



ROSEBURG

Roseburg Duramine®
Decorative Melamine

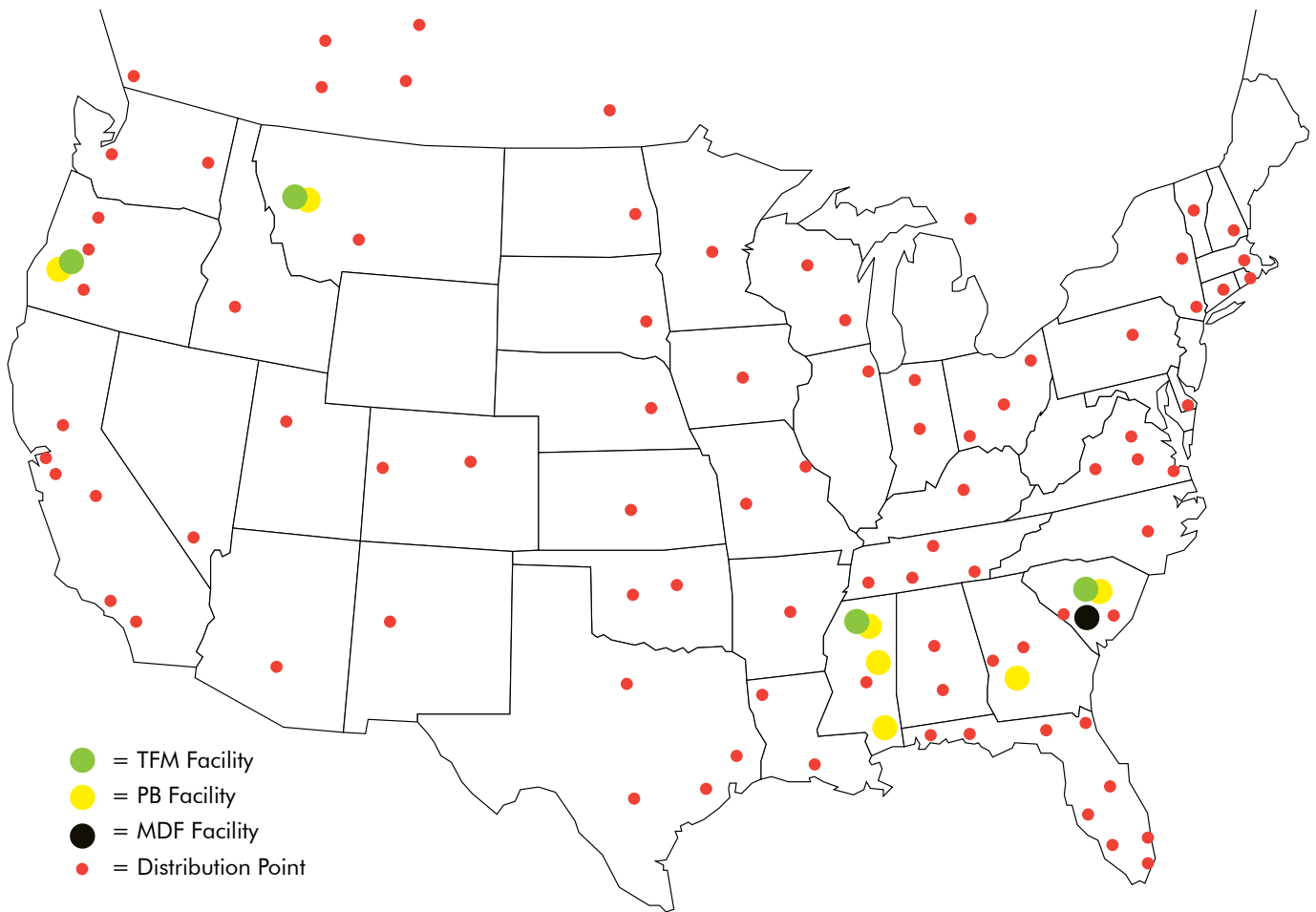


A World Of Panel Options

NATIONWIDE MANUFACTURING AND DISTRIBUTION

Where you need it.

Nationwide Manufacturing Roseburg Duramine® Decorative Melamine panels are manufactured at four technologically advanced, fully integrated facilities, strategically located around the country to provide optimal delivery logistics.



Nationwide Distribution Roseburg Duramine® Melamine is stocked at over 150 of North America's largest and most respected distributors, assuring the flexibility and availability you need to get the job done. To find the distributor nearest you, go to <http://www.roseburg.com/melamine/buy.htm>

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Roseburg is a nationwide,

family-owned manufacturer with lands and facilities throughout the United States, providing of a diverse line of wood products and specialty panels.

This brochure contains extensive information regarding Roseburg Duramine® Decorative Melamine panels. Our four state-of-the-art manufacturing facilities are strategically located in Dillard, OR, Missoula, MT, Orangeburg, SC and Oxford, MS to offer optimum delivery logistics. We've invested in people and technology to provide the best quality and service in the industry.

R O S E B U R G
DURAMINE®
 ■ ■ ■ ■ ■ ■ ■ ■ ■ ■ DECORATIVE MELAMINE ■



ROSEBURG DURAMINE®

■■■■■■■■■■ DECORATIVE MELAMINE ■■■■■■■■■■

YOUR SUCCESS
DEPENDS ON A

Quality
product.

There are so many reasons to choose Duramine® Decorative Melamine, from rich woodgrains, contemporary abstracts, and fine textures to a variety of solid colors. Our broad selection is designed to give you everything you need for a multitude of finished goods. Simply let your imagination go with Duramine®. Plus, you can depend on consistency and a constant color standard. Roseburg goes the extra step to ensure that quality is built in – all the way through the process.

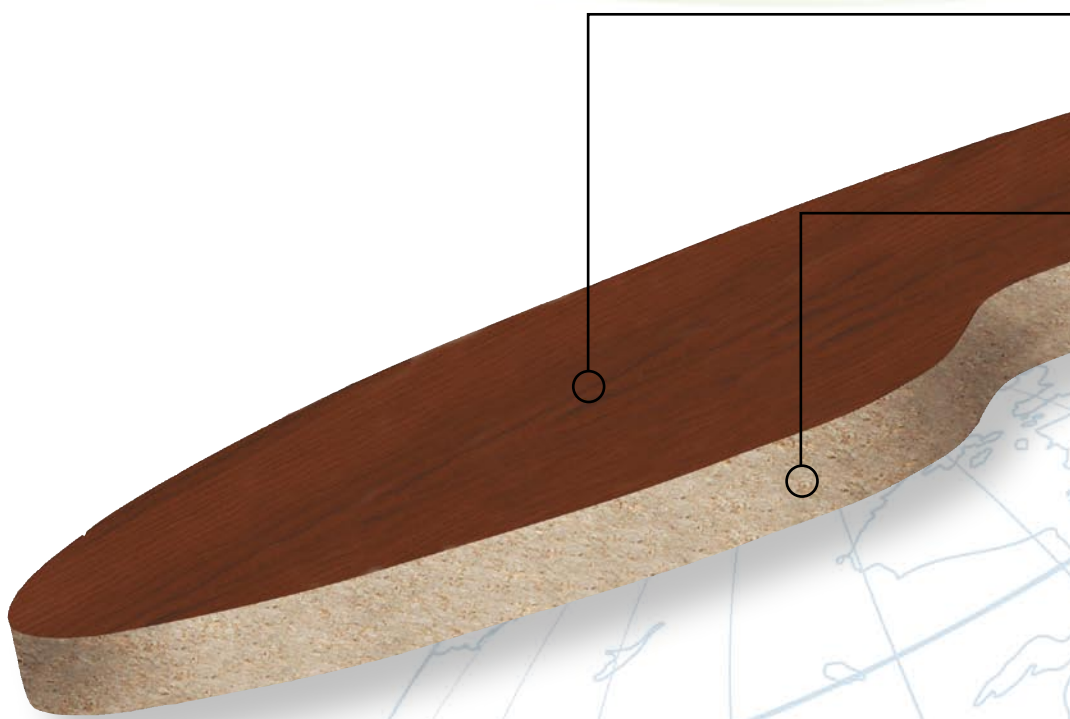
Roseburg Duramine® is perfect for a host of applications. So whether you're designing furniture, commercial fixtures or cabinets, you can count on Duramine® to offer your customers great looks and proven value.

In fact, you'll find the same strength, quality and performance which is behind Roseburg is behind Duramine®, too. At Roseburg, we know that you need quality products which are durable, reliable and

attractive. That's why Duramine® Decorative Melamine is a smart choice. Since we manufacture our particleboard and MDF, you can rely on consistency from sheet-to-sheet and batch-to-batch in addition to a steady supply. Plus, our variety of substrates in a variety of sizes gives you the flexibility to design, based on your project needs.

OUR NAME ISN'T JUST ON IT.
IT'S ALL THE WAY

Through it.



SURFACE

Quality controlled manufacturing means color consistency run-to-run

SUBSTRATE

Roseburg is a leading manufacturer of particleboard and Synergite MDF - assuring quality and strength all the way through

CONSISTENCY

We adhere to tight manufacturing standards, so your process runs smoothly board after board.

ROSEBURG ULTRABLEND PARTICLEBOARD CORE

Ultrablend panels are a premium-quality, mat-formed, multi-layer wood particle panel, made of softwood particles bonded with urea resins. Roseburg offers its Ultrablend with a high-quality, smooth laminating face, machinable edges, and excellent dimensional stability. Ultrablend panels offer controlled performance and precise physical properties for industrial applications. Ultrablend panels are designed for laminating, demanding edge applications and good machining requirements.

ROSEBURG SYNERGITE MDF CORE

Similar to particleboard, medium-density fiberboard (MDF) is made by pressing wood fibers with resin to make a dense panel. MDF uses more highly refined wood fiber, making the panels easier to machine, more water resistant, and stronger. Roseburg's Synergite is a high-quality, light-colored MDF panel, predominantly made from Southern Yellow Pine fiber.

Debut Series

Roseburg adds 5 fresh, new designs to the Debut Series. All 15 "Debut Series" items are "Designed-To-Match" rigid thermal foil and edge banding. Eight of the designs are perfectly matched in HPL by Wilsonart. For more information on these matches, see the cross-reference chart on pages 18-19.

437 - Savannah Cherry



660 - Cranberry Apple



716 - Quartered Caramel Bamboo



717 - Cioccolato Noce



718 - Cafe Primavera

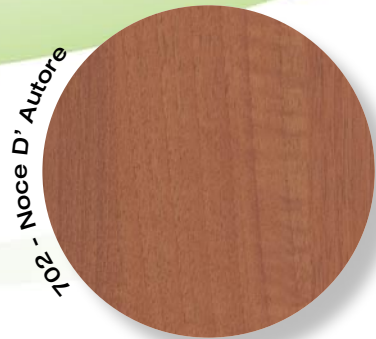




100 - Rustic Alder



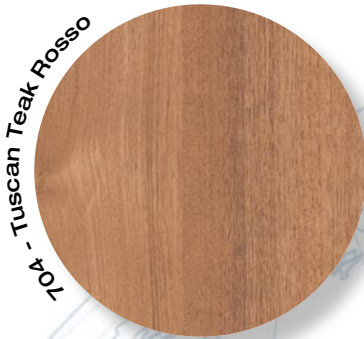
101 - American Black Walnut



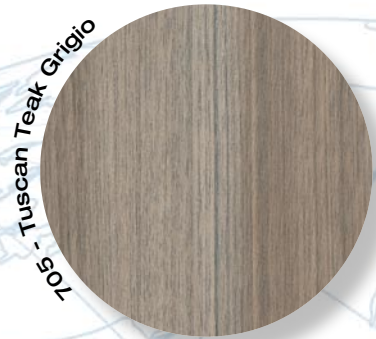
102 - Noce D'Autore



103 - Tuscan Teak



104 - Tuscan Teak Rosso



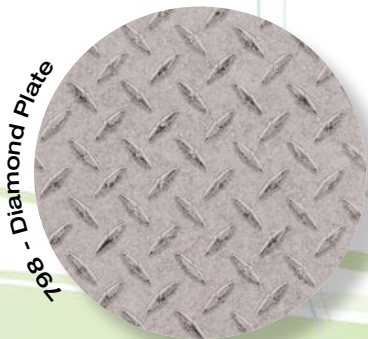
105 - Tuscan Teak Grigio



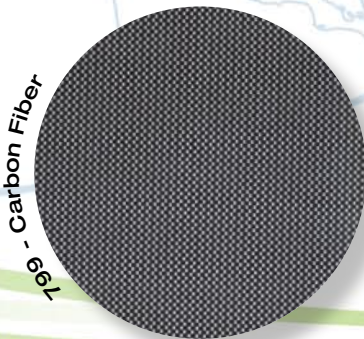
106 - Chocolate Cherry



107 - Jubilee Cherry



198 - Diamond Plate



199 - Carbon Fiber

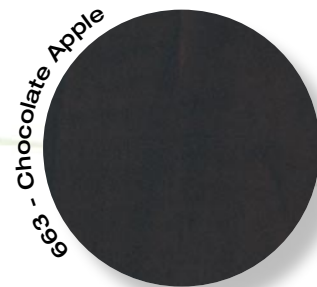
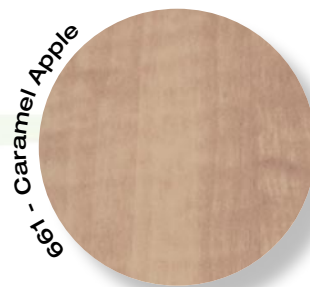
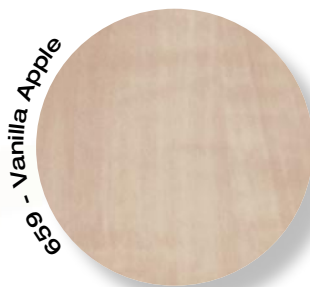
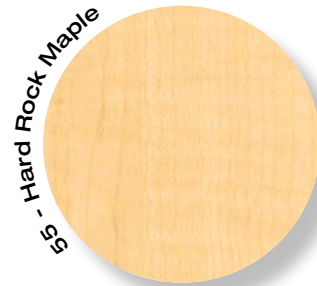
National Design Collection

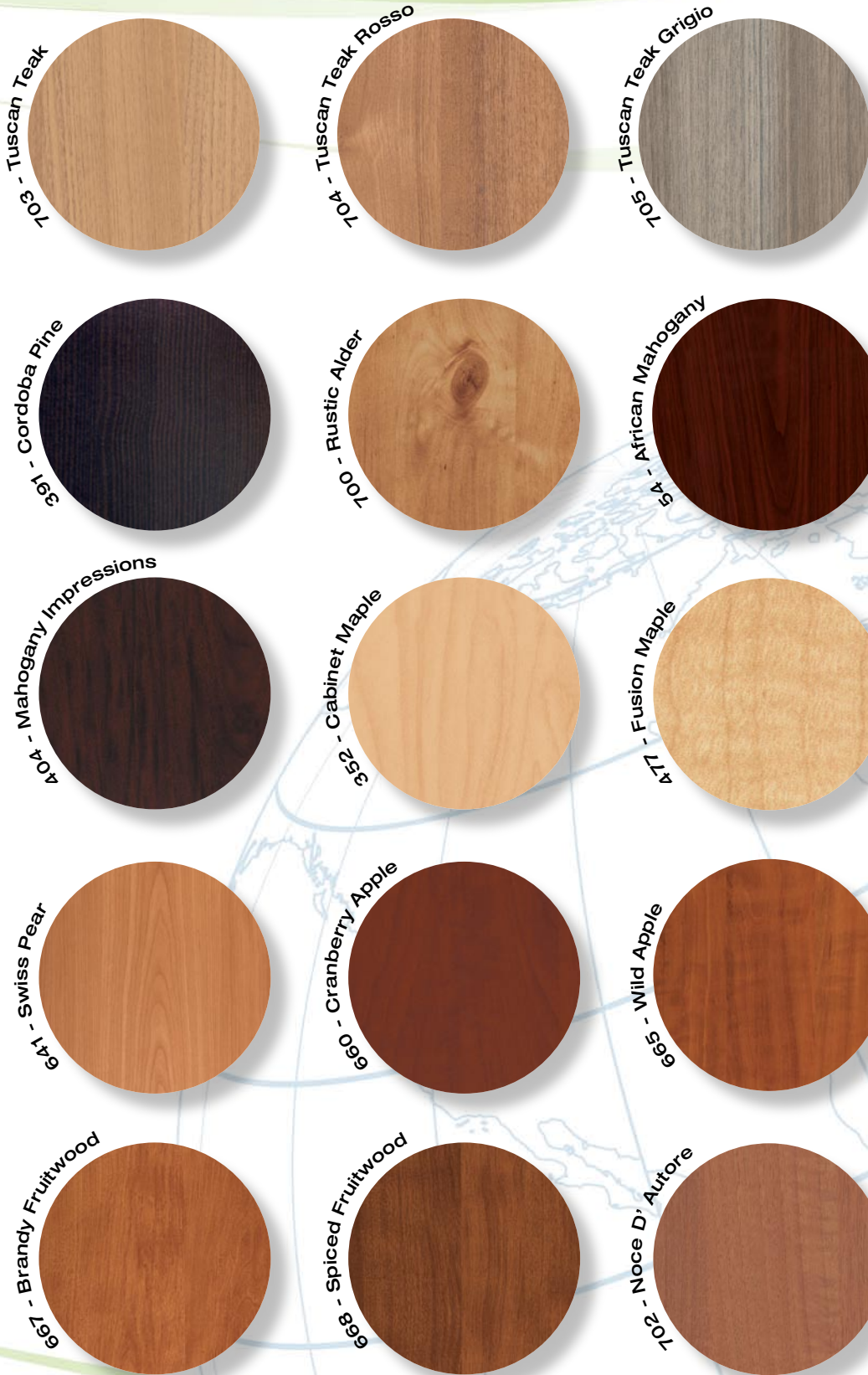
The Duramine® National Design Collection

consists of 55 of the finest designs available from all our mill locations.

Most are "Designed-To Match" rigid thermal foil and edge banding.

For more matching information, see pages 16-19.

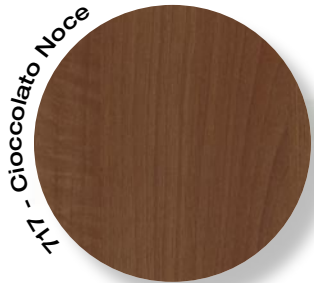




Colors and patterns shown are printed reproductions and may differ slightly from the actual product. Roseburg recommends viewing actual samples.

National Design Collection

717 - Cioccolato Noce



706 - Chocolate Cherry



405 - Serene Cherry



340 - Napa Cherry



327 - Executive Cherry



707 - Jubilee Cherry



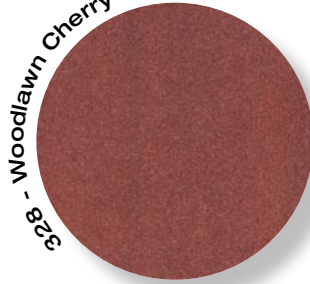
406 - Black Cherry



353 - Harvest Cherry



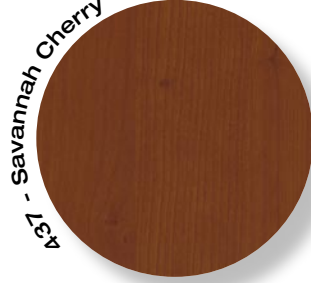
328 - Woodlawn Cherry



701 - American Black Walnut



437 - Savannah Cherry

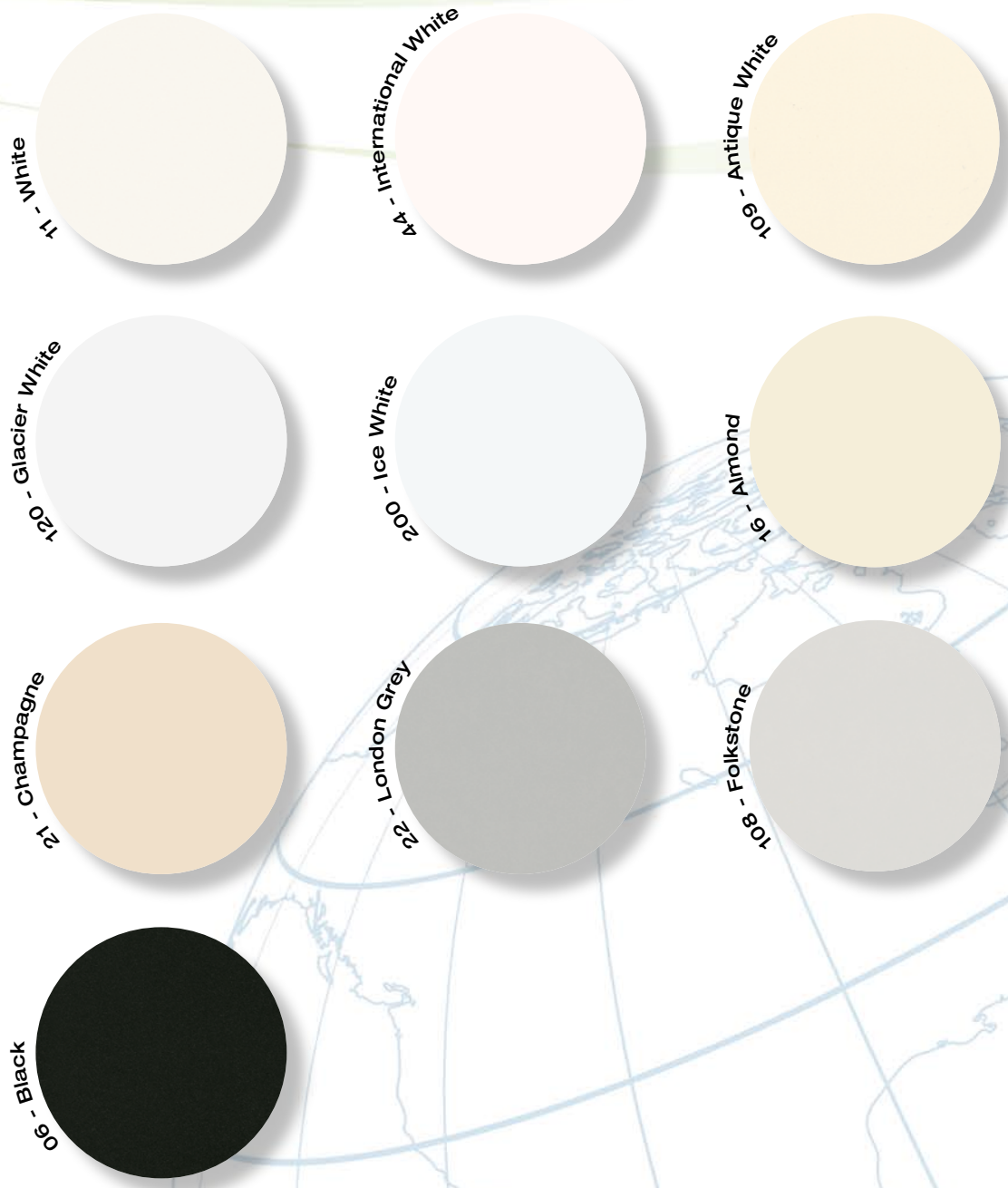


408 - Alabama Cherry



333 - Brentwood Cherry





11 - White

44 - International White

109 - Antique White

120 - Glacier White

200 - Ice White

16 - Almond

21 - Champagne

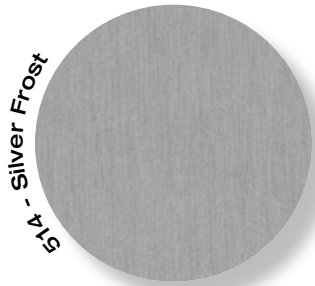
22 - London Grey

108 - Folkstone

06 - Black

Colors and patterns shown are printed reproductions and may differ slightly from the actual product. Roseburg recommends viewing actual samples.

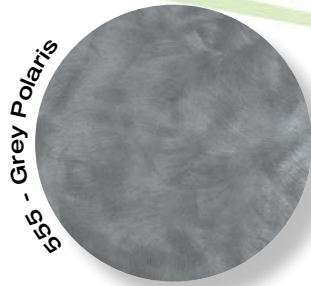
National Design Collection



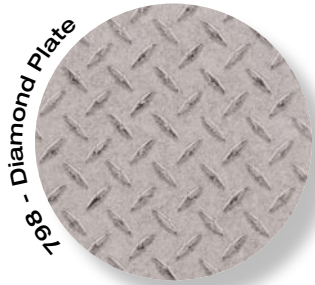
514 - Silver Frost



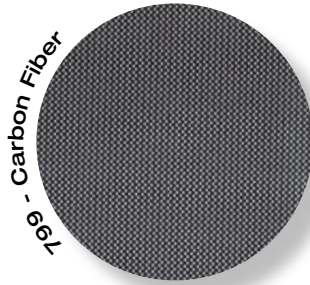
554 - Copper Polaris



555 - Grey Polaris

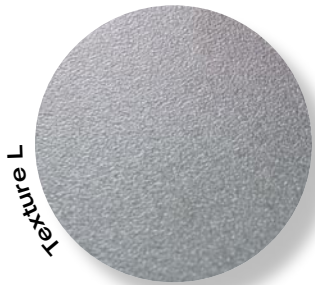


798 - Diamond Plate



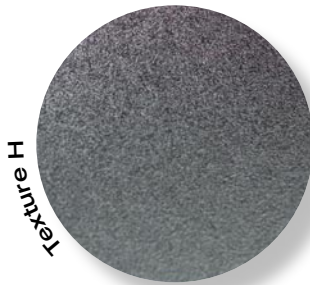
799 - Carbon Fiber

Textures



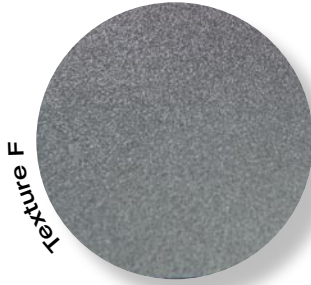
Texture L

Available in Oxford, MS



Texture H

Available in Oxford, MS



Texture F

Available in Oxford, MS



Texture Z

Available in Missoula, MT and Dillard, OR



Texture S

Available all locations

See "Panel Texture" descriptions on page 23.

Colors and patterns shown are printed reproductions and may differ slightly from the actual product. Roseburg recommends viewing actual samples.

Complementary Panels

Roseburg UltraFinish panels are produced, using a durable, low-basis weight paper or vinyl overlay that is applied with a cold rolled adhesive process, which enables one-sided lamination with a raw back. They complement our line of Roseburg Duramine® and are perfect for drawer bottoms, cabinet backs or any other application in which thermally fused melamine is not required.

Vinyl Overlays



Use with 55 Hard Rock Maple Duramine



Use with 06 Black Duramine



Use with 22 London Grey Duramine



Use with 26 Grey Duramine



Use with 16 Almond Duramine



Use with 44 International White Duramine

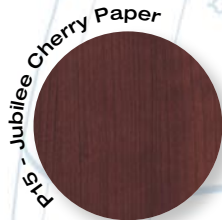


Use with 11 White Duramine

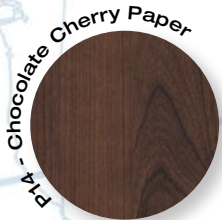
Paper Overlays



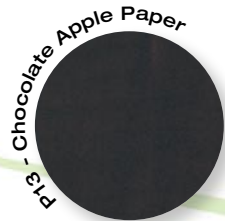
Use with 477/62 Fusion Maple Duramine



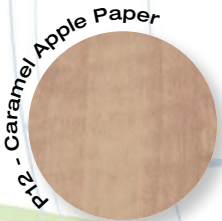
Use with 707 Jubilee Cherry Duramine



Use with 706 Chocolate Cherry Duramine



Use with 663 Chocolate Apple Duramine



Use with 661 Caramel Apple Duramine



Use with 665 Wild Apple Duramine

Synergy Partners Collection

THE DURAMINE® NATIONAL DESIGN AND SYNERGY PARTNERS COLLECTIONS COMBINE TO OFFER

Over 800 designs.



170 designs from one of the world's leading manufacturers of decorative surfacing materials. Many are available in the Coveright Stock HPL program. Some minimums may apply.

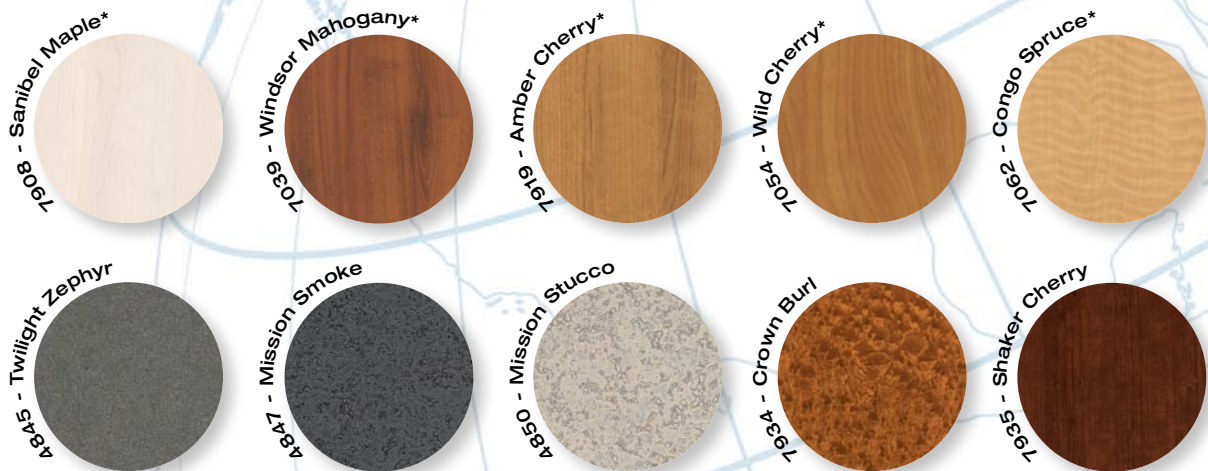


70 decorative melamine overlays available from Arclin – “The Right Designs Available Right Now”. Some minimums may apply.

Note: * = “Regional Collection” items available from our Dillard and Missoula mill locations in smaller minimums. Please refer to the Duramine Regional Collection brochure or contact your local Roseburg distributor or representative.



250 designs are available from Formica. Some minimums and lead-times may apply. Now you can specify and purchase decorative melamine panels, using genuine Formica papers from Duramine and the matching high pressure laminate from Formica.



400 exciting designs are available from Wilsonart. Now you can specify and purchase decorative melamine panels, using genuine Wilsonart papers from Duramine and the matching high pressure laminate from Wilsonart.

Colors and patterns shown are printed reproductions and may differ slightly from the actual product. Roseburg recommends viewing actual samples.

Designed-To-Match System

SIMPLIFY YOUR BUSINESS
WITH DURAMINE'S

Designed-To-Match System.

Roseburg is committed to delivering products that outperform the competition and service that exceeds anything you've experienced. That's why we developed our exclusive Duramine® Designed-To-Match System. This matching system is designed to save you time locating the components you need to complete each order.

By partnering with other manufacturers, Roseburg can help you source a complete package that includes:

- Duramine® Decorative Melamine
- High Pressure Laminate
- Rigid Thermal Foil and 5-piece Doors
- Edge Banding
- Mouldings and other Complementary Accessories

All of these components are precisely matched to over 50 Duramine® solid or woodgrain designs. You do not have to spend time matching various components with melamine panels. We've done all that work for you and simplified the process with one handy, cross-reference chart located on pages 18-19.

Time-saving convenience is not the only advantage of our Duramine® Designed-To-Match System. Duramine® woodgrains are sharper and more realistic looking, thanks to an advanced paper printing process that creates the industry's best-looking colors and patterns.



Designed-To-Match Partners

High Pressure Laminates

Wilsonart

Edgebanding

Canplast

Döellken-Woodtape

Olon

Door Companies

Advanced Door

Brentwood Corporation

California Door

Corona Millworks

Decore-Ative Specialties

Doormark

Drees Wood Products

Georgia Hardwoods

Horizon CNC

JB Cutting

Lamination Technology

Lindsey Door

M and J Woodcrafts Ltd.

Mag Works

Modern Wood Designs

Northern Contours

Polyframe™

US Customized

RTF Manufacturers

American Renolit Corp.

Benecke-Kaliko

Cova

Dackor Hornschuch

Klockner-Pendaplast

Omnova Solutions

ROSEBURG DURAMINE

DECORATIVE MELAMINE

		HPL MATCHES				EDGE-BANDING MATCHES				DURAMINE MATCHES TO DOOR COMPANIES							
		WILSONART wilsonart.com	FORMICA formica.com	Nevamar nevamar.com	Pronite pronitam.com	Roseburg UltraFinish Complementary Panels	CANPLAST canplast.com	DOIKEN WOODTAPE woodtape.com	OLON the olon company olon.com	Advanced Door advdoor.com	Brentwood Corp. brentwoodcorp.com	California Door caldoor.com	Corona Millworks 909-628-9117	Decor-Alive Specialties decorex.com	Doormark doormark.com	Drees Wood Products dreeswoodproducts.com	Georgia Hardwoods gahwds.com
SOLIDS & PATTERNS	06	Black	1595	909	S-6-1	SE101	X	1005-9	2416	7003TX	X	X	X	X			X
	11	White	D428/1573	949/7197	S-7-36	SW806	X	1401-9/1463-9	2002/2022	7001TX	X	X	X	X		X	X
	16	Almond	D30	920	S-2-85	ST655	X	2514TL/1543-9	2114	7002TX	X	X	X	X	X	X	X
	21	Champagne	1531(2)	925	S-2-3	ST613		2542TL	2122/2121	7062T							
	22	London Grey	D92	961	S-6-12	SG213	X	1060-9/1059TL	2425	7071TX		X		X		X	
	44	International White	1573	949	S-7-24	SW806	X	1463-9	2002	7309TX		X	X	X	X		X
	108	Folkstone Grey	D381	927	S-6-37	SG241		1066-9	2454	7006TX	X	X	X	X		X	
	109	Antique White	1572	932	S-7-5	SW803		1578TL/4522TL	2115	7113T	X			X	X		
	120	Glacier White	D354	459				1474TL	2001	7153TX		X	X	X			
	200	Ice White						1498-9/1474TL	2022/2027	7001TX				X	X		
	514	Silver Frost	4830			A60		86151TW	6098			X		X	X		X
554	Copper Polaris						9644TL	6151									
555	Grey Polaris						9637TL	6024	1144T		X						
WOODGRAINS	53	Solar Oak	7816			WQ571		6708/58093	3786	8104T		X	X	X	X		
	54	African Mahogany	7122		W-8-343	WY091		5714TL/7673TL	4726/4607	8803		X	X				
	55	Hard Rock Maple	10776	7012		WM791	X	58092/56469	3728/4125	8112T/8507T		X	X	X	X	X	X
	319	Pacific Maple	10745			WM951		55195TL	4938		X				X		
	327	Executive Cherry				WC331		56905TL	5013	1371T				X			
	328	Woodlawn Cherry				W144		7937TL	4624/3777	8667T		X		X	X		
	333	Brentwood Cherry		5904		WC421		57335TL	4570	2635T						X	
	339	Red Alder						55093TL	5012	8870T							
	340	Napa Cherry				W685		58791TL	5016	1402T/1116T			X	X			
	352	Cabinet Maple						58105TL	4975								
	353	Harvest Cherry						58586TL	5130		X				X		
	361	Element Alder				HP688		56414TM	5682	1181T				X	X		
	363	Castle Oak	7928					58642/58030TL	4897								
	371	Medium Sycamore				HP689		58790/56414TM	4489		X	X		X			
	391	Cordoba Pine				WX421		57657TM	4887					X	X		X
	404	Mahogany Impressions	7040	7088	W-8-343			55127TW/6866	3026/4726	1184T/8674T				X			
	405	Serene Cherry			W-8-294	WC411		57245TM	4930	2572T	X	X			X		
	406	Black Cherry						56970TL	4931	2504T	X			X			
408	Alabama Cherry	Arborite T521					58878/57167TL	4821	8880T		X				X		
477	Fusion Maple	7909	7012	W-8-340		X	58080/56232TL	3922	8435T	X	X				X		
641	Swiss Pear			WM-8-342	WX031(1)		58563TL	4296			X	X		X		X	
659	Vanilla Apple						58582/58563TL	5727/4443		X		X	X	X		X	
661	Caramel Apple					X	58792/57048TL	5728		X		X	X	X	X	X	
663	Chocolate Apple					X	58792/57170TL	5650/4763		X		X	X	X	X	X	
665	Wild Apple			W-8-294		X	56967TW	5705/5099	2573T/1196T	X		X	X	X	X		
667	Brandy Fruitwood						56589TM	4933	2571T	X			X			X	
668	Spiced Fruitwood						57244TM	4934/5717	2574T	X			X			X	
DEBUT SERIES	700	Rustic Alder	16025					58726TL	5948	1284T							
	701	American Black Walnut	16026					58727TL	5949	1285T							
	702	Noce d'Autore	16027					58725TL	5950	1286T	X						X
	703	Tuscan Teak	16029					58724TL	5951	1287T							
	704	Tuscan Teak Rosso	16028					58723TL	5952	1288T							
	705	Tuscan Teak Grigio	16030					58722TL	5953	1289T							
	706	Chocolate Cherry					X	58721TL	5954	1290T	X			X			X
	707	Jubilee Cherry					X	58720TL	5955	1291T	X			X	X		X
	798	Diamond Plate	16031					86107TW	6286	7567T							
	799	Carbon Fiber	16032(1)					86108TW	6287	7509T							
	437	Savannah Cherry						58878TL	3005	CM10670							X
660	Cranberry Apple						58879	3142	CM10671								
716	Qtrd Caramel Bamboo						58880TL	3143	CM10672								
717	Ciocolato Noce						58881TL	3144	CM10673								
718	Cafe Primavera						58882TL	3145	CM10674								







Our intent is to illustrate the best identified matching references at time of publication. Roseburg recommends contacting various component manufacturers for current availability and minimums. Roseburg recommends comparing actual samples of TFM, HPL, RTF and edge banding. See Roseburg Regional Brochure for additional designs.

■ = New for 2008 • = Five Piece Door

For additional and updated information, please see: www.Roseburg.com

DURAMINE MATCHES TO DOOR COMPANIES

RTF Manufacturer Matches

Horizon CNC horizon-cnc.com	JB Cutting Inc. jbcutting.com	Lamination Technology (LTI) ltproducts.com	Lindsey Door lindseydoors.com	M and J Woodcrafts Ltd. mjwoodcrafts.com	Meg Works meg-works.com	Modern Wood Designs 818-834-3600	Northern Contours northerncontours.com	Polyframe polyframecabinetdoors.com	US Customized uscustomized.com	 BENECKE-KALIKO callpmi.com	 COVA 3D FORMING VENEERS covaproducts.com	 DACKOR Hornschuch dackor.com	 klöckner pentaplast kpfilms.com	 OMNOVA SOLUTIONS INC. omnova.com	 RENOLIT americanrenolit.com	Other RTF Matches
X	X	X	X		X		X		X	V3918026(1)			Black	488565/488580	9920-278(1)	PVCX-BK8A
X	X	X	X	X	X	X		X •	X	V3870064(1)		428-2065	Glacier White		9317-084(1)	
X	X	X	X	X	X	X	X		X	V3927157(1)		429-0033	Almond		1399-04(1)	
					X		X									
	X	X	X			X	X						Ontario White	488089/488109		
X	X	X		X		X			X					448395 (2)	7265-133(1)	
X	X		X		X			X	X	V3870055(1)		429-1006	Antique White		1458-084(1)	PVCX-WH48A
X	X	X	X	X		X	X			V3870074(1)				494570		PVCX-WH74A
X	X					X	X						Montana White	491885	9341-084(1)	
X	X		X			X	X			V3918151(3)			Brushed Steel	491840 (SA)		

X	X	X	X				X							489215 (2)	3129004-150 (2)	Ambtra VDECRE-52
		X	X				X							490340		
X	X	X	X	X			X	X •	X			422-3019	Hard Rock Mpl	491980 (2)	2007001(1)	
X					X										3199011-043(2)	
	X	X		X		X	X			V3907178 (1)				491480	3196021-043 (1)	
							X						Wild Cherry			
							X			V3907153 (1)				488695 (2)		
						X				V 3960029 (2)	Tara B(2)					
X		X	X				X				Sakura PA (1)	424-5006				
						X									1290002-050	PVCX-HM01
		X	X											422-4005		
														442-3017		
		X	X		X		X		X							Ambtra VDEKRD-44
		X	X	X	X	X						422-4143		491880	82028-1439(2)	Riken Shadow Oak
X																PVCX-MAH01
					X	X			X						2205003-060(1)	
X					X				X						3193014-060(1)	
	X	X		X •			X	X						492210	3214002-060 (1)	
	X	X				X								490370	1282001-043(2)	
X	X	X	X		X	X			X		Geneva C	422-4137	Pearwood		3196016-050	
X			X		X				X		Calvados K			491970 (2)	2188005-050	PVCX-J9309
X	X	X		X •	X		X		X	V3907266(2)		422-4012	Candle Glow	491870 (2)	2188002-050	PVCX-J9306
X			X	X •	X	X			X	V3907258(1)			Chocolate Pear	491950 (1)	3207003-060(1)	PVCX-J9308
X		X	X	X •	X	X	X		X	V3907265(2)	Calvados C(2)	422-4044	Summer Flame	491960 (2)	3207006-060(1)	PVCX-J9307
															2192002-060(1)	
X			X		X				X						2192001-060(1)	

X	X	X			X	X								492260		
X	X	X			X	X				Wisconsin PC(1)						
X		X	X		X	X					422-4144					PVCX-CP02 (2)
X		X			X										4210003-050(2)	
X					X										4210001-050(1)	
X					X	X									3226001-050(1)	
X					X							422-3053		492180		
X	X				X							422-3054		492190		
X					X	X								492270 (2)		
X					X									491040 (2)		
	X													492230	3214004-060	
	X										Calvados V		Tawney Port	491860		
														495080		
											422-4142(1)					Rekin-Cafe Primavera

CoreOptions

Roseburg provides a broad selection of core options including: UltraBlend particleboard, Synergite and other MDFs. For green projects we meet your needs with our hybrid SkyBlend™ particleboard and MDF cores. All of our green cores have no urea formaldehyde added in the manufacturing process. Our engineered core options give you the dimensional stability and surface quality you can rely on every day.



UltraBlend particleboard

is a multi-layered substrate, produced using a blend of softwoods. The combination of sanding to extremely smooth, tight and grainless surfaces on both sides, with a controlled distribution pattern of particles in the core, results in a perfect, dimensionally stable panel.



Roseburg Synergite

Medium Density Fiberboard (MDF) and other MDFs make for a very smooth, consistent panel. This is a great substrate for applications when routing and shaping are required.

Green Core Options

LEED CATEGORY/CREDIT	INTENT	REQUIREMENTS	POSSIBLE POINTS
Materials and Resources MR Credit 4.1 Recycled Content: <i>10% (post+ 1/2 pre-consumer)</i>	Increases the use of products that incorporate recycled content material	Sum of recycled content constitutes at least 10% of materials in the project	1 point
Materials and Resources MR Credit 4.2 Recycled Content: <i>20% (post+ 1/2 pre-consumer)</i>	Increases the use of products that incorporate recycled content material	Sum of recycled content constitutes at least 20% of materials in the project	1 point (in addition to MR credit 4.1)
Indoor Environmental Quality EQ Credit 4.4: Low-Emitting Materials	Improves indoor air quality	Wood products used shall contain no added urea-formaldehyde resins	1 point
Materials and Resources MR 5.1 Regional Materials: <i>10% Extracted, Processed & Manufactured Regionally</i>	Increases the use of materials that are extracted and manufactured within the project region	A min. of 10% of the combined value of building materials or products must be extracted, harvested, or recovered, as well as manufactured within 500 miles of the project	1 point
Materials and Resources MR 5.2 Regional Materials: <i>20% Extracted, Processed & Manufactured Regionally</i>	Increases the use of materials that are extracted and manufactured within the project region	A min. of 20% of the combined value of building materials or products must be extracted, harvested, or recovered, as well as manufactured within 500 miles of the project	1 point (in addition to MR credit 5.1)
Materials and Resources MR Credit 7.0: Certified Wood <i>FSC - Forest Stewardship Council</i> NOTE: FSC Certified SkyBlend only	Encourage environmentally responsible forest management	Use a minimum of 50% wood based materials and products, which are certified in accordance with the Forest Stewardship Council's (FSC) Principles and Criteria, for wood building components	1 point



Roseburg SkyBlend™ core panels are manufactured with SkyBlend™ particleboard or MDF and contain no added urea formaldehyde.

- Particleboard Core
- EPP certified 100% pre-consumer recycled wood fiber Particleboard and MDF
- FSC SkyBlend Particleboard available when specified
- No urea formaldehyde added during the manufacturing process
- Particleboard readily identifiable by its blue-tinted core
- Will contribute to achieving LEED credits

Product Description

Roseburg Duramine® Decorative Melamine panels consist of melamine, resin saturated decorative papers, thermally fused under heat and pressure to a substrate of Roseburg UltraBlend particleboard, Synergite or other MDF (medium

density fiberboard). The thermally fused melamine (TFM) process permanently bonds the paper and the board therefore, there is NO GLUE LINE to delaminate.

Duramine® Benefits

Duramine® decorative panels have the decorative paper already permanently bonded to the substrate. There is:

- No delamination or “peel back.”
- No glue or pressing equipment required.
- No solvent emission from drying glue.
- No disposal of hazardous chemicals.
- No labor required to lay up high pressure laminates.
- Less expense than HPL.
- Less downgrade through fabrication.

Panel Face

Fifty-five solid, pattern and woodgrain designs are available in the Duramine® National Design Collection as well as hundreds of others from Coveright, Dynea, Formica, Wilsonart and other custom sources.

Duramine® panel faces are manufactured to meet or exceed NEMA LD 3-2000-VGL minimum requirements with the exceptions noted in the Surface Properties chart below.

Panel Backs

Duramine® panels are available with decorative faces, two sides or with a white or brown melamine saturated balancing backer sheet. A glueable backer is avail-

able for panels which will subsequently be laminated with high pressure laminate or other materials.

Surface Properties

Tests for Resistance to:	Test Description	Roseburg Duramine®		NEMA LD3-2000 VGL Minimum Performance Standard
		Solid Colors	Wood Grains	
Wear	A measure of the ability of a decorative overlaid surface to maintain its design or color when subjected to prolonged abrasive wear	400 cycles	125 cycles	400 cycles
Scuff	A measure of the ability of a decorative overlaid surface to maintain its original appearance when subjected to prolonged scraping or scuffing	No effect	No effect	No effect
Stain	A measure of the ability of a decorative overlaid surface to resist any discoloration or marring by prolonged contact with 15 common household agents	No effect - 1-11, 15 Moderate - 12-14	No effect - 1-11, 15 Moderate - 12-14	No effect - 1-10 Moderate - 11-15
Cleanability	A measure of the ability of a decorative overlaid surface to retain its color after prolonged exposure to a light source having a frequency range approximating sunlight	No effect Surface cleaned in 10 or fewer strokes	No effect Surface cleaned in 10 or fewer strokes	Surface cleaned in 20 or fewer strokes
Light	A measure of the ability of a decorative overlaid surface to retain its color after prolonged exposure to a light source having a frequency range approximating sunlight	Slight	Slight	Slight
High Temperature	A measure of the ability of a decorative overlaid surface to maintain its color and surface texture when a hot pot of 180° C (356° F) is placed on it for 20 minutes	Slight	Slight	Slight
Radiant Heat	A measure of the ability of a decorative overlaid surface to resist any damage when subjected to a radiant-heat source under controlled laboratory conditions	No effect after 60 seconds	No effect after 60 seconds	No effect after 80 seconds
Boiling Water	A measure of the ability of a decorative overlaid surface to maintain its color and surface texture when subjected to boiling water for a period of 20 minutes	Slight to no effect	Slight to no effect	No effect
Impact	A measure of the ability of a decorative overlaid surface to resist fracture due to the impact of a 1/2 pound steel ball dropped from a measured height	15" without fracture	15" without fracture	15" without fracture

LIMITATIONS: Roseburg Duramine® is recommended for interior vertical and low abuse horizontal applications. For any questions or additional information regarding your particular application, please contact Roseburg at 800-245-1115.

Panel Texture

Duramine® panels are available in five textures as follows:

- “S” Texture features a low gloss, suede/matte appearance — available from Dillard, OR, Missoula, MT and Oxford, MS.
- “Z” Texture features a medium gloss appearance with less aggressive stipple than “S”— available from Dillard, OR and Missoula, MT.
- “F” Texture features a low gloss, at furniture appearance - available from Oxford, MS.
- “H” Texture features a medium gloss light-soft texture – available from Oxford, MS.
- “L” Texture features a lower gloss, light-soft texture – available from Oxford, MS.

Panel Sizes

- 4’ and 5’ wide by 6’ to 12’ long
- ¼” to 1-1/8” Thick
- Note: Most all sizes listed above are available from most presses. Please ask your Roseburg representative for additional information including other available sizes and thicknesses.

Panel Core

Duramine® panels are available on UltraBlend and SkyBlend particleboard, Synergite and other MDF cores.

Please see additional information in the “Core Options” page 20 of this brochure.

Applications

RESIDENTIAL

- Kitchen & Bath Cabinets
- Home Office Furniture
- Ready-To-Assemble Furniture
- Closet & Garage Organizations Systems
- Entertainment Centers

COMMERCIAL

- Store Fixtures and Displays
- Office Furniture & Partitions
- Computer Furniture

INSTITUTIONAL

- Hotel and Motel Furniture
- Wall Coverings & Partitions
- Restaurant Furniture
- Educational, Hospital and Medical Casework
- Educational Furniture

Fabrication Standards

Cabinets constructed with Duramine® Melamine panels will conform to the relevant sections of standards set by the Woodwork Institute (WI) and American Woodwork

Institute (AWI) Standards for exposed and semi-exposed surfaces as well as the Kitchen Cabinet Manufacturers Association (KCMA) (ANSI A 161.1-1990).

How To Specify

Product: Roseburg Duramine® Decorative Melamine Panels

Color name: (Example) Hard Rock Maple Color Ref. #: (Example) 55

Texture: (Example) “S”

Substrate type: (Example) UltraBlend™ particleboard, SkyBlend™ particleboard, Synergite or standard Medium Density Fiberboard (MDF)

Width: (Example) 49” Length: (Example) 97” Thickness: (Example) 3/4”

“See 3 Part Guide Spec” at http://teamrfpco.com/products/SkyBlend_PB_CSI_3_Part_Specifications_Guide_AR.pdf

Handling

PACKAGING

Cover Sheet—Each bundle has a heavyweight cardboard cover sheet to provide protection during material handling and transportation.

Dunnage Sheet—Bottom Board—Each bundle has a protective bottom board to prevent damage from forklifts and to provide additional support for thin panels to prevent sag between stickers.

Bundle Ticket Information—Each bundle is identified by a discrete number on the bundle tag that ties into all manufacturing and process control records. This provides complete traceability back to all raw materials used to produce that bundle.

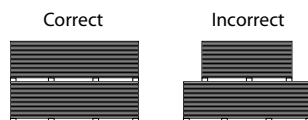
Each bundle tag also clearly identifies the top and bottom paper codes, substrate type, panel dimensions, and any customer-requested P.O. or part numbers.

Storage

To achieve the best performance from your panels, always follow these material handling and storage practices:

- Never store Duramine® panels outside or in close proximity to doors.
- Make sure Duramine® panels are stored in a horizontal position, off the floor, and on a sufficient number of evenly spaced stringers/stickers of equal thickness. This gives a uniform distribution of weight, making handling easier and preventing warping.

The chart at right shows how Duramine® is packaged and shipped from our facility. Roseburg recommends Duramine® be stored in the following manner:



- Limit any stack to a height of five (5) bundles. Never put bundles of different sizes in the same stack (ie, 5’ x 8’ on top of 5’ x 9’). Runners should always be in alignment.
- Protect unfinished edges from contact with water to prevent swelling of the substrate.
- Optimum temperatures for storage are between 60° and 90°F (16° and 32°C) with a relative humidity of 40 to 60 percent. Never store panels outdoors. Allow panels to acclimate in these conditions for 48 to 72 hours before fabrication.
- Contaminants can create problems for the finish of your panels. To help prevent the impact of contaminants, isolate storage areas from production lines.

Cleaning, Care, And Maintenance

Duramine® panels can be cleaned after fabrication with mineral spirits or contact adhesive solvent. However, the continued use of solvent cleaners is not recommended.

Never use acidic or alkaline cleaners, abrasive cleaners, or bleach. Duramine® panels should be cleaned with mild soap and warm water or a mild household cleaner like “Formula 409®.”

Drilling, Machining, and Cutting

Drilling - Duramine panels should be drilled with carbide-tipped bits. As with saw blades, there are specific bit designs for your application. Each bit is different in configuration and your needs can be determined by a tooling professional.

A special through boring bit should be used for that particular application. A backing board should also be used for through boring to limit chip out on the exit side of the panel.

Machining With A Saw - Because the substrate is surfaced with decorative material before fabrication, the sawing process is critical to avoid chipping or burning. Fabricators can encounter a chipping problem, especially when converting their operation from the use of solid wood or high pressure laminate to melamine panels. Therefore, diamond or carbide-tipped tools should be used and should always be kept sharp. Dull tools not only cause chipping but burning problems as well.

Heat buildup is a major cause of tool wear and poor-quality cutting. Geometry, size, and turning speed of the saw blade, as well as the speed of feeding, are all important to minimize heat build-up.

Heat build-up is also minimized by:

- Good tool design.
- Scheduled tool changes.
- Effective cooling during operation.
- An efficient dust-removal system.

Duramine® can be cut with many different types and configurations of saw blades. The correct setup for your equipment can be established by both the manufacturer of your equipment and your tooling supplier. Listed below are some of the basic blades that are used for cutting composite boards with thermally fused melamine. All modern panel cutting equipment with scoring units are engineered with specific cutting tool designs actually made for the application of sizing Duramine panels into a finished size.

Typical main blade configurations used with scoring are



CNC Routing

For the nested, through cuts, the use of solid carbide 1/2" two or three flute compression bit between 10,000 and 18,000 RPMs perform better than replaceable insert bits. The feed rate is determined by the chip loading. Your tool manufacturer is a good resource for helping to determine feed rate vs. chip loading. For best results with nested cuts, cut each piece out individually. This will minimize chip out associated with the up-cut portion of the compression bit as it enters the panel. Cut travel should be counter clockwise for right hand machines.

The use of a ramp in program will help prevent bits from over heating. The ramp in program allows the bit to start cutting at a shallow depth increasing in depth until desired depth is reached. This helps minimize the heat build common with plunge routing.

For the dado cuts a two or three flute down spiral bit will produce clean edges. Depending on bit diameter, multiple passes may be needed to achieve the desired dado width. Using a narrower bit with multiple passes can save time in tool changes and allows for faster cuts due to smaller diameter bits. The same is true of the compression bits.

Carbide Or Diamond: These two saw blade tips are the only recommended products for cutting Duramine. Diamond typically offers much longer tool life than carbide.

Scoring: There are two different types of scoring saws that are used to prevent chip out on the bottom panels: conical and split. Scoring saws, as with the main cutting blade, are designed for specific equipment types and your end-product requirements. The best source to determine which type is correct for you is your tooling and equipment professional.

Important Suggestions For A Clean Cut

1. Use carbide-or diamond-tipped tools.
2. Use a scoring blade.
3. Use clean, well-aligned, and correctly-sharpened tools.
4. Make sure the main blade and scoring saw are perfectly aligned.
5. Make sure the collars are well-adjusted and clean.
6. Make sure the panel is held firmly in place—avoid vibrations.
7. Avoid a projection of the blade that is too high—a blade projection of about 12 mm or 1/2 inch is sufficient.
8. Handle cutting tools with the utmost care. Damaged tools will not give the best results and could be dangerous to use.
9. Replace cutting tools regularly to minimize chipping.
10. Consult with your supplier of cutting equipment and tools for answers to questions regarding the speed of cutting and feed, as well as cutting angle.
11. Ensure proper dust collections.
12. Ensure the blade and/or slide carriage is kept clean and travels smoothly.

See our Cutting Troubleshooting Guide on the next page.

For hole boring, use brad point bits.

With CNC routers, the work piece needs to be securely fastened to prevent movement or work piece vibration. Adequate vacuum should be applied to prevent piece movement or vibration.

Woodweb.com is a useful source of information for the CNC user.

http://www.woodweb.com/knowledge_base/Feed_rates_and_spindle_speeds.html

The short answer is chip load. $RPM \times \# \text{ flutes} \times \text{chip load} = \text{feed rate}$.

RPM depends on material, tool diameter, and tool geometry. # flutes depends on material, tool and material thickness. Chip load depends on tool geometry, desired finish, material, and sometimes, available power. Higher RPMs means more heat. Higher chip load means better heat sink effects. Higher chip loads may degrade finish, but too low a chip load leads to burning and short tool life.

Fastening Systems

Screws

The screw fastening systems designed especially for particleboard are the strongest. These fasteners have straight shanks with a smaller root diameter and wider-spaced threads than wood screws. Remember:

- Always predrill a pilot hole before inserting screws.
- The diameter of the pilot hole should be 85 to 90 percent of the diameter of the screw root diameter.
- Avoid overtightening.
- The screw holding increases more with length than with the root diameter.

RTA Fittings

Some systems, using threaded steel or nylon inserts, are designed for repeated screwing and unscrewing to provide ready-to-assemble (RTA) capability for case goods, store fixtures, furniture, and cabinetry products.

Edge Treatments

Duramine® panels can be edged with a wide variety of edge treatments including:

- PVC or ABS.
- Polyester or melamine for straight edge or soft-forming applications.
- Solid wood.
 - Veneer.
- High-pressure laminates (HPL).
 - Plastic and metal T-moldings.

Troubleshooting

Cutting and drilling problems: causes and possible remedies

Problem	Possible Cause	Possible Remedy
Edge chipping and burning	Saw blade type/design	A blade with a hollow, ground-tooth face burning with a negative rake or an alternate face and top bevel design will achieve best results on most standard saws (single blade) when cutting without a scoring blade.
	Machining of "hot" panels	Allow stacks to come to ambient temperature.
	Dull tooling	Check tooling setup, geometry of tooling, and machine feeding speed. Also check to make sure that tooling type is correct for material to be cut.
	Alignment of saw blades	Saw blade should be perfectly parallel to the direction of the cut. In most operations, it should be vertical to the panel surface.
	Trueness of blade rotation	Make sure blade is not warped or damaged in any way. Check for dirt or dust between blade and blade clamps.
	Cutting depth	Set the blade depth so that it comes through the panel by about 1/2 tooth to provide a low-approach angle and greater shearing action as the teeth enter the panel. Adjust to minimum chipping and maintain sawdust removal rate.
	Feed rate of saw	Check for appropriate blade diameter and design, number of teeth, and arbor RPM.
	Vibration of panel	Panel must be held solidly by clamping device or hold-down feed rolls. Blade dampers are recommended to reduce blade vibration. Throat plate must be tight to the blade.
Warpage full-size panels	Stack stringer/stickers are different thicknesses	Keep stringer thickness uniform.
	Panel stacks do not have stringer locations uniformly placed	Position stack stringers uniformly from panel bundle to panel bundle.
	Dissimilar humidity exposure between the faces of a panel in a stack	Using an appropriate technique, expose both panel surfaces to the same humidity.
	Bundles not stacked evenly on top of one another	Reposition bundles.
	Panels stored on edge	Store flat with 3-6 evenly-spaced stringers, depending on panel length.
Dimensional tolerance stability (camber banana cut, oil-canning)	Cutting hot board	Allow panels to condition to ambient temperature and humidity.
	Camber occurring	Replace tooling and reduce infeed speed. Cut narrower pieces from center of panels, wider pieces toward panel edges. Adjust the guide rail to be parallel with the saw blade.
	Saw blade pinches	Precondition panels. Adjust guide rail and push guide.
Fastening problems	Pilot hole too large	Drill pilot hole 90-100% of shank diameter.
	Incorrect fastener type	Avoid standard wood screws, increase flange to diameter ratio.
	Incorrect application of screw	Change fastener type.
Panel split	Screws too close to edge	Redesign 75 mm from corner if in edge; 25 mm from corner if in face. Do not use "factory edge" 1/2" trim all around.

Conscientious Stewards Of Our Environment.

These five words are the foundation for every action Roseburg takes in its interactions with the environment. The phrase means not just taking care of the lands, but making them better for future generations. Harvesting a tree is easy; studying how our harvest activity impacts everything around it and finding ways to improve upon the environment is more difficult.

We have been up to the task.

We are not only in the business of producing quality wood products, but also in the business of conserving and enhancing the wonderful natural resources that each of us enjoys. Visit any of our harvest sites, and you'll see these words in action.

While using tractors and skidders may often be the easiest and least expensive alternative for removing logs, we look at other, more environmentally-friendly harvesting options such as helicopter logging to protect the soils that grow our trees. Often, you'll find us placing large, woody debris in streams to enhance the fish spawning habitat, or replacing old culverts with larger, better-placed culverts to provide better fish passage.

Roseburg was among the first in the industry to set aside some of its own land in order to study and improve upon fish habitat. Several years ago, we began working with Oregon State University and other agencies on a company-owned area near the Hinkle Creek Watershed to gain current research on the effects of logging on fish. We are now lobbying other companies to replicate the study on their own lands.

Finally, it's important to note that we are a highly self-sufficient manufacturer. We now own more than 750,000 acres of timberland, which supply the majority of wood fiber we need to produce our products. The ability to rely on our own forests as our primary source of logs gives us the flexibility to match our resources to our product mix.

We take a great deal of pride in our partnership with the natural world. However, we don't go to all of this effort and expense simply because it makes us feel good; we do it because it's the right thing to do.

- We manage our natural resources in a responsible manner
- Our EWP products enable builders to use timber resources more efficiently
- We offer composite panels and plywood products that have no added urea formaldehyde when manufactured
- We have biomass cogeneration plants which use wood waste material from our mills to produce clean energy for our plants and nearby communities
- We produce a broad array of products that are FSC, SCS, and EPP certified
- California timberlands are third party certified for their sustainability by the Forest Stewardship Council (FSC)
- Integrated manufacturing facilities dramatically reduce vehicle carbon emissions
- We plant over 5 million tree seedlings annually
- We are progressively involved in stream research and enhancement



BUILD GREENER

With an industry leader
in Green Build products.

For over 70 years, Roseburg has been an industry leader in creating ways to use natural resources wisely. From the cogeneration plants that convert waste material into energy, which provides power for our manufacturing facilities, to the 5 million seedlings planted annually, Roseburg is committed to being a good steward of the environment.

Roseburg produces the broadest mix of "Green Build Wood Products".

EWP I-Joist

EWP LVL

Particleboard

Plywood Underlayment

Real Wood Siding

Concrete Forming Panel

Plywood Sheathing

Sanded Plywood

Hardwood Panels

Thermally Fused Melamine

Specialty Panels



ROSEBURG
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