surface advancements, the use and performance of decorative foils has increased. Widespread use of decorative foils ranges from retail fixtures to closet systems, RTA furniture, profile wrappings and POP displays. Specifiers choose decorative foils for their sharp print fidelity; wear-, stain- and water-resistant qualities; ease of maintenance and durability as well as their cost-effectiveness and reliable machining and manufacturing characteristics. ■



DECORATIVE FOILS ARE ADHERED TO A SUBSTRATE USING A GLUE SYSTEM. THE APPLICATIONS ARE VIRTUALLY IDENTICAL TO THERMALLY FUSED PAPERS AND INCLUDE HOME STORAGE 1, CLOSET SYSTEMS AND KITCHEN CABINETS 2.

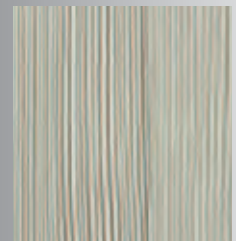
Textured Beauty

Pentadecor® 3D Laminate films
Designs with deep surface texture

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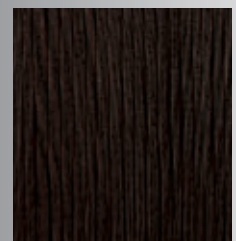
Weathered Pine



Linear Ash



Sculpted Wenge



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1

FILM OVERLAYS

COMMON USES

KITCHEN CABINETS

FURNITURE

SHELVING

MANUFACTURED HOUSING

OFFICE APPLICATIONS

WALL PANELING

3DL



2

Known as rigid thermoformable foils (RTF), three-dimensional laminate (3DL) and two-dimensional laminate (2DL), are thermoplastic film overlays. They provide end users the freedom to design components with contoured surface profiles and seamless edges without requiring edge treatments. Designers can also use film overlays to customize shapes and incorporate punch-outs, logos and concave/convex surfaces. These films are available in solid colors or printed designs.



3

3D LAMINATES' RESISTANCE TO CHIPPING, CRACKING AND BREAKING MAKE THEM A POPULAR CHOICE FOR CABINET DOORS 1 AS WELL AS WORK SURFACES AND CONFERENCE TABLES 2. A SEAMLESS EDGE PROFILE AND AN EASY TO CLEAN SURFACE ARE IDEAL FOR HEALTHCARE APPLICATIONS 3. FILM OVERLAYS ARE VACUUM FORMED OR MEMBRANE PRESSED OVER CONTOURED SUBSTRATES 4.



4



level.

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The films used in 3DL and 2DL are thermoplastic, meaning they soften when heated to take on the shape of their substrate and return to a firm state when sufficiently cooled.

3DLs are primarily made of polyvinyl chloride (PVC) and polyester (PET) films. They can be seamlessly membrane pressed or vacuum formed around contoured components, including edges. 3DL can also be used in 2DL applications such as profile wrapping and flat lamination. 3D laminates are available in typical thicknesses from 0.008" to 0.040" and customized gloss ranges. In addition, they can be embossed with specific patterns to improve realistic aesthetics.

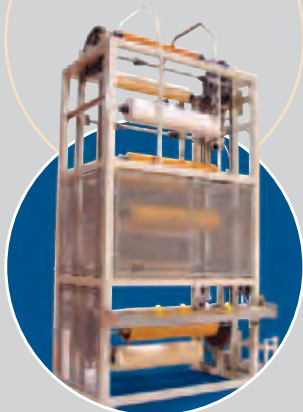
3D laminates are resistant to chipping, cracking or breaking making them a popular choice for retail store fixtures. In addition, their application seals the core panel substrate from bacteria and moisture, which make them an increasingly popular choice in healthcare settings for over bed tray tables, furniture and cabinetry. Due to their ability to wrap around custom shapes, edges and contoured surfaces, designers often specify 3DL materials for POP displays, commercial hospitality components, office furniture and door/drawer fronts for cabinetry.

FILM OVERLAYS CONTINUED ON PAGE 46 >



IN ADDITION TO BREAK-RESISTANT QUALITIES, SOME 3DL FINISHES OFFER BROAD CHEMICAL RESISTANCE THAT ALLOWS THE USE OF STRONG CLEANSERS FOR REMOVING GRIME AND GRAFFITI.

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MEMBRANES & MORE

2DLs are generally made from vinyl, polypropylene (PP) or oriented polypropylene (OPP). They are designed to be flat laminated or profile wrapped.

2DLs are available in a variety of thicknesses ranging from 0.001" to 0.007", and can be solid colored, reverse printed or top printed with an overlay based on end use requirements.

2D laminates provide excellent water and chemical resistance, and varying degrees of scratch and stain resistance. Common uses for 2D Laminates include walls and ceilings of recreational vehicles, vertical surfaces for retail store fixtures, cabinets, commercial flooring, and residential components.

Films can be divided into eight categories:

2ML REVERSE PRINTED RIGID FILM: Print design and base coat are printed on the back of the film in reverse order. This film is used for wall paneling (mostly in recreational vehicles), kitchen cabinets, furniture and manufactured housing.

SEMI-RIGID CLEAR FILM / REVERSE PRINTED: The film is frequently embossed and can be coated with scuff resistant coatings. These films range from 4 to 8 mils in thickness. Some can be mitre folded.

SANDWICH FILM: Semi-rigid two-ply overlay. The opaque base film is top printed and a clear overlay is laminated on top. This film is designed for mitre folding and flat sheet lamination. These films range from 5.5 to 8 mils in thickness. Some are available with scuff resistant topcoating.

SOLID COLOR FILM / SEMI-RIGID FILM: This film is integrally colored and can be top printed and/ or embossed. Top printed film is used extensively in manufactured housing, recreational vehicles, commercial paneling and movable walls. Plain solids are used in furniture, kitchen cabinets, fixtures and displays and office furniture applications. Thicknesses range from 3.5 to 8.0 mils. Some films are available with scuff resistant topcoatings.

THERMOFORMED OVERLAY FILMS: Single-ply or two-ply construction. Gauges range from .010" to .030" and the film may be printed in wood grain or decorative patterns. Films may be embossed and may be coated with scuff and stain resistant coatings. Primers to promote adhesion are available. Films are designed for thermoforming with heat and pressure in a bladder press or vacuum forming process. Decorative effects can be achieved with two-ply films when a router is used to expose a different color in the bottom ply film. Films may also be flat laminated or mitre folded. Raised panel cabinet doors and free-formed furniture components are the most common applications for this type of film.

FILM OVERLAYS CONTINUED ON PAGE 48 >

3DL

WOODGRAIN FILM OVERLAYS, COATED FOR SCUFF, SCRATCH AND STAIN RESISTANCE, ARE WELL-SUITED TO OFFICE FURNITURE ① AND HOSPITAL SURFACES ②.

WRAPPING FILMS: Rigid vinyl films in gauges from .005" to .010". Film may be printed in wood grain or decorative patterns, may be embossed and may be coated with scratch and stain resistant coatings. Films are designed for wrapping profiles, like picture frames and furniture moulding, and can also be flat laminated and mitre folded.

CALENDERED POLYPROPYLENE FILM: These films range from 5 to 20 mils in thickness and are available in a range of solid colors. Typical applications include flat laminations and edge banding for garage and kitchen cabinets as well as electronics.

ORIENTED POLYPROPYLENE (OPP) FILM (OPAQUE): Relatively new to the decorative overlay category, these films are stretched (oriented) in both the machine and cross-machine direction to deliver improved dimensional stability. In addition, OPP offers resistance to water and chemicals. Because of its non-absorbent print surface OPP is ideal for high fidelity wood grain prints and decorative patterns. OPP films may be embossed and are typically coated for scuff, scratch and stain resistance. Oriented polypropylene films are available in thicknesses ranging from 0.9 to 2.2 mil (23 gsm to 56 gsm). Typical applications include RTA furniture, cabinets, wrapped profiles, ceiling and wall panels. ■



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LIGHT BASIS WEIGHT PAPERS

COMMON USES

CABINETS

SHELVING SYSTEMS

CLOSET SYSTEMS

PANELING

STORE FIXTURES

HOME OFFICE FURNITURE

1



2

Light basis weight papers range in weight from 23 to 50 grams/m². The paper may contain acrylic, polyester or other resins added during the paper making process to improve the internal bond strength. The paper is then printed and topcoated with polyurethane, urea, polyester, acrylic or melamine or a combination thereof for increased durability and performance.

These papers can be printed with excellent quality and high-fidelity patterns. Optional chemical, optical, or gloss-matte embossing of these papers enhances the realism of woodgrain and natural patterns. Light basis weight papers have long been common in higher levels of value engineering and are widely used in cabinets, store fixtures, paneling, shelving, closet systems, RTA and home office furniture.

5



Light basis weight papers are usually divided into two categories, standard and industrial. Standard grade papers contain a lower amount of resin in the base paper and offer an economical overlay for use on general surface applications.

Industrial grade papers with their higher resin content, should be specified for applications that demand higher production and processing performance (i.e., improved cutting and machining). The cost effectiveness of this overlay group is further enhanced by the possibility of single sided panels. It is not necessary to laminate both sides of the substrate to achieve a balanced panel. As an additional application, depending on their weight, light basis weight papers can be profile wrapped to produce trim that is an exact match of the flat surface.

Light basis weight papers will accept a variety of adhesives applied during the laminating process. Additionally, they can be supplied precoated with hotmelt adhesive ready for hot roll laminating without any additional adhesive application to the paper or substrate. The performance and appearance of the finished panel will be affected by the adhesive system used and substrate quality. ■

3



4



6



LIGHT BASIS WEIGHT PAPERS (LBWP) ARE IDEAL AS AN ECONOMICAL OVERLAY. INDUSTRIAL-GRADE LBWP HAVE A HIGHER RESIN CONTENT AND GREATER INTERNAL BOND AND ARE OFTEN USED IN KITCHEN CABINETS 2, HOME OFFICE FURNITURE 5 AND CLOSET SYSTEMS 6. STANDARD LBWP ARE USED IN LOW WEAR APPLICATIONS LIKE SHELVING 3, 4 AND PANELING, IN THIS CASE FOR CEILINGS 1.

VENEER

COMMON USES

- EDGE BANDING
- READY TO ASSEMBLE FURNITURE
- CABINETS
- FURNITURE
- STORE FIXTURES
- CASE GOODS

1



2

Another common decorative surfacing material used in the lamination industry is natural wood veneer. Veneers are available in a variety of wood species, both domestic and imported. Composite panels, like particleboard and MDF, are the preferred substrate for veneers due to their superior surface qualities of being flat, smooth, uniform, dense and free of knots and grain patterns. In addition, their dimensional stability, strength properties and cost advantages further increase the advantages of using these substrates.

The veneers are typically sliced between 1/25" to 1/50" (1.0 mm to 0.51 mm) and are available plain or with a paper or fleece backer that have varying degrees of flexibility. The backers provide stability and strength to the veneer and minimize splintering, cracking and checking. Veneered composite panel constructions are used in many applications including high quality furniture, case goods, store fixtures and cabinetry. Some veneers are used for profile wrapping, typically over MDF, for high end millwork applications.

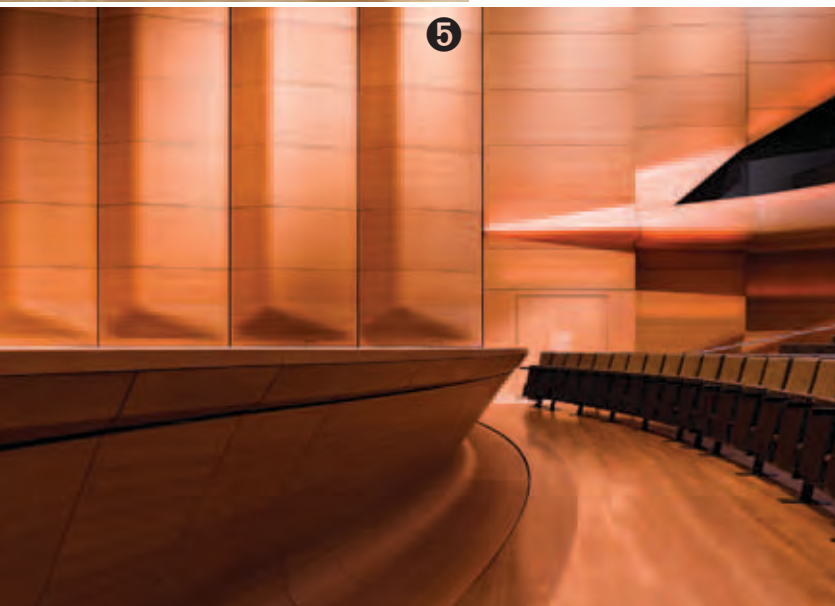
Veneers can be overlaid with either heat activated resins or cold pressed. The main resin used in hot press systems is a urea-based adhesive due to its ability to make the panel more rigid, faster processing parameters and lower cost base. Another hot press resin system that is increasingly used is a soy-based resin. Cold press systems typically use polyvinyl acetates, casein and contact adhesives. These systems are used for smaller production quantities and may be less rigid than heat activated resin systems. ■



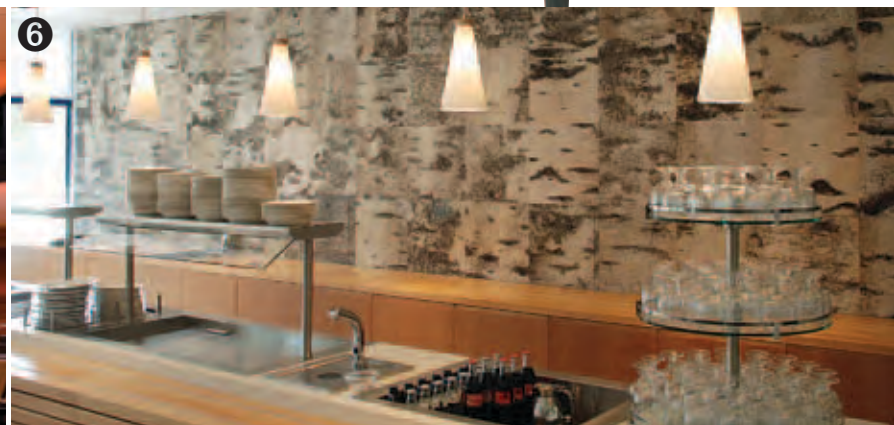
4



3



5



6

WOOD VENEERS HAVE BECOME THINNER 1, 3 AS THE TECHNOLOGY TO PROCESS THEM HAS IMPROVED. NEVERTHELESS, THIN VENEERS WOULD NOT HAVE PRACTICAL APPLICATION WITHOUT THE ADVANCES MADE IN THE SURFACE QUALITY OF PARTICLEBOARD AND MDF. WOOD VENEERS REQUIRE A GLUE SYSTEM AND A SURFACE FINISH. VENEERS ADD WARMTH TO COMMERCIAL INTERIORS 2, FURNITURE 4, ENTERTAINMENT VENUES 5 AND RESTAURANTS 6.

COATINGS

Another common decorative surfacing option is paint coating. With the advance of technology, coatings can now be applied to composite wood substrates in either liquid or powder forms. Paint can also be used in tandem with special inks, particularly in applications calling for printed wood grains or abstract patterns. Aside from wood grain printing, coatings are available as a decorative color finish or as a clear protective topcoat. The surface characteristics of composite panel products, especially MDF, allow for direct coating and printing applications, which result in exceptionally consistent defect-free finishes. While some industrial finishes are available on a retail basis, most coatings are custom formulated to fit the specific prefinisher's line configuration and the requirements of the intended end application.



MDF IS THE PERFECT SUBSTRATE FOR STRIKING HIGH-GLOSS FEATURES IN RETAIL ENVIRONMENTS ① AND SATIN GLOSS COATED MILLWORK AND KITCHEN CABINETS ②. POWDER COATING PROVIDES A CONSISTENT AND DURABLE FINISH FOR CONTOURED COMPONENTS ④, AND IS AVAILABLE IN A WIDE RANGE OF COLORS, TEXTURES AND FINISHES ③.



LIQUID COATINGS

There are many types of liquid coatings used as industrial decorative surfaces. Coatings can be water or solvent-based, and chemistry advancements continue to provide increases in performance of both types. Both families of coatings are used in finishing cabinets and furniture, exterior siding, millwork, trim, flooring and fixtures.

WATER-BASED ACRYLIC LATEX COATINGS: These coatings are used in industrial, commercial and residential settings and are formulated for both interior and exterior applications. Manufacturers can modify these coatings with different types of resins and cross-linking agents to extend the service life and exterior durability of the coating system. These additives also improve the chemical, corrosion and water resistance properties.

One of the advantages of water-based coatings is their lower VOC content, which reduces their impact to indoor air quality. They are also superior to other coating types in their exterior durability and color retention, which is a function of the acrylic resins used in the formulation. However, these coatings do not perform as well as solvent borne coatings in chemical and wear resistance.

SOLVENT-BASED COATINGS: The higher VOC nature of solvent-based coatings limits their use primarily to industrial settings that are equipped with specialized air handling and treatment devices. These coatings can be modified with urethanes, epoxies, nitrocellulose, alkyds and acrylics to impart certain performance qualities.

Solvent-based coating systems are widely recognized for their outstanding chemical and wear resistant properties. This family of coatings is used for high gloss finishes that have superior abrasion resistance. Their toughness and performance properties are among the reasons they are extensively used in the furniture and kitchen cabinet manufacturing business. In addition, there is minimal grain raise and fiber swell with solvent-based coatings, and the finish is easier to touch up and repair if damaged.

ULTRA-VIOLET (UV) COATINGS: The main difference with this coating type is how the coating is cured or dried. UV coatings have special ingredients that react almost instantaneously with UV radiation. This results in a significantly faster curing process. As a result, UV coatings are extremely tough, durable and long lasting. They are mainly formulated as clear coats and sealers.

3

POWDER COATINGS

The popularity of powder coating has continued to grow as an industrial finishing system. Initially developed as an alternative way to coat metal, the advantages of this evolving technology have made powder coating the fastest growing industrial finish for metal in the world. Powder coatings are used on appliances, machinery, furniture and fixtures. The powder coating process significantly reduces waste, with nearly 95% transfer efficiency and low VOC emissions.

In the late 1990's, companies began experimenting with applying powder to wood products, particularly MDF. As MDF was a wood-based product and not prone to carrying electrical charges (critical for the electrostatic process), there were significant processing challenges to overcome. With the development of specially engineered MDF and powders, along with new processing techniques, these efforts were successful and a new way to finish composite panel products was launched.

4

Powder coating is an advanced method of applying a decorative and protective finish onto a wide range of materials and products that are used for both industrial and consumer applications. The powder used for the process is a mixture of finely ground particles of pigment and resin that is sprayed onto a surface to be coated. The charged particles adhere to the electrically grounded surface until heated and cured to create a variety of smooth and textured finishes that are uniform and durable. The coating process is a single-stage application where all exposed surfaces are coated simultaneously.

The benefits of powder coatings include increased design flexibility, cost efficiency and seamless edges. Powder coatings also provide high resistance to heat, moisture, abrasion, staining and fading, and offer a range of colors, textures and finishes. ■



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North American Composite Panel Manufacturers

LEGEND

1. Boise Cascade, LLC
2. Clarion Boards, Inc.
3. CMI/CraftMaster Manufacturing, Inc.
4. Collins Products, LLC
5. Dakota Panel
6. Decorative Panels International, Inc.
7. DeFehr Furniture
8. Del-Tin Fiber, LLC
9. Duraplay de Parral, S.A. de C.V.
10. Flakeboard
11. Florida Plywoods, Inc.
12. Georgia-Pacific Wood Products LLC
13. Giles & Kendall, Inc.
14. Hambro Group
15. Industrias Emman, S.A. de C.V.
16. JELD-WEN, Inc.
17. Kronospan LLC
18. Langboard, Inc.
19. Louisiana-Pacific Corporation
20. Maderas Conglomeradas, S.A. de C.V. (MACOSA)
21. Maderas y Sintéticos de México, S.A. de C.V. (MASISA)
22. Marshfield DoorSystems, Inc.
23. Masonite International Corporation
24. Northern Engineered Wood Products, Inc.
25. Overhead Door Corporation
26. Pan Pacific Products, Inc.
27. Panolam Industries International Inc.
28. Plum Creek MDF, Inc.
29. Plummer Forest Products
30. Ponderplay, S.A. de C.V.
31. PPM Pacific Panels Mexico, S.A. de C.V.
32. Rexcel S.A. de C.V.
33. Roseburg
34. Sacopan Inc.
35. SierraPine
36. Stimson Lumber Company
37. Tafisa Canada Inc.
38. Taosa Paneles S.A. de C.V.
39. Temple-Inland
40. Timber Products Company
41. Uniboard
42. Unilin US MDF
43. Webb Furniture Enterprises, Inc.
44. West Fraser Mills Ltd.



- CPA Particleboard Members
- CPA Medium Density Fiberboard Members
- CPA Hardboard and Engineered Wood Siding/Trim Members
- Non-Member Particleboard
- Non-Member MDF, Hardboard and Engineered Wood Siding/Trim

OVERLAY MANUFACTURERS

COMPOSITE PANEL ASSOCIATION



COMPANY AND LOCATION	BRAND NAME	3-D LAMINATES	CPL (CONTINUOUS PRESSED LAMINATE)	DECORATIVE FOILS	HEAT TRANSFER FOIL	HIGH PRESSURE LAMINATES	LIGHT BASIS WEIGHT PAPER	PHENOLIC	POLYESTER	POLYPROPYLENE	SATURATED PAPER	THERMALLY FUSED MELAMINE	VINYL FILM	WOOD VENEER	OTHER (SEE NEXT COLUMN)	OTHER PRODUCT TYPES	SPECIAL TREATMENTS, FEATURES AND CAPABILITIES
AET FILMS New Castle, Delaware	SynDECOR®									•						• SynDECOR®, a performance polymer-based decorative overlay	Water resistant, sustainable overlay. Dimensionally stable. High print fidelity. Miter-foldable. No VOC's. Available 23gsm thru 56gsm; white and beige.
AMERICAN RENOLIT CORPORATION Swedesboro, New Jersey LaPorte, Indiana	RENOLIT	•							•	•				•		• Exterior Film	3D laminates, PVC, PET and PP decorative films for pressing wrapping and thermoforming. Horizontal grades. Extensive stocking with cut roll program. Solids, prints, metallic and high gloss. Popular TFM/HPL matching program.
ARCLIN Tacoma, Washington	E-Gen		•			•		•			•	•				• Glue films, backers	Arclin's E-Gen designated decorative overlays are available for TFM, HPL, CPL, flooring and industrial surfacing applications. Available with GREENGUARD, Children and Schools, and FSC Chain of Custody Certification.
ARJO WIGGINS USA, INC. Stamford, Connecticut																• Base paper manufacturer (saturating and pre-impregnated) for the printing, saturating and laminating industry	
BAUSCHLINNEMANN NA Greensboro, North Carolina Myrtle Beach, South Carolina	TecoFoil, TecoLine, TecoTop, TecoLam		•	•		•										• Pre-applied hotmelt adhesive	Flat surface and profile wrap laminates, high abrasive resistant surfaces, recoatable surfaces, melamine edgebanding for straight and softformed edges, slitting services.
CDM DÉCOR PAPERS INC. Drummondville, Quebec	AquaSeal™, Foilspec™, Microspec™			•		•				•						• Pre-applied hotmelt adhesive	AquaSEAL™: Water, stain and abrasion resistant, dimensionally stable, resists shrink/creep, formaldehyde free. Electron beam cured decorative foils and light basis weight papers.
CHIYODA AMERICA, INC. Morgantown, Pennsylvania				•		•					•			•			Zen Finish. North American printing and design services. Experienced in matching design and color across product mix for maximum end use opportunities. Solid Color Light Weight (30gm) paper.
COVERIGHT SURFACES AMERICAS Blythewood, South Carolina Curitiba Brazil Cobourg, Ontario	Silveright, Hi-Wear					•					•	•		•	•	• Broad range of technical films. • PG backers, glue films, Coated Glass • Mat, Decorative prints for surfaces	High Wear Melamine, impact resistant melamine. Silveright anti-bacterial surface treatment now available for TFM Decorative prints and can be ordered in sheet or roll form, HPL, Laminate flooring surfaces and other building products.
FORMICA CORPORATION Cincinnati, Ohio	Formica High Pressure Laminates, Formica Solid Surfacing, DecoMetal Metal Laminates, Formica Veneer Premium Wood Surfacing, Chemtop2					•					•					• Solid surfacing, metal and wood laminates	Innovative High Pressure Laminate finishes: Etchings, Honed, Naturelle, MicroDot, Riverwash; Radiance; fire and chemical resistant laminates, compact phenolic panels.
INTERPRINT, INC. Pittsfield, Massachusetts				•		•					•						Decorative printing, in-house laser engraving, design and repro services.
KAPSTONE CHARLESTON KRAFT LLC North Charleston, South Carolina																• Producers of DuraSorb® saturating kraft paper for use as core paper for HPL, CPL, and compact laminates as well as overlays for construction grade applications.	

LAMINATORS

COMPOSITE PANEL ASSOCIATION



LAMINATORS 2011

COMPANY AND LOCATION	BRAND NAME	CERTIFIED WOOD	EPP DOWNSTREAM LICENSED FACILITY	NAUF (NO ADDED UREA-FORMALDEHYDE)*	3-D LAMINATES	DECORATIVE FOILS	HEAT TRANSFER FOIL	HIGH PRESSURE LAMINATES	LIGHT BASIS WEIGHT PAPER	MDO / HDO	PHENOLIC	POLYESTER	POLYPROPYLENE	SATURATED PAPER	THERMALLY FUSED MELAMINE	VINYL FILM	WOOD VENEER	SPECIAL TREATMENTS, FEATURES AND CAPABILITIES	SUBSTRATES OFFERED	PB, MDF OR HB PRODUCER
AMERICAN LAMINATES, INCORPORATED Riverbank, California		FSC	•	•											•			Offering premium melamine panels with high specification industrial particleboard and MDF. 60 colors in stock. High inventory including shelving, edge banding and line-boring. Fast service to distributors in Western USA.	EPP PB, MDF, NAF PB, MDF	No
CLARION BOARDS, INC. Clarion, Pennsylvania		FSC													•			E-I-R (Embossed-in-Register) Capable.	MDF	Yes
CLOSETMAID COMPANIES Chino, California														•	•			Custom components, cut-to-size and CNC routing.	PB, MDF, HB	No
COLUMBIA FOREST PRODUCTS St. Casimir, Quebec Trumann, Arkansas	Melawood products	FSC FSC	•	•		•			•						•			Hardwood Plywood. FSC Capable. Hardwood Plywood. Capable of laminating 5' wide panels. FSC Capable. Coating Available.	PB, MDF, HB, Plywood PB, MDF, HB, Plywood	No No
DURAPLAY DE PARRAL, SA DE CV Chihuahua, Mexico	Duralam, Duramel, Duracore					•			•	•					•			Mix loads capabilities with raw PB, Mende, softwood and hardwood plywood, CTS, bullnose and furniture parts.	PB, MDF, Mende, Veneer Core	Yes
FLAKEBOARD Albany, Oregon Bennettsville, South Carolina Sault Ste. Marie, Ontario Simsboro, Louisiana St. Stephen, New Brunswick	Duraflake UltraPine® Superior MDF, Superior Plus MDF, Superior SW MDF UltraPine® Fibrex®, Rezflake	FSC FSC													• • • • •			Mix ship capabilities with raw MDF, melamine laminated MDF and particleboard. Can produce MDF/HDF, particleboard, mende with paint, print, melamine, paper/foils, CTS and perforated board from one source. Specialty products also include melamine lamination on thin MDF (Fibrex®), moisture resistant, fire-rated and no added urea-formaldehyde resin (Vesta) particleboard and MDF.	PB, MDF Fire-rated PB, PB, MDF, Moisture Resistant PB, MDF PR, MDF, Fibrex®	Yes Yes Yes Yes Yes
FLORIDA PLYWOODS, INC. Greenville, Florida									•						•	•		Cut-to-size, bullnose edge, drawer sides, shelving, end panels, tops & bottoms. Particleboard manufactured in-house; homogeneous.	PB, MDF, Veneer Core	Yes
FUNDER AMERICA, INC. Hope, Arkansas; Mocksville, North Carolina; Sebring, Florida	FUNDER	FSC	•	•				•							•	•		Multiple surface textures & glosses, complete fabrication/ component capability and multiple sizes.	PB, MDF	No
KML CORPORATION Tacoma, Washington; Stockton, California								•							•			Top quality TFM panels with decorative overlays from Coveright, Arclin, Wilsonart, Formica and Tafisa. Variety of plate finishes available including embossed diamond finish. Slotwall panels, edgebanding/shelving, custom components and line boring. High pressure laminate bonded panels.	PB, MDF, Veneer Core, NAF, FSC, Fire Retardant, Moisture resistant	No
LAMINATE TECHNOLOGIES Tiffin, Ohio Gallatin, Tennessee Diboll, Texas		FSC FSC FSC	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •		Three fully integrated manufacturing facilities featuring continuous and HPL laminating plus full fabrication capabilities. Double sided continuous laminators capable of laminating papers, vinyl's, polyester and polypropylene. HPL panels available in many sizes and from all major HPL manufactures. Full fabricating capabilities at all locations including cut-to-size, edge banding, drilling, dadoing, toe notching, mite folding and routing for custom components.	All locations: PB, MDF, HB Hardwood Plywood, Veneer Core	No
MADERAS CONGLOMERADAS S.A. DE C.V. Tlalnepantla, Mexico	MACOPELL, MACOMELL, MACOPLAY					•	•	•	•									Cut to size, LP in one / two faces, Thickness up to one inch, Mix PB/ MDF, Manufacturer of flush doors skins.	PB, MDF	Yes
MJB WOOD GROUP, INC. Cedar Hill, Texas					•		•	•	•									Custom component fabricator. Cut-to-size, edgebanding, CNC routing and boring. National warehouse distribution.	PB, MDF, HB, Plywood	No
OLON INDUSTRIES INC. (COMPONENTS DIVISION) Geneva, Illinois Georgetown, Ontario Jefferson, Indiana Washington, Indiana	Decorative Laminates Olon Components Olon Creative Products Olon Components	FSC FSC FSC FSC	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	Decorative profile wrapped cabinet stiles and rails with thermally fused polyester, vinyl and lightweight papers. Vinyl wrapped drawer components, v-grooved, blank, mitrefold and KD drawer systems. Baltic birch drawer sides.	All locations: MDF, Solid Wood, Metal, Backers, Fiberglass, Plastic	No

PANEL SPECIALISTS, INC. Temple, Texas																				Custom Component parts and OEM manufacturing. Manufactures Wall Systems, Casework, Marine Panels, and Panel Board. Services include laminating, edgebanding, cut-sizing, drilling, and machining.	PB, MDF, HB, Thermanax	No
PANOLAM INDUSTRIES INTERNATIONAL, INC.																						
Albany, Oregon	Panolam® TFM, Pluswood® TFM	FSC, SFI/SCA	•	•	•																	
Huntsville, Ontario	Panolam® TFM, Pluswood® TFM	FSC, SFI/SCA	•	•	•																	
Norcross, Georgia	Panolam® TFM, Pluswood® TFM	FSC, SFI/SCA	•	•	•																	
Oshkosh, Wisconsin	Panolam® TFM, Pluswood® TFM	FSC, SFI/SCA	•	•	•																	
PASQUIER PANEL PRODUCTS Sumner, Washington																						
PATRICK INDUSTRIES, INC. Elkhart, Indiana																						
PPM PANELS MEXICO MEXICO, S.A. DE C.V. Tijuana, Mexico																						
	Best Board																					
REXCEL SA DE CV Chihuahua, Mexico																						
	Panelart																					
ROSEBURG Dillard, Oregon		FSC	•	•	•																	
	Duramine TFM, Hardwood Plywood, UltraFinish-Paper & Vinyl Overlays, RediPly, Melagard, Redishef, SkyBlend™																					
Missoula, Montana	Duramine TFM, Melagard, Redishef, SkyBlend™		•	•																		
Oxford, Mississippi	Duramine TFM, SkyBlend™	FSC	•	•																		
Orangeburg, South Carolina	Duramine TFM, SkyBlend™	FSC	•	•																		
ROUCKE, INC. Denver, Colorado		FSC	•	•	•																	
SHIOLENO INDUSTRIES, INC. Arlington, Texas																						
	Rainbow Panels		•																			
STEVENS INDUSTRIES, INC. Teutopolis, Illinois																						
	Stevens TFM, Stevens HPL, StevensWood™, Stevens Shelf™		•																			
TAFISA CANADA INC. Lac-Mégantic, Quebec		FSC	•	•																		
	Tafilam																					
TIMBER PRODUCTS COMPANY White City, Oregon		FSC/SFI	•		•																	
	SpectraBoard, Spectracore, ColorLam, TufDec, Polyboard, DecraBoard																					
UNIBOARD Moncure, North Carolina		FSC	•	•																		
Sayabec, Quebec	Uniboard TFM	FSC	•	•																		
Val-d'Or, Quebec	Uniboard TFM	FSC	•	•																		
VISULAM DIVISION DE PRODUITS FORESTIER AFA INC. Lachute, Quebec																						
			•		•	•																

* These companies and facilities offer products made with "No added urea-formaldehyde" (NAUF) panel products. NAUF panel products may be eligible for low-emitting materials credit under LEED for Commercial Interiors and LEED for New Construction and Major Renovations.



COMPANY AND LOCATION	BRAND NAME	CERTIFIED WOOD	EPP DOWNSTREAM LICENSED FACILITY	NAUF (NO ADDED UREA-FORMALDEHYDE)*	LIQUID COATING	POWDER COATING	PRINTING	SPECIAL TREATMENTS, FEATURES, CAPABILITIES AND SERVICES	SUBSTRATES OFFERED	PB, MDF, OR HB PRODUCER
AMERICAN ADHESIVE COATINGS LLC Lawrence, Massachusetts					•			Manufacturer of hot melt adhesives for particleboard and MDF laminations to paper up to five feet wide.		No
BAUSCHLINNEMANN NA Greensboro, North Carolina Myrtle Beach, South Carolina	TecoFoil, TecoLine, TecoTop, TecoLam				•			Pre-applied hotmelt adhesive.		No
CDM DÉCOR PAPERS INC. Drummondville, Quebec					•			Pre-applied hotmelt adhesive.		No
CLOSETMAID COMPANIES Chino, California						•		Wood powder coating, custom components, cut-to-size, CNC routing.	PB, MDF, HB, Lauan	No
COLUMBIA FOREST PRODUCTS Chatham, Virginia Hearst, Ontario Klamath Falls, Oregon Old Fort, North Carolina Trumann, Arkansas		FSC FSC FSC FSC FSC		• • • • •	• • • • •			Hardwood Plywood. Hardwood Plywood. Hardwood Plywood. Primer Finish, Hardwood Plywood, Cut-to-Size Available, Beaded Panels. Hardwood Plywood and Laminating, Beaded Panels.	PB, MDF, HB, Plywood PB, MDF, HB, Plywood PB, MDF, HB, Plywood PB, MDF, HB, Plywood PB, MDF, HB, Plywood	No No No No No
FLAKEBOARD St. Stephen, New Brunswick	Rezcote		•	•	•		•	Standard acrylic and UV top coat, unlimited solid colors, wood grain print.	PB, MDF, Fibrex®	Yes
FUNDER AMERICA, INC. Mocksville, North Carolina			•			•		Wood powder coating, custom components, cut-to-size, CNC routing.	PB, MDF	No
ROSEBURG Dillard, Oregon Missoula, Montana	UltraFinish-UV Cured Paints & Finishes, SkyBlend™ UltraFinish-UV Cured Paint & Finishes, SkyBlend™	FSC	•	•	•		• •	UV fill and topcoat, wood grain print, PB, MDF, VC, acrylic solid colors with custom color program, prefinished shelving and edge banding. UV fill and topcoat, wood grain print, PB, MDF, VC, acrylic solid colors with custom color program, prefinished shelving and edge banding.	PB, MDF, SkyBlend™, and others PB, MDF, SkyBlend™, and others	Yes Yes

* These companies and facilities offer products made with "No added urea-formaldehyde" (NAUF) panel products. NAUF panel products may be eligible for low-emitting materials credit under LEED for Commercial Interiors and LEED for New Construction and Major Renovations.

COATING MANUFACTURERS

COMPOSITE PANEL ASSOCIATION



COMPANY AND LOCATION

BRAND NAME

LIQUID COATING

POWDER COATING

PRINTING

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Lawrence, Massachusetts

•

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High Point, North Carolina

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COMPOSITE PANEL ASSOCIATION



COMPANY AND MILL LOCATION	BRAND NAME	WOOD SPECIES	CERTIFIED WOOD	EPP CERTIFIED	NAUF (NO ADDED UREA-FORMALDEHYDE)*	CARB EXEMPT (ULEF / NAF)**	INDUSTRIAL GRADES					FLOOR UNDERLAYMENT (PBU)	MFD HOME DECKING D-2, D-3	DOOR CORE LD-1, LD-2	SPECIAL ITEMS AND TREATMENTS (SEE LEGEND BELOW)	PRESS SIZE (FT.)	THICKNESS RANGE (IN.)	DENSITY RANGE (LBS/FT ³)
							M-0	M-1	M-S	M-2	M-3i							
BOISE CASCADE, LLC La Grande, Oregon	Boise Select, Boise Evergreen, Anchor™	Western Pine, Mixed Softwoods	FSC	•	•				•	•	•				BE C CS EF HD LD MR S ST	5x18, 4x24	3/8 – 1-1/4	41 – 50
COLLINS PRODUCTS, LLC Klamath Falls, Oregon	Collins Pine Particleboard, Free Form	Western Pine	FSC	•	•				•	•	•				C CS MR S	5x24	3/8 – 1-1/4	42 – 47
DURAPLAY DE PARRAL, S.A. DE C.V. Parral, Chihuahua	Duraplay Supremo, Duramel, Duracore, Duralam	Pine		•					•	•	•				BE C CS EF ET FO LP M MN MR PA S ST W	8x48 Single Opening, 4' Mende	1/8 – 1-1/8	40 – 55
FLAKEBOARD Albany, Oregon	Duraflake®, Vesta	Douglas Fir, Hemlock	FSC	•	•				•	•	•	•		•	C CS DC FR HD M MR S ST	4x24, 6x26	3/8 – 1-15/16	42 – 55
Bennettsville, South Carolina	UltraPine®, UltraPine® Plus, Vesta	Pine	FSC	•	•				•	•	•	•		•	C CS DC LD M MR S	10xContinuous	9/32 – 1-1/2	41 – 46
Simsboro, Louisiana	UltraPine®, UltraPine® Plus, Vesta	Pine	FSC	•	•				•	•	•	•		•	C CS DC LD M MR S	10xContinuous	1/4 – 1-1/2	41 – 46
St. Stephen, New Brunswick	Rezflake, Vesta	Spruce	FSC	•	•				•	•	•	•		•	B F FO LP M MN P PA PF PR T	4xContinuous, 8x32	3.0mm – 1-1/8	42 – 47
FLORIDA PLYWOODS, INC. Greenville, Florida		Southern Yellow Pine													BE CS PA S V W	5x12, 5x24	5/16 – 5/8	50
MARSHFIELD DOORSYSTEMS, INC. Marshfield, Wisconsin	Uni-Cor ST, Uni-Cor ST Lite, Uni-Cor FR	Aspen, Basswood, Northern Hardwoods	FSC	•	•									•	CS DC SR FR LB LD	7x9	1-1/8 – 2-1/4	28 – 37
Maderas Conglomeradas S.A. de C.V. Tlalnepantla, Mexico	MACOPAN	Pine / Softwood													CS LP P W	4 X Continuous 8 X Continuous	1/12 – 5/16	46-49
Maderas Sintéticos de México, S.A. de C.V. (MASISA) Durango, Mexico	Placa Masisa, MDF Masisa, Melamina, Masisa	Duranguense Pine												•	CS FO LP LD M	4x8, 5x8, 8x8	3/8 – 1-3/8	35 – 50
NORTHERN ENGINEERED WOOD PRODUCTS, INC. Smithers, British Columbia	NEWPRO Blonde	Pine, Spruce		•	•				•	•	•				M	8x48	1/4 – 1	38 – 50
PANOLAM INDUSTRIES INTERNATIONAL, INC. Huntsville, Ontario	Panolam, Pionite, Conolite	Canadian Wood Mixture		•	•										C FR LP M MR	5x18, 8xContinuous	1/4 – 1-1/2	42 – 45
PLUMMER FOREST PRODUCTS Post Falls, Idaho	EnStron, EnStron Plus, Terramica	Western Softwoods	FSC / SCS	•	•	•	•	•	•	•	•				CS MR	4x8	1/4 – 1-1/8	42 – 48
PPM PACIFIC PANELS MEXICO, S.A. DE C.V. Tijuana, Mexico	Best Board	Pine (Some Recycled)		•											C CS FO LP LD M MR P S V W	4x40	3/8 – 1-3/8	42 – 47

REXCEL S.A. DE C.V.																						
Chihuahua, Chihuahua		Ponderosa Pine																				
Zitacuaro, Michoacan		Wood Mixture																				
ROSEBURG																						
Dillard, Oregon	UltraBlend™, SkyBlend™	Fir, Pine Blend	FSC	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
Louisville, Mississippi	UltraBlend™	Southern Pine	FSC	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
Missoula, Montana	UltraBlend™, SkyBlend™	Western Pine, White Fir		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
Russellville, South Carolina	UltraBlend™, SkyBlend™	Southern Pine	FSC	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
Taylorsville, Mississippi	UltraBlend™, SkyBlend™	Southern Pine	FSC	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
Vienna, Georgia	UltraBlend™	Southern Pine	FSC	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
SIERRAPINE																						
Adel, Georgia	ENCORE™, ENCORE™ MR	Southern Pine	FSC	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
Martell, California	Ampine™, ENCORE™	Western Pine	FSC	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
Springfield, Oregon	ENCORE™, ENCORE™ FR, ENCORE™ MR	Western Softwoods	FSC	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
TAFISA CANADA INC.																						
Lac-Megantic, Quebec	Tafipan	Spruce, Pine, Fir, Maple, Birch, Aspen		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
TEMPLE-INLAND																						
Diboll, Texas	Temstock	Southern Pine		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
Hope, Arkansas	Temstock	Southern Pine		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
Monroeville, Alabama	Temstock	Southern Pine		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
Thomson, Georgia	Temstock	Southern Pine		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
TIMBER PRODUCTS COMPANY																						
Medford, Oregon		Fir, Pine		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
UNIBOARD																						
Moncure, North Carolina	Uniboard PB	Southern Pine, Soft Hardwood	FSC	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
Sayabec, Quebec	Uniboard PB	Softwood, Hardwood	FSC	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
Val-d'Or, Quebec	Uniboard PB	Softwood, Hardwood	FSC	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
WEBB FURNITURE ENTERPRISES, INC.																						
Galax, Virginia	Webb Particleboard	Pine		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	

Special Items and Treatments: Base Coat (B), Bullnose Edge (BE), Countertop (C), Concrete Form (CF) Cut to Size (CS), Door Core (DC), Door Stiles and Rails (SR), Edge Fill (EF), Edge Tape (ET), Fill (F), Fire Retardant (FR), Flush Door Skins (FD), Foil (FO), High Density (HD), Hot Melt Wax (H), Laminate Flooring Substrate (LF), Laminated Products (LP), Lockblocks (LB), Low Density (LD), Melamine (M), Mende (MN), Moisture Resistant (MR), Moulding (MO), Moulded Door Skins (MDS), Paint (P), Paper (PA), Perforated (PE), Prefinished (PF), Print (PR), Shelving (S), Smooth Siding (SS), Stair Tread (ST), Textured Siding (TS), Topcoat (T), Tongue and Groove (TG), Turning and Moulding (TM), Vinyl (V), Wood Veneer (W)

All particleboard and MDF facilities in this Guide offer third party certified products to meet the California Air Resources Board (CARB) Airborne Toxic Control Measure (ATCM 93120) regulation. Some facilities may also have been issued a NAF or ULEF Exemption Executive Order from the State of California. CPA maintains a current list of CARB certified and exempt facilities at www.pbmdf.com.

* "No added urea-formaldehyde" (NAUF) and NAF panel products may be eligible for low-emitting materials credit under LEED for Commercial Interiors and LEED for New Construction and Major Renovations

** CARB exempt (NAF/ULEF) manufacturers offer composite wood product categories that have no added formaldehyde (NAF) and/or ultra-low emitting formaldehyde (ULEF), and have been exempted from third party certification requirements of the California Air Resources Board (CARB) ATCM 93120.

MEDIUM DENSITY FIBERBOARD

COMPOSITE PANEL ASSOCIATION



COMPANY AND MILL LOCATION	BRAND NAME	WOOD SPECIES	CERTIFIED WOOD	EPP CERTIFIED	NAUF (NO ADDED UREA-FORMALDEHYDE)*	CARB EXEMPT (ULEF / NAF)**	LOW DENSITY	STANDARD DENSITY	HIGH DENSITY	MOISTURE RESISTANT	SPECIAL ITEMS AND TREATMENTS (SEE LEGEND BELOW)	PRESS SIZE (FT.)	THICKNESS RANGE (IN.)	DENSITY RANGE (LBS/FT ³)
CLARION BOARDS, INC.														
Clarion, Pennsylvania	Standard Premium, Flooring Premium, Standard Premium High Density	Hardwoods Northern Softwoods	FSC	•	•	•	•	•	•	•	HD LD LF LP M MO MR	10xContinuous	3/16 – 1-1/8	38 – 57
DEL-TIN FIBER, LLC														
El Dorado, Arkansas	Solidium, Solidium Free	Southern Pine			•	•	•	•	•	•	CS LF LD MO MR S	9xContinuous	3/16 – 1	40 – 60
FLAKEBOARD														
Bennettsville, South Carolina	Premier®, Premier® Plus, Premier® HD, Premier® MR, Vesta	Pine	FSC	•	•		•	•	•		CS FR HD LD	5x18	3/8 – 2	39 – 55
Eugene, Oregon	Premier®, Premier® Plus, Premier® FR, Premier® MR, Vesta, elite™, Evo	Douglas Fir, Hemlock	FSC	•	•		•	•	•		C-MDF FR HD LD	4x16	1/4 – 1-1/4	32 – 55
Malvern, Arkansas	Premier®, Premier® Plus, Premier® MR, Vesta	Pine		•	•		•	•	•		CS HD S	5x18, 5x24	3/8 – 1-1/2	41 – 46
Sault Ste. Marie, Ontario	Superior MDF, Superior Plus MDF, Superior SW, Superior Lite, Vesta	Spruce, Pine, Fir	FSC	•	•		•	•	•		LP LD M PF	10xContinuous	3/16 – 1-1/2	40 – 48
St. Stephen, New Brunswick	FibreX®, Fibrex Vesta	Mixed Hardwoods	FSC	•	•				•		B CS F FR FO HD LF M MR P PA PE	5xContinuous, 5xContinuous	1/16 – 5/16	55 – 62
GEORGIA-PACIFIC WOOD PRODUCTS LLC														
Monticello, Georgia	InfiniCor	Southern Pine		•				•			B CS F FD FO MN P PA PE PF PR T	4xContinuous	1/10 – 1/4	50 – 56
KRONOSPAN LLC														
Eastaboga, Alabama	Krono-light, Krono-med, Krono-DR Krono-dur, Krono-dur plus	Southern Pine, Light Hardwood					•	•	•		CS HD LF LD MR	10xContinuous	1/8 – 1-1/2	32 – 62
LANGBOARD, INC.														
Willacoochee, Georgia	Langboard MDF, Elite®	Southern Yellow Pine		•			•	•	•		BE CS DC MO S ST TM	5x18	3/8 – 1-1/2	41 – 52
MADERAS CONGLOMERADAS S.A. DE C.V.														
Tlalnepantla, Mexico	MACOCELL	Pine						•			CS LP P W	4 X Continuous 7 X Continuous	1/12 – 7/32	48-51
PAN PACIFIC PRODUCTS, INC.														
Broken Bow, Oklahoma	Megaboard	100% Pine			•		•	•	•		DC SR HD LD	8x20	3/4 – 4	22 – 65

PLUM CREEK MDF, INC.															
Columbia Falls, Montana	Super Refined MDF2®, Thin HDF, Glacier Green™ and Glacier Clear™	Western Softwoods	SFI / SCS	•	•	•	•	•	•	CS FD HD LD LF MR	5x18, 10xContinuous	1/16 – 1-1/2	40 – 60		
SIERRAPINE															
Medford, Oregon	ARREIS, Medex, Medite, Medite II	Western Softwoods	FSC	•	•	•	•	•	•	CS DC EXT FR HD LD LP MR MO	5x18	1/4 – 1-1/2	40 – 55		
Rocklin, California	Medite FR, Medite 3D, Permacore Rock-Top	Western Pine	FSC	•	•	•	•			PF PR S TM W CS FD LD MN MO P PF PR S SR T	8xContinuous	2mm – 7mm	45 – 50		
TEMPLE-INLAND															
Mt. Jewett, Pennsylvania	ULTRASTOCK	Mixed Hardwoods	FSC	•	•	•	•	•	•	BE CS HD LD LF MO MR S	9x25	7/32 – 1-5/16	40 – 55		
UNIBOARD															
Moncure, North Carolina	Uniboard MDF	Southern Pine	FSC	•		•	•	•		HD LD M MO	10xContinuous	5.6 – 9.8mm	33 – 57		
Mont-Laurier, Quebec	Uniboard MDF	Softwood, Hardwood	FSC	•	•	•	•	•	•	HD LD MO	9xContinuous	9.53 – 28.58			
UNILIN US MDF															
Mt. Gilead, North Carolina		Southern Yellow Pine		•				•	•	CS FD HD LF MR PR	9xContinuous	1/16 – 3/8	45 – 62		
WEST FRASER MILLS LTD.															
Quesnel, British Columbia	WestPine MDF, EcoGold™	Spruce, Pine, Fir		•	•	•	•	•	•	HD LF LD	10xContinuous	3mm – 3/4	41 – 60		
White Court, Alberta	Ranger Board	Spruce, Pine, Fir		•		•	•	•	•	HD LF LD	6x24	3/8 – 1-1/2	41 – 60		

Special Items and Treatments: Base Coat (B), Bullnose Edge (BE), Countertop (C), Concrete Form (CF), Colored MDF (C-MDF), Cut to Size (CS), Door Core (DC), Door Stiles and Rails (SR), Edge Fill (EF), Edge Tape (ET), Fill (F), Fire Retardant (FR), Flush Door Skins (FD), Foil (FO), High Density (HD), Hot Melt Wax (H), Laminate Flooring Substrate (LF), Laminated Products (LP), Lockblocks (LB), Low Density (LD), Melamine (M), Mende (MN), Moisture Resistant (MR), Moulding (MO), Moulded Door Skins (MDS), Paint (P), Paper (PA), Perforated (PE), Prefinished (PF), Print (PR), Shelving (S), Smooth Siding (SS), Stair Tread (ST), Textured Siding (TS), Topcoat (T), Tongue and Groove (TG), Turning and Moulding (TM), Vinyl (V), Wood Veneer (W)

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HARDBOARD

ENGINEERED WOOD SIDING AND TRIM

COMPANY AND MILL LOCATION		BRAND NAME	WOOD SPECIES	CERTIFIED WOOD	EPP CERTIFIED	NAUF (NO ADDED UREA-FORMALDEHYDE)*	SURFACES		CLASS		APPLICATION					SPECIAL ITEMS AND TREATMENTS (SEE LEGEND BELOW)	PRESS SIZE (FT.)	THICKNESS RANGE (IN.)	DENSITY RANGE (LBS/FT ³)	
						TWO-SIDED (S2S)	ONE-SIDED (S1S)	TEMPERED	UN-TEMPERED	INDUSTRIAL	DOOR SKIN/FACE	TILEBOARD	INTERIOR PANELING	SIDING	TRIM					
COLLINS PRODUCTS, LLC																				
Klamath Falls, Oregon	TruWood Siding & Trim	Western Softwoods	FSC /SCS	•	•	•	•	•	•					•	•	•	B BE CF CS LP MR P PM SS TS TG UP	4x16	7/16 – 5/4	47
CMI/CRAFTMASTER MANUFACTURING, INC.																				
Towanda, Pennsylvania	CraftMaster molded door designs	Hardwoods	SCS	•	•	•	•	•	•		•						MDS	5x7, 5x14	1/8	60
	Extira panels	Hardwoods	SCS	•	•	•	•	•	•	•							MR UP	4x16	1/2 – 1-1/4	45 - 49
	MiraTEC trim	Hardwoods	SCS	•	•	•	•	•	•								MR PM	4x16	4/4, 5/4	47
GEORGIA-PACIFIC WOOD PRODUCTS LLC																				
Duluth, Minnesota	SuperWood	Aspen, Mixed Hardwoods	SFI	•	•	•	•	•	•	•	•						B CS GD F P PE PF PR T	4x16, 5-1/2x16	1/16 – 9/32	60 - 65
Phillips, Wisconsin	Jubilee, Lionite, UltraStrate	Aspen, Mixed Hardwoods	SFI	•	•	•	•	•	•	•		•	•				B CS F P PE PF PR T	4x8	1/10 – 1/4	62 - 66
LOUISIANA-PACIFIC CORPORATION																				
East River, Nova Scotia	Canexel	Hardwood	ISO-9001 SFI	•	•	•	•	•	•					•			PF TS	7x16, 4x24	3/8 – 7/16	58 - 65
Roaring River, North Carolina	SmartSide	Mixed Hardwoods	SFI	•	•	•	•	•	•					•	•		PF PM SS TS UP	4x16, 4x18	7/16 – 1/2	47-52
SACOPAN, INC.																				
Sacre-Coeur, Quebec	SACOPAN	SPF, Sawmill Residuals									•						MDS	65x90	1/8	60 - 65
STIMSON LUMBER COMPANY																				
Forest Grove, Oregon	Stimson Hardboard Duratrim	Douglas Fir	SFI	•	•	•	•	•	•	•	•						B CS HD LD M P PE PF PM TS	4x16	1/10 – 5/8	50 - 70

Special Items and Treatments: Base Coat (B), Bullnose Edge (BE), Countertop (C), Concrete Form (CF) Cut to Size (CS), Door Core (DC), Door Stiles and Rails (SR), Edge Fill (EF), Edge Tape (ET), Fill (F), Fire Retardant (FR), Flush Door Skins (FD), Foil (FO), Garage Door Panels (GD), High Density (HD), Hot Melt Wax (H), Laminate Flooring Substrate (LF), Laminated Products (LP), Lockblocks (LB), Low Density (LD), Melamine (M), Mende (MN), Moisture Resistant (MR), Moulding (MO), Moulded Door Skins (MDS), Paint (P), Paper (PA), Perforated (PE), Prefinished (PF), Primed (PM), Print (PR), Shelving (S), Smooth Siding (SS), Stair Tread (ST), Textured Siding (TS), Topcoat (T), Tongue and Groove (TG), Turning and Moulding (TM), Unprimed (UP), Vinyl (V), Wood Veneer (W)

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North American Composite Panel Manufacturers

LEGEND

1. Boise Cascade, LLC
2. Clarion Boards, Inc.
3. CMI/CraftMaster Manufacturing, Inc.
4. Collins Products, LLC
5. Dakota Panel
6. Decorative Panels International, Inc.
7. DeFehr Furniture
8. Del-Tin Fiber, LLC
9. Duraplay de Parral, S.A. de C.V.
10. Flakeboard
11. Florida Plywoods, Inc.
12. Georgia-Pacific Wood Products LLC
13. Giles & Kendall, Inc.
14. Hambro Group
15. Industrias Emman, S.A. de C.V.
16. JELD-WEN, Inc.
17. Kronospan LLC
18. Langboard, Inc.
19. Louisiana-Pacific Corporation
20. Maderas Conglomeradas, S.A. de C.V. (MACOSA)
21. Maderas y Sintéticos de México, S.A. de C.V. (MASISA)
22. Marshfield DoorSystems, Inc.
23. Masonite International Corporation
24. Northern Engineered Wood Products, Inc.
25. Overhead Door Corporation
26. Pan Pacific Products, Inc.
27. Panolam Industries International Inc.
28. Plum Creek MDF, Inc.
29. Plummer Forest Products
30. Ponderplay, S.A. de C.V.
31. PPM Pacific Panels Mexico, S.A. de C.V.
32. Rexcel S.A. de C.V.
33. Roseburg
34. Sacopan Inc.
35. SierraPine
36. Stimson Lumber Company
37. Tafisa Canada Inc.
38. Taosa Paneles S.A. de C.V.
39. Temple-Inland
40. Timber Products Company
41. Uniboard
42. Unilin US MDF
43. Webb Furniture Enterprises, Inc.
44. West Fraser Mills Ltd.



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OVERLAY MANUFACTURERS

COMPOSITE PANEL ASSOCIATION



COMPANY AND LOCATION	BRAND NAME	3-D LAMINATES	CPL (CONTINUOUS PRESSED LAMINATE)	DECORATIVE FOILS	HEAT TRANSFER FOIL	HIGH PRESSURE LAMINATES	LIGHT BASIS WEIGHT PAPER	PHENOLIC	POLYESTER	POLYPROPYLENE	SATURATED PAPER	THERMALLY FUSED MELAMINE	VINYL FILM	WOOD VENEER	OTHER (SEE NEXT COLUMN)	OTHER PRODUCT TYPES	SPECIAL TREATMENTS, FEATURES AND CAPABILITIES
AET FILMS New Castle, Delaware	SynDECOR®									•						• SynDECOR®, a performance polymer-based decorative overlay	Water resistant, sustainable overlay. Dimensionally stable. High print fidelity. Miter-foldable. No VOC's. Available 23gsm thru 56gsm; white and beige.
AMERICAN RENOLIT CORPORATION Swedesboro, New Jersey LaPorte, Indiana	RENOLIT	•							•	•				•		• Exterior Film	3D laminates, PVC, PET and PP decorative films for pressing wrapping and thermoforming. Horizontal grades. Extensive stocking with cut roll program. Solids, prints, metallic and high gloss. Popular TFM/HPL matching program.
ARCLIN Tacoma, Washington	E-Gen		•			•		•			•	•				• Glue films, backers	Arclin's E-Gen designated decorative overlays are available for TFM, HPL, CPL, flooring and industrial surfacing applications. Available with GREENGUARD, Children and Schools, and FSC Chain of Custody Certification.
ARJO WIGGINS USA, INC. Stamford, Connecticut																• Base paper manufacturer (saturating and pre-impregnated) for the printing, saturating and laminating industry	
BAUSCHLINNEMANN NA Greensboro, North Carolina Myrtle Beach, South Carolina	TecoFoil, TecoLine, TecoTop, TecoLam		•	•		•										• Pre-applied hotmelt adhesive	Flat surface and profile wrap laminates, high abrasive resistant surfaces, recoatable surfaces, melamine edgebanding for straight and softformed edges, slitting services.
CDM DÉCOR PAPERS INC. Drummondville, Quebec	AquaSeal™, Foilspec™, Microspec™			•		•				•						• Pre-applied hotmelt adhesive	AquaSEAL™: Water, stain and abrasion resistant, dimensionally stable, resists shrink/creep, formaldehyde free. Electron beam cured decorative foils and light basis weight papers.
CHIYODA AMERICA, INC. Morgantown, Pennsylvania				•		•					•			•			Zen Finish. North American printing and design services. Experienced in matching design and color across product mix for maximum end use opportunities. Solid Color Light Weight (30gm) paper.
COVERIGHT SURFACES AMERICAS Blythewood, South Carolina Curitiba Brazil Cobourg, Ontario	Silveright, Hi-Wear					•					•	•		•	•	• Broad range of technical films. • PG backers, glue films, Coated Glass • Mat, Decorative prints for surfaces	High Wear Melamine, impact resistant melamine. Silveright anti-bacterial surface treatment now available for TFM Decorative prints and can be ordered in sheet or roll form, HPL, Laminate flooring surfaces and other building products.
FORMICA CORPORATION Cincinnati, Ohio	Formica High Pressure Laminates, Formica Solid Surfacing, DecoMetal Metal Laminates, Formica Veneer Premium Wood Surfacing, Chemtop2					•					•					• Solid surfacing, metal and wood laminates	Innovative High Pressure Laminate finishes: Etchings, Honed, Naturelle, MicroDot, Riverwash; Radiance; fire and chemical resistant laminates, compact phenolic panels.
INTERPRINT, INC. Pittsfield, Massachusetts			•			•					•						Decorative printing, in-house laser engraving, design and repro services.
KAPSTONE CHARLESTON KRAFT LLC North Charleston, South Carolina																• Producers of DuraSorb® saturating kraft paper for use as core paper for HPL, CPL, and compact laminates as well as overlays for construction grade applications.	

LAMINATORS

COMPOSITE PANEL ASSOCIATION



LAMINATORS 2011

COMPANY AND LOCATION	BRAND NAME	CERTIFIED WOOD	EPP DOWNSTREAM LICENSED FACILITY	NAUF (NO ADDED UREA-FORMALDEHYDE)*	3-D LAMINATES	DECORATIVE FOILS	HEAT TRANSFER FOIL	HIGH PRESSURE LAMINATES	LIGHT BASIS WEIGHT PAPER	MDO / HDO	PHENOLIC	POLYESTER	POLYPROPYLENE	SATURATED PAPER	THERMALLY FUSED MELAMINE	VINYL FILM	WOOD VENEER	SPECIAL TREATMENTS, FEATURES AND CAPABILITIES	SUBSTRATES OFFERED	PB, MDF OR HB PRODUCER
AMERICAN LAMINATES, INCORPORATED Riverbank, California		FSC	•	•											•			Offering premium melamine panels with high specification industrial particleboard and MDF. 60 colors in stock. High inventory including shelving, edge banding and line-boring. Fast service to distributors in Western USA.	EPP PB, MDF, NAF PB, MDF	No
CLARION BOARDS, INC. Clarion, Pennsylvania		FSC													•			E-I-R (Embossed-in-Register) Capable.	MDF	Yes
CLOSETMAID COMPANIES Chino, California														•	•			Custom components, cut-to-size and CNC routing.	PB, MDF, HB	No
COLUMBIA FOREST PRODUCTS St. Casimir, Quebec Trumann, Arkansas	Melawood products	FSC FSC	•	•		•		•	•						•			Hardwood Plywood. FSC Capable. Hardwood Plywood. Capable of laminating 5' wide panels. FSC Capable. Coating Available.	PB, MDF, HB, Plywood PB, MDF, HB, Plywood	No No
DURAPLAY DE PARRAL, SA DE CV Chihuahua, Mexico	Duralam, Duramel, Duracore					•		•	•						•			Mix loads capabilities with raw PB, Mende, softwood and hardwood plywood, CTS, bullnose and furniture parts.	PB, MDF, Mende, Veneer Core	Yes
FLAKEBOARD Albany, Oregon Bennettsville, South Carolina Sault Ste. Marie, Ontario Simsboro, Louisiana St. Stephen, New Brunswick	Duraflake UltraPine® Superior MDF, Superior Plus MDF, Superior SW MDF UltraPine® Fibrex®, Rezflake	FSC FSC													• • • • •			Mix ship capabilities with raw MDF, melamine laminated MDF and particleboard. Can produce MDF/HDF, particleboard, mende with paint, print, melamine, paper/foils, CTS and perforated board from one source. Specialty products also include melamine lamination on thin MDF (Fibrex®), moisture resistant, fire-rated and no added urea-formaldehyde resin (Vesta) particleboard and MDF.	PB, MDF Fire-rated PB, PB, MDF, Moisture Resistant PB, MDF PR, MDF, Fibrex®	Yes Yes Yes Yes Yes
FLORIDA PLYWOODS, INC. Greenville, Florida									•						•	•		Cut-to-size, bullnose edge, drawer sides, shelving, end panels, tops & bottoms. Particleboard manufactured in-house; homogeneous.	PB, MDF, Veneer Core	Yes
FUNDER AMERICA, INC. Hope, Arkansas; Mocksville, North Carolina; Sebring, Florida	FUNDER	FSC	•	•				•							•	•		Multiple surface textures & glosses, complete fabrication/ component capability and multiple sizes.	PB, MDF	No
KML CORPORATION Tacoma, Washington; Stockton, California								•							•			Top quality TFM panels with decorative overlays from Coveright, Arclin, Wilsonart, Formica and Tafisa. Variety of plate finishes available including embossed diamond finish. Slotwall panels, edgebanding/shelving, custom components and line boring. High pressure laminate bonded panels.	PB, MDF, Veneer Core, NAF, FSC, Fire Retardant, Moisture resistant	No
LAMINATE TECHNOLOGIES Tiffin, Ohio Gallatin, Tennessee Diboll, Texas		FSC FSC FSC	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •		Three fully integrated manufacturing facilities featuring continuous and HPL laminating plus full fabrication capabilities. Double sided continuous laminators capable of laminating papers, vinyl's, polyester and polypropylene. HPL panels available in many sizes and from all major HPL manufactures. Full fabricating capabilities at all locations including cut-to-size, edge banding, drilling, dadoing, toe notching, mite folding and routing for custom components.	All locations: PB, MDF, HB Hardwood Plywood, Veneer Core	No
MADERAS CONGLOMERADAS S.A. DE C.V. Tlalnepantla, Mexico	MACOPELL, MACOMELL, MACOPLAY					•	•	•	•									Cut to size, LP in one / two faces, Thickness up to one inch, Mix PB/ MDF, Manufacturer of flush doors skins.	PB, MDF	Yes
MJB WOOD GROUP, INC. Cedar Hill, Texas					•		•	•	•									Custom component fabricator. Cut-to-size, edgebanding, CNC routing and boring. National warehouse distribution.	PB, MDF, HB, Plywood	No
OLON INDUSTRIES INC. (COMPONENTS DIVISION) Geneva, Illinois Georgetown, Ontario Jefferson, Indiana Washington, Indiana	Decorative Laminates Olon Components Olon Creative Products Olon Components	FSC FSC FSC FSC	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •		Decorative profile wrapped cabinet stiles and rails with thermally fused polyester, vinyl and lightweight papers. Vinyl wrapped drawer components, v-grooved, blank, mitrefold and KD drawer systems. Baltic birch drawer sides.	All locations: MDF, Solid Wood, Metal, Backers, Fiberglass, Plastic	No

PANEL SPECIALISTS, INC. Temple, Texas																									Custom Component parts and OEM manufacturing. Manufactures Wall Systems, Casework, Marine Panels, and Panel Board. Services include laminating, edgebanding, cut-sizing, drilling, and machining.	PB, MDF, HB, Therman	No	
PANOLAM INDUSTRIES INTERNATIONAL, INC. Albany, Oregon Huntsville, Ontario Norcross, Georgia Oshkosh, Wisconsin		Panolam® TFM, Pluswood® TFM FSC, SFI/SCA Panolam® TFM, Pluswood® TFM FSC, SFI/SCA Panolam® TFM, Pluswood® TFM FSC, SFI/SCA Panolam® TFM, Pluswood® TFM FSC, SFI/SCA	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •	Six laminating plants located throughout North America (Albany, OR; Auburn, ME; Hampton, SC; Huntsville, ON; Norcross, GA; Oshkosh, WI).	All locations: PB, MDF, Hardwood Plywood	Yes Yes Yes Yes	
PASQUIER PANEL PRODUCTS Sumner, Washington																									Custom laminating and cutting – shelving and drawer parts – edgebanding, CNC routing and boring, moulding, profile wrapping and RTA packaging to precise custom specifications.	PB, MDF, HB, Plywood	No	
PATRICK INDUSTRIES, INC. Elkhart, Indiana																									Eight laminating plants located throughout the US (Elkhart, IN; Mt. Joy, PA; Decatur, AL; Phoenix, AZ; Waco, TX; Woodburn, OR; Fontana, CA). Drawer sides, wrapped mouldings, cut-to-size, HPL panels, edgebanding and custom components, and membrane pressed doors.	PB, MDF, HB, Luan and Decorative Hardwood, Plywood	No	
PPM PANELS MEXICO MEXICO, S.A. DE C.V. Tijuana, Mexico		Best Board																									PB	Yes
REXCEL SA DE CV Chihuahua, Mexico		Panelart																							In-house impregnation, mix loads capabilities with raw PB, Bullnose, Stair Tread and CTS.	PB	Yes	
ROSEBURG Dillard, Oregon Missoula, Montana Oxford, Mississippi Orangeburg, South Carolina		Duramine TFM, Hardwood Plywood, UltraFinish-Paper & Vinyl Overlays, RediPly, Melagard, Redisheif, SkyBlend™ Duramine TFM, Melagard, Redisheif, SkyBlend™ Duramine TFM, SkyBlend™ Duramine TFM, SkyBlend™	FSC • • • • • • • • • • • • • • • • FSC FSC	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	Mixed shipments of flat panel, CTS, edge-treated matching surfaces from this integrated producer of custom designs, Wilsonart, Formica, Arclin, Coveright and others. Mixed shipments of flat panel, from this integrated producer of custom designs, Wilsonart, Formica, Arclin, Coveright and others.	PB, MDF, VC, HB, SkyBlend™ and others PB, MDF, SkyBlend™ and others	Yes Yes No No	
ROUCKE, INC. Denver, Colorado																									Full service panel processing from cut-to-size to CNC machining. Flat or 3-D processing of rigid thermal foil to match TFM & HPL. Coveright, Arclin, Formica and Wilsonart TFM papers. All brands high pressure laminate bonded panels. Bulk or custom packaging available.	PB, MDF, Plywood, NAF, NAUF PB & MDF FR PB & MDF	No	
SHIOLENO INDUSTRIES, INC. Arlington, Texas		Rainbow Panels																							Specialist in short run batches of TFM and HPL panels. Quick to Ship Program. Most major brands for TFM/HPL matches, including PVC custom edging to match. Full service manufacturing facility including: Cut to size, EB, CNC Routing & Drilling and UV Coatings. Fully integrated production for Fixtures, Shelving, Cabinets, Closets Systems and Drawer components.	PB, MDF, HB, Fire-rated, NAF	No	
STEVENS INDUSTRIES, INC. Teutopolis, Illinois		Stevens TFM, Stevens HPL, StevensWood™, Stevens Shelf™																							Thermofused Melamine Panels: Special wood look and feel textures (StevensWood), Wilsonart, Coveright, Pionite and Formica patterns. High Pressure Laminate Panels: All major brands including Wilsonart, Pionite, Formica and Nevamar. Component Fabrication: Cut-to-size, EB, CNC routing, contour edging, postforming (HPL and TFM) closet parts, cabinet parts, fixture components and shelving.	PB, MDF, Plywood, Fire-rated PB, MDF, Moisture-resistant PB, MDF, NAF (Green) PB, MDF	No	
TAFISA CANADA INC. Lac-Mégantic, Quebec		Tafilam																							Tafilam color range offered with various complementary color matching products such as high pressure laminates, PVC edgebanding, polyester wrapped mouldings, thermovinyl films and five piece doors.	PB, MDF, NAF PB	Yes	
TIMBER PRODUCTS COMPANY White City, Oregon		Spectraboard, Spectracore, ColorLam, TufDec, Polyboard, Decraboard	FSC/SFI																						Cut-to-size, shelving, drilling, hardwood veneer one-side and sublimation grade polyester.	PB, MDF, Plywood	Yes	
UNIBOARD Moncure, North Carolina Sayabec, Quebec Val-d'Or, Quebec		Uniboard TFM Uniboard TFM Uniboard TFM	FSC FSC FSC	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	• •	Thermofused melamine panels. Matching products such as high pressure laminates. PVC edgebanding, mouldings and RTF. All surfaces available on NU Green particleboard – no urea formaldehyde added. Multiple surface textures / glosses and multiple sizes.	PB, NU Green MDF, HDF	Yes	
VISULAM DIVISION DE PRODUITS FORESTIER AFA INC. Lachute, Quebec																									Top quality TFM panels with decorative overlays, multiple surface textures & glosses, complete fabrication/component capability and multiple sizes, slotwall panels, edgebanding/shelving, custom components and cut-to-size, bullnose edge, drawer sides, shelving, end panels, tops & bottoms.	PB, MDF	No	

* These companies and facilities offer products made with "No added urea-formaldehyde" (NAUF) panel products. NAUF panel products may be eligible for low-emitting materials credit under LEED for Commercial Interiors and LEED for New Construction and Major Renovations.



COMPANY AND LOCATION	BRAND NAME	CERTIFIED WOOD	EPP DOWNSTREAM LICENSED FACILITY	NAUF (NO ADDED UREA-FORMALDEHYDE)*	LIQUID COATING	POWDER COATING	PRINTING	SPECIAL TREATMENTS, FEATURES, CAPABILITIES AND SERVICES	SUBSTRATES OFFERED	PB, MDF, OR HB PRODUCER
AMERICAN ADHESIVE COATINGS LLC Lawrence, Massachusetts					•			Manufacturer of hot melt adhesives for particleboard and MDF laminations to paper up to five feet wide.		No
BAUSCHLINNEMANN NA Greensboro, North Carolina Myrtle Beach, South Carolina	TecoFoil, TecoLine, TecoTop, TecoLam				•			Pre-applied hotmelt adhesive.		No
CDM DÉCOR PAPERS INC. Drummondville, Quebec					•			Pre-applied hotmelt adhesive.		No
CLOSETMAID COMPANIES Chino, California						•		Wood powder coating, custom components, cut-to-size, CNC routing.	PB, MDF, HB, Lauan	No
COLUMBIA FOREST PRODUCTS Chatham, Virginia Hearst, Ontario Klamath Falls, Oregon Old Fort, North Carolina Trumann, Arkansas		FSC FSC FSC FSC FSC		• • • • •	• • • • •			Hardwood Plywood. Hardwood Plywood. Hardwood Plywood. Primer Finish, Hardwood Plywood, Cut-to-Size Available, Beaded Panels. Hardwood Plywood and Laminating, Beaded Panels.	PB, MDF, HB, Plywood PB, MDF, HB, Plywood PB, MDF, HB, Plywood PB, MDF, HB, Plywood PB, MDF, HB, Plywood	No No No No No
FLAKEBOARD St. Stephen, New Brunswick	Rezcote		•	•	•		•	Standard acrylic and UV top coat, unlimited solid colors, wood grain print.	PB, MDF, Fibrex®	Yes
FUNDER AMERICA, INC. Mocksville, North Carolina			•			•		Wood powder coating, custom components, cut-to-size, CNC routing.	PB, MDF	No
ROSEBURG Dillard, Oregon Missoula, Montana	UltraFinish-UV Cured Paints & Finishes, SkyBlend™ UltraFinish-UV Cured Paint & Finishes, SkyBlend™	FSC	•	•	•		•	UV fill and topcoat, wood grain print, PB, MDF, VC, acrylic solid colors with custom color program, prefinished shelving and edge banding. UV fill and topcoat, wood grain print, PB, MDF, VC, acrylic solid colors with custom color program, prefinished shelving and edge banding.	PB, MDF, SkyBlend™, and others PB, MDF, SkyBlend™, and others	Yes Yes

* These companies and facilities offer products made with "No added urea-formaldehyde" (NAUF) panel products. NAUF panel products may be eligible for low-emitting materials credit under LEED for Commercial Interiors and LEED for New Construction and Major Renovations.

COATING MANUFACTURERS

COMPOSITE PANEL ASSOCIATION



COMPANY AND LOCATION

BRAND NAME

LIQUID COATING

POWDER COATING

PRINTING

SPECIAL TREATMENTS, FEATURES, CAPABILITIES AND SERVICES

SUBSTRATES OFFERED

PB, MDF, OR HB PRODUCER

AKZO NOBEL COATINGS, INC.

High Point, North Carolina

Chemcraft®

•

Industrial wood finishes that provide decorative and protective qualities for wood, MDF, wood composites and wood-based products. AkzoNobel specializes in Building Products Interior and Exterior, Cabinetry, Contract Furniture, Distribution, Flooring, Furniture, Windows and Doors, and more. We pride ourselves in exceptional Sales, Customer Service and Technical Support

No

AMERICAN ADHESIVE COATINGS LLC

Lawrence, Massachusetts

•

Manufacturer of hot melt adhesives for particleboard and MDF laminations to paper up to five feet wide.

No

THE VALSPAR CORPORATION

High Point, North Carolina

•

•

Decorative and protective coatings for wood, metal and plastic in the industrial markets, interior and exterior decorative paints and aerosols for architectural use, coatings and inks for rigid packaging containers, automotive and fleet refinish products, floor coatings and specialty polymers, composites and colorants.

No

TIGER DRYLAC POWDER COATINGS

Reading, Pennsylvania

•

Environmentally friendly powder coatings for wood (MDF) as well as metals. Largest selection of colors and finishes in the industry. North American as well as Global production and distribution network.

No

OVERLAY MANUFACTURERS

COMPOSITE PANEL ASSOCIATION



COMPANY AND LOCATION	BRAND NAME	3-D LAMINATES	CPL (CONTINUOUS PRESSED LAMINATE)	DECORATIVE FOILS	HEAT TRANSFER FOIL	HIGH PRESSURE LAMINATES	LIGHT BASIS WEIGHT PAPER	PHENOLIC	POLYESTER	POLYPROPYLENE	SATURATED PAPER	THERMALLY FUSED MELAMINE	VINYL FILM	WOOD VENEER	OTHER (SEE NEXT COLUMN)	OTHER PRODUCT TYPES	SPECIAL TREATMENTS, FEATURES AND CAPABILITIES
AET FILMS New Castle, Delaware	SynDECOR®									•						• SynDECOR®, a performance polymer-based decorative overlay	Water resistant, sustainable overlay. Dimensionally stable. High print fidelity. Miter-foldable. No VOC's. Available 23gsm thru 56gsm; white and beige.
AMERICAN RENOLIT CORPORATION Swedesboro, New Jersey LaPorte, Indiana	RENOLIT	•							•	•				•		• Exterior Film	3D laminates, PVC, PET and PP decorative films for pressing wrapping and thermoforming. Horizontal grades. Extensive stocking with cut roll program. Solids, prints, metallic and high gloss. Popular TFM/HPL matching program.
ARCLIN Tacoma, Washington	E-Gen		•			•		•			•	•				• Glue films, backers	Arclin's E-Gen designated decorative overlays are available for TFM, HPL, CPL, flooring and industrial surfacing applications. Available with GREENGUARD, Children and Schools, and FSC Chain of Custody Certification.
ARJO WIGGINS USA, INC. Stamford, Connecticut																• Base paper manufacturer (saturating and pre-impregnated) for the printing, saturating and laminating industry	
BAUSCHLINNEMANN NA Greensboro, North Carolina Myrtle Beach, South Carolina	TecoFoil, TecoLine, TecoTop, TecoLam		•	•		•										• Pre-applied hotmelt adhesive	Flat surface and profile wrap laminates, high abrasive resistant surfaces, recoatable surfaces, melamine edgebanding for straight and softformed edges, slitting services.
CDM DÉCOR PAPERS INC. Drummondville, Quebec	AquaSeal™, Foilspec™, Microspec™			•		•				•						• Pre-applied hotmelt adhesive	AquaSEAL™: Water, stain and abrasion resistant, dimensionally stable, resists shrink/creep, formaldehyde free. Electron beam cured decorative foils and light basis weight papers.
CHIYODA AMERICA, INC. Morgantown, Pennsylvania				•		•					•			•			Zen Finish. North American printing and design services. Experienced in matching design and color across product mix for maximum end use opportunities. Solid Color Light Weight (30gm) paper.
COVERIGHT SURFACES AMERICAS Blythewood, South Carolina Curitiba Brazil Cobourg, Ontario	Silveright, Hi-Wear					•					•	•		•	•	• Broad range of technical films. • PG backers, glue films, Coated Glass • Mat, Decorative prints for surfaces	High Wear Melamine, impact resistant melamine. Silveright anti-bacterial surface treatment now available for TFM Decorative prints and can be ordered in sheet or roll form, HPL, Laminate flooring surfaces and other building products.
FORMICA CORPORATION Cincinnati, Ohio	Formica High Pressure Laminates, Formica Solid Surfacing, DecoMetal Metal Laminates, Formica Veneer Premium Wood Surfacing, Chemtop2					•					•					• Solid surfacing, metal and wood laminates	Innovative High Pressure Laminate finishes: Etchings, Honed, Naturelle, MicroDot, Riverwash; Radiance; fire and chemical resistant laminates, compact phenolic panels.
INTERPRINT, INC. Pittsfield, Massachusetts				•		•					•						Decorative printing, in-house laser engraving, design and repro services.
KAPSTONE CHARLESTON KRAFT LLC North Charleston, South Carolina																• Producers of DuraSorb® saturating kraft paper for use as core paper for HPL, CPL, and compact laminates as well as overlays for construction grade applications.	

LAMIGRAF, S.A. Barcelona, Spain Bonnen, Germany																	<ul style="list-style-type: none"> Decorative and solid color printed papers for TFM, HPL and laminate flooring markets 	Decorative printing of saturating papers up to 2700mm wide, along with full digital design and engraving services.
MUNKSJO PAPER Fitchburg, Massachusetts																	<ul style="list-style-type: none"> Base paper manufacturer for the printing, saturating & laminating industry 	
OLON INDUSTRIES INC. (Decoratives Division) Geneva, Illinois Olon Decorative laminates		•	•														<ul style="list-style-type: none"> Olon Thermally Fused Continuous Decorative Laminates 	Continuous TF laminates for wrapping and edgbanding applications. Designs to complement Arclin, Coverright, Flakeboard, Formica, Nevamar, Panval, Tafisa and Wilsonart. High abrasion resistant wrapping grade laminates for flooring laminate designs. Saturated products with polyester resins, such as décor cellulose paper, fiberglass and backers. Available with antimicrobial protection.
OMNOVA SOLUTIONS, INC. Fairlawn, Ohio Auburn, Pennsylvania Jeanette, Pennsylvania Monroe, North Carolina OMNOVA Laminates, surf(x) 3D Laminates, EFX 3D Laminates, radiance Flat Laminates, duraMAX Flat Laminates		•	•						•								<ul style="list-style-type: none"> EFX 3-D Laminates (non-PVC), pre-applied adhesive, broad range of technical films, acrylic laminates 	North American manufacturer with short lead times, leading print designs, small minimum orders, extensive stock program and a range of performance coatings. Variety of constructions with matching designs across constructions (Harmony Program) provides the best application of laminate based on cost and functional requirements.
PANOLAM INDUSTRIES INTERNATIONAL, INC. Auburn, Maine Hampton, South Carolina Morristown, Tennessee Oshkosh, Wisconsin Pionite® decorative laminate Nevamar® decorative laminate ProWrap® Polyester and Melamine Panolam® TFM, Pluswood® TFM			•	•		•	•											<ul style="list-style-type: none"> Custom print capabilities in TFM and HPL. Custom print capabilities in TFM and HPL. ProWrap® Polyester and Melamine in standard and high-wear laminates in a variety of textures. Custom print capabilities in TFM and HPL.
RIKEN U.S.A. Burlington, New Jersey Integra, Tre Nuovo, FINO, Rivestar		•																<ul style="list-style-type: none"> Printing, top coats, non PVC, UV top coats, 3D thermofoil, high gloss thermofoil.
SCHATTEDECOR St. Louis, Missouri			•															
SUDDEKOR, LLC Agawam, Massachusetts East Longmeadow, Massachusetts Biscoe, North Carolina D. Fin, D. Film, D. Release				•														<ul style="list-style-type: none"> Design service and in-house engraving offering prompt, proprietary service. Impregnation of high-clarity overlays, decorative prints, and backer papers, in either roll or sheet form, at two North American locations. New line of D.Fin® finish foils and D.Release® release papers engineered to visually and technically coordinate with Süddekor products.
SURFACE SOURCE INTERNATIONAL Randolph, New Jersey Klöckner Pentaplast, Pentadecor®, Basic Line, Matte Line, Gloss Line, kpExtreme™, EGR, Stylelite®, Zenolite®, Acrylic sheets, 2D Acrylics		•	•														<ul style="list-style-type: none"> Phenolic Backed 3D Laminates Peel n stick 3D laminates, ABS - Edge banding 	Stocking distributor with same day shipping and a on-staff technical department. HPL/TFM matching program. Slitting services available. PVC & PET High Gloss and solid color 3DL program. Industry leading printed designs with a wide range of embossing's from, ultra-smooth to deep texture. Special surfaces available for healthcare and fixture & display markets.
TECHNOCELL DEKOR Pulaski, New York																	<ul style="list-style-type: none"> Base paper manufacturer (saturating and pre-impregnated) for the printing, saturating and laminating industry 	
TOPPAN INTERAMERICA INC. McDonough, Georgia			•														<ul style="list-style-type: none"> Non PVC film (printed) 	
U.S. COATING COMPANY Lexington, South Carolina			•														<ul style="list-style-type: none"> Paintable/glueable papers and backing 	Electron beam cured decorative foils; pigmented coatings applied to specialty papers, basis weights from 40gsm to 100 gsm.
WILSONART INTERNATIONAL Temple, Texas Wilsonart Laminate, Wilsonart HD High Definition Laminate, Chemsurf Chemical-Resistant Laminate																	<ul style="list-style-type: none"> Wilsonart Solid Surface, Decorative Metals, and Adhesives. 	AEON™ Enhanced Performance; Digital and Silk-Screened Custom Laminate; Performance Types: Chemical Resistant, Fire-Rated, Marker Board, Chalkboard, High Wear Laminates.
ZAMMA CORPORATION Orange, Virginia		•	•														<ul style="list-style-type: none"> Frame and profile wrapping, floor transitions, mouldings. 	Laminates and continuous pressure laminates for flat surfaces and profile wrapping in various surface finishes. High abrasive resistant surfaces including flooring grade. Edgbanding and custom treating solutions up to 1,400 mm (55") wide.

LAMINATORS

COMPOSITE PANEL ASSOCIATION



LAMINATORS 2011

COMPANY AND LOCATION	BRAND NAME	CERTIFIED WOOD	EPP DOWNSTREAM LICENSED FACILITY	NAUF (NO ADDED UREA-FORMALDEHYDE)*	3-D LAMINATES	DECORATIVE FOILS	HEAT TRANSFER FOIL	HIGH PRESSURE LAMINATES	LIGHT BASIS WEIGHT PAPER	MDO / HDO	PHENOLIC	POLYESTER	POLYPROPYLENE	SATURATED PAPER	THERMALLY FUSED MELAMINE	VINYL FILM	WOOD VENEER	SPECIAL TREATMENTS, FEATURES AND CAPABILITIES	SUBSTRATES OFFERED	PB, MDF OR HB PRODUCER
AMERICAN LAMINATES, INCORPORATED Riverbank, California		FSC	•	•											•			Offering premium melamine panels with high specification industrial particleboard and MDF. 60 colors in stock. High inventory including shelving, edge banding and line-boring. Fast service to distributors in Western USA.	EPP PB, MDF, NAF PB, MDF	No
CLARION BOARDS, INC. Clarion, Pennsylvania		FSC													•			E-I-R (Embossed-in-Register) Capable.	MDF	Yes
CLOSETMAID COMPANIES Chino, California														•	•			Custom components, cut-to-size and CNC routing.	PB, MDF, HB	No
COLUMBIA FOREST PRODUCTS St. Casimir, Quebec Trumann, Arkansas	Melawood products	FSC FSC	•	•		•		•	•						•			Hardwood Plywood. FSC Capable. Hardwood Plywood. Capable of laminating 5' wide panels. FSC Capable. Coating Available.	PB, MDF, HB, Plywood PB, MDF, HB, Plywood	No No
DURAPLAY DE PARRAL, SA DE CV Chihuahua, Mexico	Duralam, Duramel, Duracore					•		•	•						•			Mix loads capabilities with raw PB, Mende, softwood and hardwood plywood, CTS, bullnose and furniture parts.	PB, MDF, Mende, Veneer Core	Yes
FLAKEBOARD Albany, Oregon Bennettsville, South Carolina Sault Ste. Marie, Ontario Simsboro, Louisiana St. Stephen, New Brunswick	Duraflake UltraPine® Superior MDF, Superior Plus MDF, Superior SW MDF UltraPine® Fibrex®, Rezflake	FSC FSC													• • • • •			Mix ship capabilities with raw MDF, melamine laminated MDF and particleboard. Can produce MDF/HDF, particleboard, mende with paint, print, melamine, paper/foils, CTS and perforated board from one source. Specialty products also include melamine lamination on thin MDF (Fibrex®), moisture resistant, fire-rated and no added urea-formaldehyde resin (Vesta) particleboard and MDF.	PB, MDF Fire-rated PB, PB, MDF, Moisture Resistant PB, MDF PR, MDF, Fibrex®	Yes Yes Yes Yes Yes
FLORIDA PLYWOODS, INC. Greenville, Florida									•						•	•		Cut-to-size, bullnose edge, drawer sides, shelving, end panels, tops & bottoms. Particleboard manufactured in-house; homogeneous.	PB, MDF, Veneer Core	Yes
FUNDER AMERICA, INC. Hope, Arkansas; Mocksville, North Carolina; Sebring, Florida	FUNDER	FSC	•	•				•							•	•		Multiple surface textures & glosses, complete fabrication/ component capability and multiple sizes.	PB, MDF	No
KML CORPORATION Tacoma, Washington; Stockton, California								•							•			Top quality TFM panels with decorative overlays from Coveright, Arclin, Wilsonart, Formica and Tafisa. Variety of plate finishes available including embossed diamond finish. Slotwall panels, edgebanding/shelving, custom components and line boring. High pressure laminate bonded panels.	PB, MDF, Veneer Core, NAF, FSC, Fire Retardant, Moisture resistant	No
LAMINATE TECHNOLOGIES Tiffin, Ohio Gallatin, Tennessee Diboll, Texas		FSC FSC FSC	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •	• • •		Three fully integrated manufacturing facilities featuring continuous and HPL laminating plus full fabrication capabilities. Double sided continuous laminators capable of laminating papers, vinyl's, polyester and polypropylene. HPL panels available in many sizes and from all major HPL manufactures. Full fabricating capabilities at all locations including cut-to-size, edge banding, drilling, dadoing, toe notching, mite folding and routing for custom components.	All locations: PB, MDF, HB Hardwood Plywood, Veneer Core	No
MADERAS CONGLOMERADAS S.A. DE C.V. Tlalnepantla, Mexico	MACOPELL, MACOMELL, MACOPLAY					•	•	•	•									Cut to size, LP in one / two faces, Thickness up to one inch, Mix PB/ MDF, Manufacturer of flush doors skins.	PB, MDF	Yes
MJB WOOD GROUP, INC. Cedar Hill, Texas					•		•	•	•									Custom component fabricator. Cut-to-size, edgebanding, CNC routing and boring. National warehouse distribution.	PB, MDF, HB, Plywood	No
OLON INDUSTRIES INC. (COMPONENTS DIVISION) Geneva, Illinois Georgetown, Ontario Jefferson, Indiana Washington, Indiana	Decorative Laminates Olon Components Olon Creative Products Olon Components	FSC FSC FSC FSC	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	• • • •	Decorative profile wrapped cabinet stiles and rails with thermally fused polyester, vinyl and lightweight papers. Vinyl wrapped drawer components, v-grooved, blank, mitrefold and KD drawer systems. Baltic birch drawer sides.	All locations: MDF, Solid Wood, Metal, Backers, Fiberglass, Plastic	No



COMPANY AND LOCATION	BRAND NAME	CERTIFIED WOOD	EPP DOWNSTREAM LICENSED FACILITY	NAUF (NO ADDED UREA-FORMALDEHYDE)*	LIQUID COATING	POWDER COATING	PRINTING	SPECIAL TREATMENTS, FEATURES, CAPABILITIES AND SERVICES	SUBSTRATES OFFERED	PB, MDF, OR HB PRODUCER
AMERICAN ADHESIVE COATINGS LLC Lawrence, Massachusetts					•			Manufacturer of hot melt adhesives for particleboard and MDF laminations to paper up to five feet wide.		No
BAUSCHLINNEMANN NA Greensboro, North Carolina Myrtle Beach, South Carolina	TecoFoil, TecoLine, TecoTop, TecoLam				•			Pre-applied hotmelt adhesive.		No
CDM DÉCOR PAPERS INC. Drummondville, Quebec					•			Pre-applied hotmelt adhesive.		No
CLOSETMAID COMPANIES Chino, California						•		Wood powder coating, custom components, cut-to-size, CNC routing.	PB, MDF, HB, Lauan	No
COLUMBIA FOREST PRODUCTS Chatham, Virginia Hearst, Ontario Klamath Falls, Oregon Old Fort, North Carolina Trumann, Arkansas		FSC FSC FSC FSC FSC		• • • • •	• • • • •			Hardwood Plywood. Hardwood Plywood. Hardwood Plywood. Primer Finish, Hardwood Plywood, Cut-to-Size Available, Beaded Panels. Hardwood Plywood and Laminating, Beaded Panels.	PB, MDF, HB, Plywood PB, MDF, HB, Plywood PB, MDF, HB, Plywood PB, MDF, HB, Plywood PB, MDF, HB, Plywood	No No No No No
FLAKEBOARD St. Stephen, New Brunswick	Rezcote		•	•	•		•	Standard acrylic and UV top coat, unlimited solid colors, wood grain print.	PB, MDF, Fibrex®	Yes
FUNDER AMERICA, INC. Mocksville, North Carolina			•			•		Wood powder coating, custom components, cut-to-size, CNC routing.	PB, MDF	No
ROSEBURG Dillard, Oregon Missoula, Montana	UltraFinish-UV Cured Paints & Finishes, SkyBlend™ UltraFinish-UV Cured Paint & Finishes, SkyBlend™	FSC	•	•	•		• •	UV fill and topcoat, wood grain print, PB, MDF, VC, acrylic solid colors with custom color program, prefinished shelving and edge banding. UV fill and topcoat, wood grain print, PB, MDF, VC, acrylic solid colors with custom color program, prefinished shelving and edge banding.	PB, MDF, SkyBlend™, and others PB, MDF, SkyBlend™, and others	Yes Yes

* These companies and facilities offer products made with "No added urea-formaldehyde" (NAUF) panel products. NAUF panel products may be eligible for low-emitting materials credit under LEED for Commercial Interiors and LEED for New Construction and Major Renovations.

COATING MANUFACTURERS

COMPOSITE PANEL ASSOCIATION



COMPANY AND LOCATION

BRAND NAME

LIQUID COATING

POWDER COATING

PRINTING

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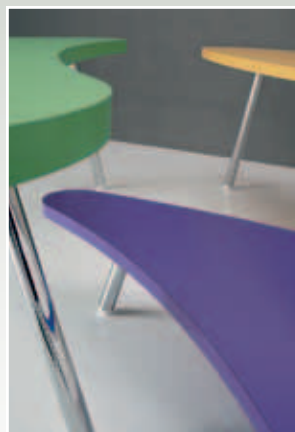
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SPECIFYING SURFACES

Selecting the proper surface material for any project will depend on the type of environment it will be used in, the demands those environments will place on the surfaces and the desired performance characteristics over time. These points should be considered when selecting the proper surface materials in retail, hospitality, education, healthcare or corporate environments. In nearly all cases, a variety of different surface materials will be used within the same space. And it will be critical that those surfaces match each other precisely. Industry innovation, technologically advanced manufacturing processes and cooperation among producers have significantly advanced the “surface material matching programs” as a solution to this challenge. Designers can confidently specify multiple surface materials knowing that each will match in harmony within the space.

The healthcare environment shown here is an example of the use of multiple surface materials, each specifically selected for design and performance.



PRODUCTS USED

1 **EDGEBANDING** is often made from the same material found on the surface of the panel. Melamine or polyester edgework made with décor paper guarantees an exact match. However, considering the abuse in healthcare environments and the demand for performance, 1-2 mm PVC edgework is a better specification here. It can withstand a direct blow without cracking or chipping.

2 **TFM** (thermally fused melamine), decorative foils, PVC sheet or even HPL could be used on the vertical surfaces of the back wall and the cabinet doors. Considering that vertical surfaces take less abuse than horizontal surfaces, TFM might be the best spec for this application.

3 **HIGH PRESSURE LAMINATE** (HPL) is an excellent specification for horizontal surfaces and counters in healthcare. It is easily cleaned and very durable. Less obvious is the use of HPL on the vertical surface of the serving cart. Movable devices tend to receive high levels of abuse, so HPL is a good spec here.

4 **LAMINATE FLOORING** is very popular today in many environments. In healthcare HPL laminate floors are an excellent choice for cleanability, impact-resistance and an ability to withstand the weight of hospital beds.

5 **3DL** (three dimensional laminated film overlays) are the perfect choice for the horizontal surfaces on the serving cart. The design of the tray's elevated edges calls for a laminate that can be applied in three dimensions. 3DL overlays can be PVC, polyester or other engineered thermoplastic sheet laminated to the contoured tray under heat and pressure in a membrane or vacuum press. The application of 3DL eliminates the possibility of contaminants collecting in the panel's seams. It is a very cleanable surface that withstands harsh cleaning agents.

Beneath each and every surface material choice in this hospital room is a composite panel product. Particleboard and medium density fiberboard (MDF) are highly engineered, environmentally friendly and the materials of choice for architects, designers and fabricators.

GLOSSARY OF TERMS

ADHESIVE

A substance capable of holding materials together by surface attachment. The term is used to cover the bonding of sheet material and is synonymous with glue.

BACKER

A non-decorative overlay used on the back of composite panel constructions to protect the substrate from changes in humidity and to balance the panel construction.

BALANCED CONSTRUCTION

A laminated composite panel construction that typically has a similar overlay on both surfaces, which reduces or eliminates warp when subjected to moisture changes.

BASIS WEIGHT

Most often used to characterize the weight of paper products; in the decorative overlay industry the basis weight is defined as the weight in pounds (or grams) per square feet (or square meter) of paper.

BIAXIALLY ORIENTED FILM

Film in which molecules are oriented in two directions within the transverse direction (TD) and machine direction (MD) of the film.

CALENDERED

Polymer is passed through heated rolls, moving at varying rates, to reduce the film thickness.

COATER

A company that paints, prints, primes or otherwise pre-finishes panel substrates with liquid or powder paint finishes.

COATING MANUFACTURER

A company that produces and/or supplies an industrial decorative paint, print or prime coating.

EMBOSSING

A process by which the surface of the panel product is given a relief effect. This can be accomplished with a pressure roll or a patterned caul plate in a hot press.

EPOXY

A two-component thermosetting adhesive typically used for laminating medium and heavy gauge vinyls. Epoxy adhesives are generally blended 1:1 (resin to hardener) by volume and are roll-coated either to the backside of the vinyl web or to the board surface.

HOT MELT

A thermoplastic adhesive that is 100% solid and applied molten to form a bond upon cooling. Hot melts differ from conventional liquid adhesives because they set by cooling rather than by absorption or evaporation of water or solvent.

LAMINATOR

A company that applies an overlay to a panel substrate or other blank material, typically through the use of a bonding system.

MIL

A thickness measurement, typically used for vinyls and papers. One mil = 0.001"

OVERLAY MANUFACTURER

A company that produces and/or supplies a decorative overlay. The manufacturer may add value to the overlay by, for example, applying a topcoat.

POLYURETHANE DISPERSIONS

Polyurethane dispersions are used for the membrane pressing of vinyl films and veneers to a MDF core. They can be used in conjunction with a hardener for higher heat resistance if required. Polyurethane dispersions are typically spray-applied to the MDF and then air-dried before mating with the vinyl film or veneer in the press.

RESIN CONTENT

In the decorative overlay industry, the resin content is the percentage of resin in the saturated paper in relation to the total weight of the saturated paper.

SOLVENT-BORNE ADHESIVES

An adhesive containing polymeric materials dissolved in volatile organic solvents to which other components can be added to obtain certain desired performance properties, such as higher heat resistance. This type of adhesive is typically used on a hot line laminator where it is applied to the board or film surface, dried and then heat-activated prior to a hot roll laminating station. They are non-grain raising and exhibit good coatability, high heat resistance and excellent bond strengths.

SUBSTRATE

A material that provides the surface onto which an adhesive or coating is spread.

TELEGRAPHING

Transfer of substrate surface defects through the thickness of the overlay material.

THERMOPLASTIC

Resins or adhesives that harden at room temperature and re-soften upon exposure to heat.

THERMOSETTING

Resins or adhesives that cure at room temperature or in the hot press by chemical reaction to form rigid bonds that are not re-softened by subsequent exposure to heat (cross-links).

VOLATILES CONTENT





















Weight loss of a saturated paper when heated to bone-dry, expressed as a percentage of the weight of the saturated paper.

WATER-BORNE ADHESIVES

Formulated synthetic polymer (usually polyvinyl acetate or ethylene vinyl acetate). These products are generally used for paper laminating where the adhesive is applied to the web and/or panel surface and tacks up through one or more heated rolls that combine paper to panel.



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