

# Particleboard

## LEADING APPLICATIONS

- Countertops • Kitchen Cabinets • Shelving • Door Core
- Stair Treads • Floor Underlayment • Office & Residential Furniture • Store Fixtures • Manufactured Home Decking •



### HOW IT'S MADE

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.

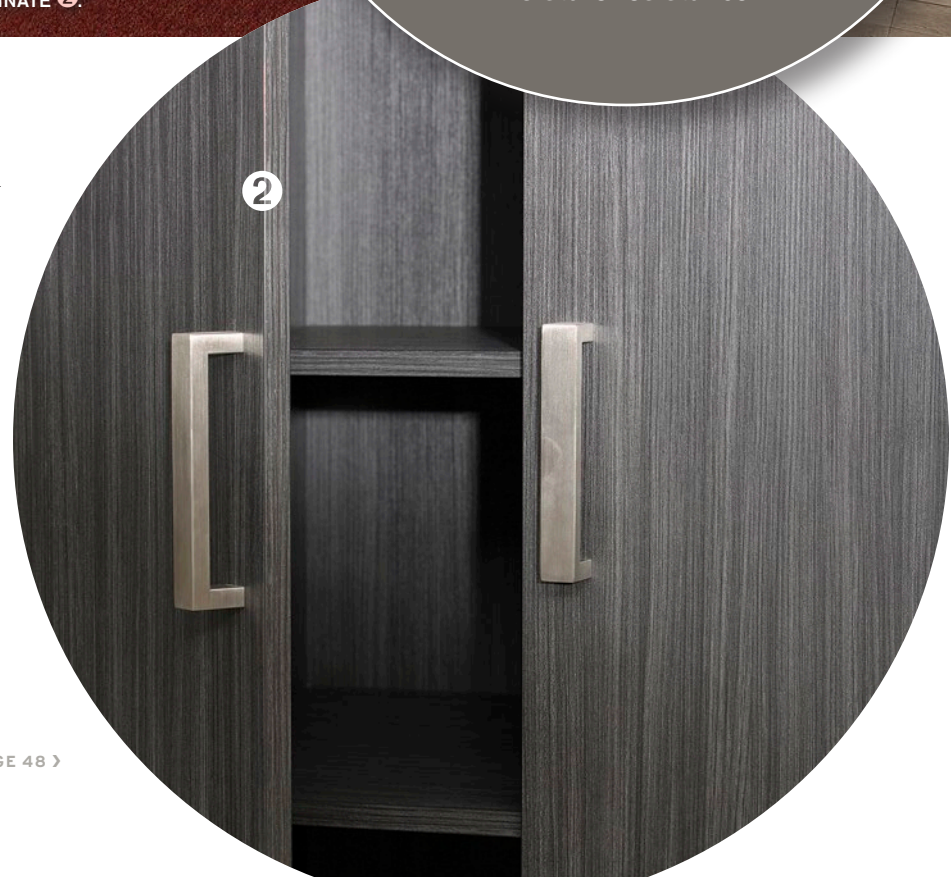
PARTICLEBOARD IS CONSISTENT, DURABLE AND PRODUCED TO PRECISE THICKNESSES IN A VARIETY OF PANEL SIZES. PARTICLEBOARD IS USED EXTENSIVELY IN RESIDENTIAL KITCHENS ①, PLAYING A ROLE IN COUNTERTOPS, CABINETS, SHELVING AND FLOOR UNDERLAYMENT. IT IS THE SUBSTRATE OF CHOICE FOR MANY SURFACE TREATMENTS, SUCH AS THERMALLY FUSED LAMINATE ②.

**T**oday'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, providing maximum design flexibility for specifiers and end users.

Particleboard is widely used in the manufacture of office and residential furniture, countertops, kitchen cabinets, shelving, store fixture, underlayment, door core and stair treads.

### PRODUCT STANDARDS, CERTIFICATION AND ENVIRONMENTAL SPECIFICATIONS

ANSI A208.1 Particleboard is the North American industry voluntary standard. It classifies particleboard by density and strength, and covers physical, dimensional and mechanical characteristics as well as formaldehyde emission levels. ANSI



PARTICLEBOARD CONTINUED ON PAGE 48 >



**Table A: REQUIREMENTS FOR GRADES OF PARTICLEBOARD**

Grade	Dimensional Tolerances			Physical and Mechanical Properties					
	Length & Width mm (inch)	Thickness Tolerance		Modulus of Rupture N/mm <sup>2</sup> (psi)	Modulus of Elasticity N/mm <sup>2</sup> (psi)	Internal Bond N/mm <sup>2</sup> (psi)	Screw-holding		Linear Expansion max. avg. percent
		Panel Average Thickness from Specified mm (inch)	Variance from Panel Average Thickness 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)	±0.125 (±0.005)	2.8 (406)	500 (72500)	0.10 (15)	360 (81)	NS	0.40
LD-2	±2.0 (±0.080)	-0.375 (-0.015) +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 Tolerance mm (inch)	Thickness Tolerance		Modulus of Rupture N/mm <sup>2</sup> (psi)	Modulus of Elasticity N/mm <sup>2</sup> (psi)	Internal Bond N/mm <sup>2</sup> (psi)	Hardness N (pounds)	Concentrated Loading N (pounds)	Thickness Swell		Linear Expansion max. avg. percent
		Panel Average from Specified mm (inch)	Variance from Panel Average mm (inch)						max. avg. mm (inch)	percent	
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 <sup>7</sup>	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	Length & Width mm (inch)	Thickness Tolerance		Modulus of Rupture N/mm <sup>2</sup> (psi)	Modulus of Elasticity N/mm <sup>2</sup> (psi)	Internal Bond N/mm <sup>2</sup> (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 (247)	1000 (225)	0.35

◀ CONTINUED FROM PAGE 46

A208.1 was developed through the sponsorship of the Composite Panel Association (CPA) in conjunction with producers, users and general interest groups. A summary of the Particleboard Property Requirements is included in this Guide and copies of ANSI A208.1 are available from CPA.

Third-party certification to ANSI 208.1 is required for many applications of composite panels. For example, 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.

Environmental Product Declarations (EPDs) are the widely accepted standardized specification format for communicating the environmental footprint and performance of a product. EPDs are the definitive source of environmental technical data that is scientifically based on life cycle

PARTICLEBOARD HAS EXCELLENT MACHINING CHARACTERISTICS, WHICH IS IMPORTANT WHEN POSTFORMING HIGH PRESSURE LAMINATE COUNTERTOPS.



◀ CONTINUED FROM PAGE 48

analysis and can be used to directly compare alternative product materials. An industry-wide EPD for North American particleboard is now available. See page 8 of this Guide for additional information.

**FORMALDEHYDE EMISSION LIMITS**

ANSI A208.1 allows for a maximum of 0.09 ppm emission level for particleboard. To meet the needs of the market, many particleboard manufacturers offer ultra-low emitting formaldehyde (ULEF) and no-added formaldehyde (NAF) products. Those companies currently producing ULEF and NAF products are identified in the product listings in this Guide.

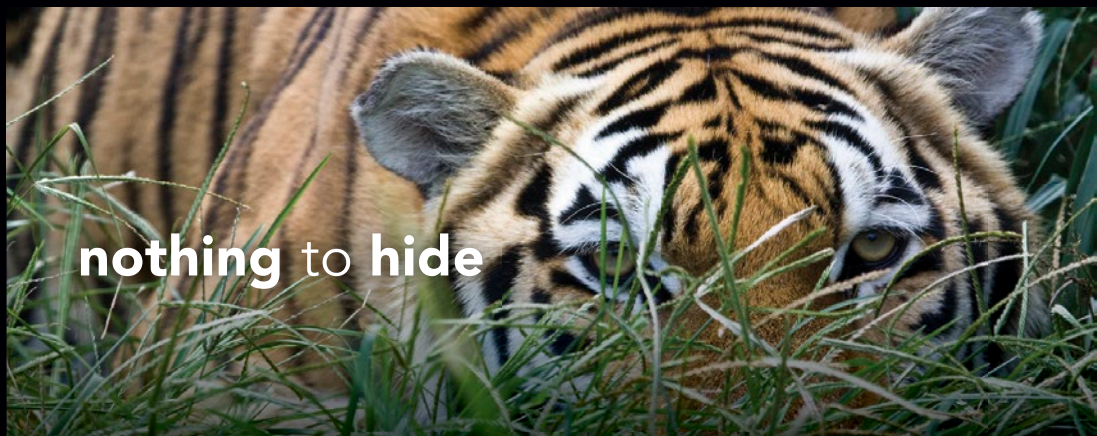
In addition, CPA's Eco-Certified Composite (ECC) Grademark Program (to which almost all of the North American producers subscribe) requires emission limits no higher than the California Air Resources Board Airborne Toxic Control Measure (CARB ATCM 93120) regulation, or not covered by CARB ATCM 93120 (e.g. hardboard). In the future, ECC will incorporate EPA TSCA Title VI emission requirements into the program.

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." ■



*Please see pages 98-99 for information about the companies that produce particleboard.*

ADVANCES IN PAPER, DÉCOR PRINTING AND RESIN TECHNOLOGY ALLOW FOR THE PRODUCTION OF TEXTURED THERMALLY FUSED LAMINATES ON PARTICLEBOARD ❶  
 ADDING HIGH FIDELITY DESIGN TO A STANDARD PARTICLEBOARD PANEL. PARTICLEBOARD IS MADE IN A WIDE RANGE OF PROPERTIES TO SUIT JUST ABOUT ANY PURPOSE. PARTICLEBOARD PLAYS A KEY ROLE IN CABINET MANUFACTURING PLANTS ❷



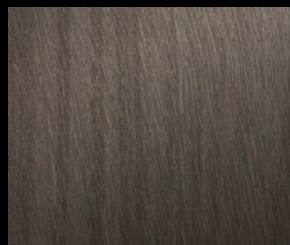
nothing to hide

a|lusion

The look and feel of natural wood grain in a composite panel.



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 complimentary samples  
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 (888) 358-5075



Fennec Fox



Vicuna



Nightengale



Walking Stick



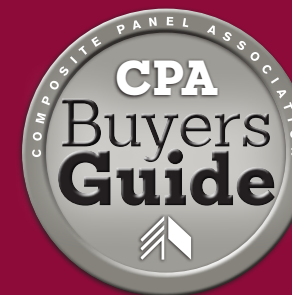
Maltese



Snowy Owl



# Particleboard



www.CompositePanel.org

COMPANY AND MILL LOCATION	BRAND NAMES	WOOD SPECIES	CERTIFIED WOOD	ECC CERTIFIED	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 <sup>3</sup> )
					ULEF / NAF (AS APPROVED BY CARB)*	M-0	M-1	M-S	M-2	M-31							
<b>ARAUCO NORTH AMERICA</b>																	
www.arauco-na.com • (800) 268-9830																	
Albany, Oregon	Duraflake®, Vesta, Vesta ULEF/NAF	Douglas Fir, Hemlock	FSC	•	•	•	•	•	•	•	•	•	C CS DC FR HD M MR S ST	4 x 24, 6 x 26	3/8 - 1-15/16	32 - 55	
Bennettsville, South Carolina	UltraPB®; Plus, Vesta ULEF, MR, Custom	Pine	FSC	•	•	•	•	•	•	•	•	•	C CS DC LD M MR S	10 x Continuous	9/32 - 1-3/4	30 - 46	
Moncure, North Carolina	UltraPB®; Plus, Custom	Pine	FSC	•	•	•	•	•	•	•	•	•	C CS DC LD M	9x24 multi-opening	3/8 - 1-1/2	30 - 48	
St. Stephen, New Brunswick	UltraPB®, DuraFR, Vesta ULEF	Spruce	FSC	•	•	•	•	•	•	•	•	•	B CS F FO FR LP M MN P PA PF PR T	(2) - 4' Continuous, 8 x 32	3.0mm - 1-1/8	42 - 47	
<b>BESTBOARD IMPULSORA S.A. DE C.V</b>																	
www.bestboard1.com • (619) 819-6064																	
Tijuana, Mexico	Best Board	Pine (Some Recycled)		•									C CS FO LP LD M MR P S V W	4 x 40	3/8 - 1-3/8	42 - 47	
<b>BOISE CASCADE COMPANY</b>																	
www.bc.com/manufacturing • (888) 264-7372																	
La Grande, Oregon	Boise Select®, Boise Evergreen™, Anchor™ Firewall FR®, Super Shelf®, Super Step®	Western Pine, Mixed Softwoods, Ponderosa Pine	SFI	•	•	•	•	•	•	•	•	•	BE C CS EF FR HD LD MR S ST	5 x 18, 4 x 24	3/8 - 1-1/4	39 - 50	
<b>COLLINS PRODUCTS LLC</b>																	
www.collinswood.com • (800) 547-1793																	
Klamath Falls, Oregon	Collins Pine Particleboard, Collins Pine FreeForm®, Collins Pine MR50	Western Pine	FSC	•	•	•	•	•	•	•	•	•	C CS HD MR S	5 x 24	3/8 - 1-1/4	40 - 50	
<b>DURAPLAY DE PARRAL, S.A.P.I. DE C.V.</b>																	
www.duraplay.com.mx • (505) 217-1700																	
Parral, Chihuahua	Duraplay, Ultraplay, Duramel, Duramel Sense, Duracore, Duralam	Pine		•		•		•	•	•			BE C CS EF ET FO LP M MN	8 x 48 Single Opening, MR PA S ST W	1/8 - 1-1/8 4' Mende	40 - 55	
<b>FLORIDA PLYWOODS, INC.</b>																	
www.flply.com • (850) 948-2211																	
Greenville, Florida		Southern Yellow Pine											BE CS LP PA S V W	5 x 12, 5 x 24	5/16 - 5/8	50	
<b>GEORGIA-PACIFIC WOOD PRODUCTS LLC</b>																	
www.buildgp.com • (800) 424-2311																	
Diboll, Texas	Temstock	Southern Pine	FSC	•	•	•	•	•	•	•	•	•	BE C CS EF HD LD MR S	4 x 24	1/4 - 1-7/16	41 - 52	
Hope, Arkansas	Temstock	Southern Pine	FSC	•	•	•	•	•	•	•	•	•	C DC LD MR	9 x 25	3/8 - 1-1/2	41 - 52	
Monroeville, Alabama	Temstock	Southern Pine	FSC	•	•	•	•	•	•	•	•	•	FR LD MR	4 x 24	1/4 - 1-7/16	41 - 52	
Thomson, Georgia	Temstock	Southern Pine	FSC	•	•	•	•	•	•	•	•	•	LD MR	4 x 24	3/8 - 1-1/4	41 - 52	
<b>MADERAS CONGLOMERADAS S.A. DE C.V.</b>																	
www.macosa.com.mx • +52 (55) 5715 5870																	
Tlalnepantla, Mexico	MACOPAN	Pine / Softwood											CS LP P PA PE W	8 x Continuous	4 x Continuous 1/12 - 5/16	46 - 49	
<b>MARSHFIELD DOORSYSTEMS, INC.</b>																	
www.customdoorcomponents.com • (800) 826-4020																	
Marshfield, Wisconsin	Uni-Cor ST, Uni-Cor ST Lite, Uni-Cor FR	Aspen, Basswood, Northern Hardwoods	FSC	•									CS DC SR FR LB LD	7 x 9	1-1/8 - 2-1/4	28 - 37	

**MASISA S.A. DE C.V.**

www.masisa.com • +52 (55) 91382300 Ext. 2608

Chihuahua, Chihuahua  
Durango, Mexico  
Zitacuaro, Michoacan

Ponderosa Pine & Mixed Softwood  
Mixed Pine  
Mixed Pine

FSC  
FSC

• • • • • • • •  
• • • • • • • •  
• • • • • • • •

BE C CS FO LP M S ST  
CS  
CS FO LP M

8 x Continuous  
8 x 48, 8 x 32  
8 x 20 Multi-Opening

3/8 - 1-1/8  
1/4 - 5/16  
3/8 - 1-1/8

40 - 50  
40 - 50  
40 - 50

**PANOLAM INDUSTRIES INTERNATIONAL, INC.**

www.panolam.com • (800) 672-6652

Huntsville, Ontario Panolam

Canadian Wood Mixture

• • • • • • • •

C LP M

5 x 18, 8 x Continuous

1/4 - 1-1/2

42 - 45

**PLUMMER FOREST PRODUCTS**

www.enstron.com • (208) 777-2202

Post Falls, Idaho EnStron, Enstron Underlayment, Enstron Underlayment Plus, Enstron Industrial Particleboard, Enstron FR, Enstron MR10, MR50, Enstron Door Core

Western Softwoods

FSC

• • • • • • • •

CS DC FR MR

4 x 8

1/4 - 1-1/8

28 - 48

**ROSEBURG**

www.Roseburg.com • (800) 245-1115

Dillard, Oregon UltraBlend™, SkyBlend™  
Missoula, Montana UltraBlend™, SkyBlend™  
Simsboro, Louisiana UltraBlend™  
Taylorsville, Mississippi UltraBlend™, SkyBlend™

Fir, Pine Blend  
Western Pine, White Fir  
Southern Pine  
Southern Pine

FSC  
FSC  
FSC  
FSC

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B BE C CS DC ET F FO HD LD  
M MR P PF PR S ST T W  
C CS ET HD LD LP M MR S ST  
C CS DC HD LD LP M  
BE C EF MR S

8x24  
5 x 24  
10 x continuous  
5 x 24

3/8 - 1-1/2  
7/16 - 1-1/2  
1/4 - 1-11/16  
1/2 - 1-1/4

30 - 55  
40 - 49  
34 - 50  
42 - 52

**TAFISA CANADA INC.**

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Lac-Megantic, Quebec Tafipan Evolo®  
Tafipan®

Spruce, Pine, Fir,  
Maple, Birch, Aspen

FSC  
FSC

• • • • • • • •  
• • • • • • • •

C LD M

9 x & 10 x Continuous

1/4 - 1-1/2

38 - 44

**TIMBER PRODUCTS COMPANY (COMPOSITE PANEL GROUP)**

www.timberproducts.com • (800) 547-9520 (800) 676-3339

Medford, Oregon GreenT™  
Martell, California Ampine™, Ampine FR™, Encore™, Encore™ FR, Encore™ MR, Encore™ MR50, APEX, APEX MR50, APEX FR

Fir, Pine  
Western Pine

FSC, SFI  
FSC

• • • • • • • •  
• • • • • • • •

CS DC FO LP LB M PA PF S V W  
BE C CS DC EF HD LD MR S

4 x 16  
5 x 24

3/8 - 1-3/4  
3/8 - 1-3/4

30 - 47  
32 - 55

**UNIBOARD**

www.uniboard.com • (800) 263-5240

Saybec, Quebec Uniboard PB, NU Green SOYA™, NU Green® 2  
Val-d'Or, Quebec Uniboard PB

Softwood, Hardwood  
Softwood, Hardwood

FSC  
FSC

• • • • • • • •  
• • • • • • • •

C DC LD LP M TS  
LD LP M

8 x 114, 10 x Continous  
8 x 20

1/4 - 1-3/4  
3/8 - 1-1/8

28 - 43  
36 - 43

**WEBB FURNITURE ENTERPRISES, INC.**

www.webbfurn.com • (276) 236-6141

Galax, Virginia Webb Particleboard

Pine

• • • • • • • •

C CS DC LB LD

5 x 12

7/16 - 1-1/2

30 - 48

**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), Thermally Fused Laminate (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)

\* Manufacturers approved by the California Air Resources Board (CARB) to produce composite wood products that meet the no-added formaldehyde (NAF) and/or ultra-low emitting formaldehyde (ULEF) requirements of CARB's ATCM 93120 (2008) will also meet those in EPA TSCA Title VI once in effect. See CompositePanel.org for the most current list of CARB-approved manufacturers.

# Sales INFORMATION 2017

Information about  
company products  
offered by category  
can be found on  
pages 96-109.

## AKZO NOBEL COATINGS, INC.

1431 Progress Avenue  
High Point, North Carolina 27260  
(336) 841-5111 Fax (336) 883-8494  
infowfaus@akzonobel.com  
www.akzonobel.com

• COATING MANUFACTURER

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www.americanlaminates.com

• LAMINATOR

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ST. STEPHEN AND SAULT STE. MARIE SALES  
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Markham, Ontario L3R 0G4  
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Albany, Oregon 97321  
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customer.service@arauco-na.com  
www.arauco-na.com

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• PARTICLEBOARD MANUFACTURER  
• LAMINATOR  
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info.decorative@arclin.com  
www.arclinTFL.com

• OVERLAY MANUFACTURER

## BESTBOARD IMPULSORA S.A. DE C.V.

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Chula Vista, California 91912-5224  
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araymond@bestboard1.com  
www.bestboard1.com

• PARTICLEBOARD MANUFACTURER  
• LAMINATOR

## BOISE CASCADE COMPANY

P.O. Box 62, Boise, Idaho 83707  
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twparticleboardsales@bc.com  
www.bc.com/manufacturing

• PARTICLEBOARD MANUFACTURER

## COLLINS PRODUCTS LLC

6410 Highway 66  
Klamath Falls, Oregon 97601  
www.collinswood.com

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(800) 547-1793 Fax (541) 882-8671  
mshuey@collinsco.com  
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(800) 417-3674 Fax (541) 884-7282  
lworthington@collinsco.com (EWST)

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info@confalonierispa.it  
www.confalonierispa.it

• OVERLAY MANUFACTURER

## DEL-TIN FIBER, LLC

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El Dorado, Arkansas 71730  
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mikehopkins@deltinfiber.com  
www.deltinfiber.com

• MDF MANUFACTURER

## DKB DECOR, INC.

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www.melamine-papers.com

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Fax +52 (627) 523-9817  
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wayneschwerin@duraplay.com.mx  
www.duraplay.com.mx

• PARTICLEBOARD MANUFACTURER  
• LAMINATOR

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sales@dvuv.com  
www.dvuv.com

• COATER

## EXPERA SPECIALTY SOLUTIONS, LLC.

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info@expera.com  
www.expera.com

• OVERLAY MANUFACTURER

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www.flply.com

• PARTICLEBOARD MANUFACTURER  
• LAMINATOR

## FORMICA CORPORATION

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bryce.hartman@formica.com  
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