PRODUCT DESCRIPTION

Roseburg Melamine decorative panels consist of melamine resin saturated decorative papers, thermally fused under heat and pressure to a substrate of Roseburg UltraBlend particleboard, Roseburg Pine particleboard, or MDF (medium density fiberboard). The Thermally Fused Melamine (TFM) process permanently bonds the paper and the board; there is NO GLUE LINE to delaminate. The panels resists warping, bowing, scratches, stains, heat, steam, burnishing, abrasion, chip-out and damage due to excessive wear. Roseburg Melamine Decorative Panels perform like high pressure laminate at a fraction of the cost.

PANEL FACE

Hundreds of solid, pattern and woodgrain designs are available from Coveright, Dynea, Wilsonart, Tafisa and other sources that match high pressure laminates and rigid thermo foils.

PANEL BACKS

Panels are available with decorative faces two sides or with a white or brown melamine saturated balancing backer sheet. A glueable backer is available for panels which will subsequently be laminated with high pressure laminates or other materials.

PANEL FINISH

Roseburg melamine panels are available with either "S"- Matte finish for a low gloss textured appearance, or "Z" – Satin finish, for a textured furniture grade appearance.

THE BOARD MATTERS

Roseburg Forest Products has the distinct advantage of manufacturing our own particleboard specifically engineered for our Roseburg Melamine decorative panels. This unique vertical integration allows for complete quality control and gives us the ability to produce a substrate that meets our customers' performance and price expectations.

- UltraBlend™ - a proven and trusted blend of Western softwoods, providing the strength and stability of fir, with the machinability of pine for industrial applications.
- Roseburg Pine - a high quality particleboard panel with ultimate machinability for industrial applications.
- Medium Density Fiberboard (MDF) - Roseburg Melamine is also available on many of the West's highest quality MDF cores.

APPLICATIONS

RESIDENTIAL

- Kitchen and Bath Cabinets
- Home Office Furniture
- Ready-to-Assemble Furniture
- Closet and Garage Organization Systems
- Entertainment Centers

COMMERCIAL

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

INSTITUTIONAL

- Hotel and Motel Furniture
- Educational Furniture
- Restaurant Furniture
- Hospital and Medical Casegoods
- Institutional Interiors and Casegoods
- Wall Coverings and Partitions

HOW TO SPECIFY

Product: Roseburg Thermally Fused Melamine Panels
Color name: _____ Color Ref. #: _____
Finish: "S"- Matte or "Z"- Satin
Substrate type: UltraBlend™, Roseburg Pine particleboard or Medium Density Fiberboard (MDF)
Width: _____ Length: _____ Thickness: _____

MELAMINE MINI-PAK PROGRAM

A special selection of Melamine woodgrains can be ordered in convenient mini-units. The Roseburg Melamine Mini-Pak program is perfect for introduction of new unique melamine designs to the market.

- CONVENIENT PACKAGING - 10 piece units, individually strapped for easy handling
- THICKNESS/SIZES - 1/4" MDF (finished 1 side, with #11 white back), and 3/4" particleboard (finished 2 sides) in 49"x97" panels
- WIDE SELECTION - 16 Popular Roseburg Melamine designs
- AVAILABILITY - Many distributors stock our designs or can add Mini-Paks to their mill orders with normal lead times.

Look for the **x** next to color samples in this brochure for designs available in Mini-Paks.

CONSCIENTIOUS STEWARDS OF THE ENVIRONMENT

Roseburg Pine is an Environmentally Preferable Product (EPP). EPP-certified products contain 100% recycled and recovered wood waste or fiber generated from wood residue including sawdust and shavings.

Environmentally Preferable Product

Roseburg has Scientific Certification Systems (SCS), a neutral third party environmental testing and certification organization, audit our manufacturing process that verifies our UltraBlend™ and Roseburg Pine particleboard is produced from recycled/recovered wood fiber.

Scientific Certification Systems

PREPARATORY WORK

STORAGE & HANDLING

Prior to fabrication, Roseburg Melamine panels should be stored off the floor, on a sufficient number of evenly spaced stringers/stickers of equal thickness, and allowed to acclimate 48 to 72 hours. Optimum storage conditions are temperatures between 60 degrees and 90 degrees F (15-30 degrees cc) with a relative humidity of 40-60%.

Roseburg Melamine may be affected by severe climatic changes that cause the relative humidity to vary and can result in warping, swelling, or shrinking. Unbanding the units and allowing the panels to acclimate inside the shop for a minimum of 72 hours before fabricating will minimize the effect.

Panels should always be stored horizontally to prevent warpage and edge damage. Proper support is important to maintain flatness. Avoid unnecessary flexing of the panels when lifting by transport machinery.

MACHINING

Roseburg Melamine can be machined as effectively as solid woods, if proper machining techniques are applied. Roseburg recommends consulting both your tooling and machine manufacturers, to ensure proper equipment is used to fabricate Roseburg Melamine.

Other key factors, such as tool design, speed, material feed rate, and quality of cutting equipment are important to successfully fabricate melamine. A good tool maintenance program is critical for controlling the quality and consistency of the cut.

TOOLING

Carbide or diamond-tipped cutting tools are recommended for fabricating Roseburg Melamine.

Carbide-tipped: The most common way to machine melamine is with a carbide-tipped tool, employing tungsten carbide and modified grades of tungsten carbide in its makeup. It is recommended that you work closely with the supplier to ensure the grade of carbide is hard enough to provide a good consistent cut.

Diamond-tipped: Diamond tipped cutting tools can also be used to fabricate melamine. Diamond tools can be up to 125 times more wear-resistant than tungsten carbide. They are often used when runs of mass-produced parts with intricate detail are being fabricated. They tend to have a longer life cycle between sharpening, allow for faster speeds, maintain original contour, and can provide a finer, smoother finish than carbide tools. *(Caution: Diamond tools can be more brittle than carbide. The tool manufacturer should be consulted to ensure the best product is used to meet fabricating specifications.)*

PANEL SAW: The most important piece of machinery required to fabricate melamine is a high quality panel saw with a scoring blade. All sawing machines must be checked often to be certain they are in alignment. The ways must be straight and true, the carriage tight, and the scoring blade and through saw perfectly aligned with each other. The through blade needs to run straight and not heel, bearings tight, throat place in good condition, and the work hold-downs applying proper pressure on the melamine. The sawblades must be ground accurately and truly.

ROUTING & SHAPING: The selection of fabricating process will be dependent upon the cutting detail desired and volume of the production requirements. Carbide-tipped router bits and shaper cutterhead knives perform the best on Roseburg Melamine. Because cutting details for the wide range of finished products can vary greatly, it is impossible to make recommendations for every application. It is recommended that you work closely with the tooling supplier to select the right tool for your application.

SAWBLADE

Because there are so many uses for Roseburg Melamine, it is difficult to set specific guidelines that satisfy every cutting requirement. There are two basic forms of sawtooth configurations-the flattop tooth and the alternate-top-bevel tooth. All other sawtooth design are modified versions of these basic forms. For the best possible cut, the sawblade should have 80 teeth or more, an alternate-top-bevel teeth of 10 degrees, positive hook of 15 degrees and side clearance of 7 degrees. To improve the smoothness of the cut, you can increase RPM and/or rim speed, decrease feed speed, and use a greater tooth approach (blade just slightly projecting through the surface of the melamine). In all fabricating instances, avoid poor hold downs, loose nuts, worn bearings, sleeves or throat plates. Always maintain clean collars, a smooth "runout" (no wobble), and sharp, properly ground teeth. Another factor to consider is the thickness of the sawblade.

SAWING

The sawblade design and high quality equipment are the basic requirements needed to achieve successful fabrication. There are three angles from which the sawblade should cut melamine: clearance angle, hook or rake angle, and approach angle.

JOINING & FASTENING

Panels may be joined with the most common woodworking joints. These include dowels, wafers, camber locks, and screw fastening systems especially designed for melamine.

EDGE TREATMENTS

Roseburg Melamine can be edged with a variety of treatments such as polyvinyl chloride (PVC), polyester, solid wood or veneer, soft formed melamine, or high pressure laminates. Plastic and metal T-molding can also be used as edgebanding materials.

MAINTENANCE & REPAIRING

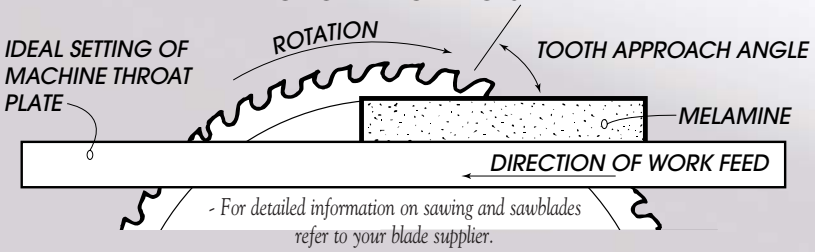
Panels can be easily cleaned with warm water and mild soaps. Do not use cleaners containing abrasives, acids, or alkalis. Oversprays and adhesives are easily removed with solvents recommended for such use.

Damaged or chipped melamine panels can be repaired in the same manner as a high-pressure laminate. Plastic seam fillers can be purchased to match the proper color and are easy to apply. Contact your local Roseburg Melamine distributor as a source for this product.

FABRICATION STANDARDS

Cabinets constructed with thermally fused melamine will conform to relevant sections of standards set by Kitchen Cabinet Manufacturers Association (KCMA) (ANSI A161.1-1990), Woodworking Institute(WI), Standards for exposed and semi-exposed surfaces of cabinet bodies.

MELAMINE APPROACH ANGLE TO SAWBLADE



- For detailed information on sawing and sawblades refer to your blade supplier.

RECOMMENDED SAWBLADE SPEED:

Size	Speed (RPM)
8"	3,600
10"	3,600
12"	3,600
14"	3,800
16"	3,800

PRODUCT PERFORMANCE

Roseburg Melamine panels are highly resistant to: scratching, stains, abrasion, edge chip-out, burnishing, steam, radiant heat, impacts, scuffs,moisture, and light.

SURFACE PROPERTIES

TESTS FOR RESISTANCE TO:	TEST DESCRIPTION[2]	ROSEBURG MELAMINE		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	125-175 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 be cleaned following prolonged contact with 15 soiling agents, using a sponge-scrubbing device	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[3]	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	No effect	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 Melamine 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.

PERFORMANCE STANDARDS

Roseburg's thermally fused melamine panel typically meets or exceeds performance standards set by:

- NEMA LD3 2000-VGL (National Electrical Manufacturers Association) Standards.
- Woodwork Institute (WI) for premium, custom, or economy cabinets for exposed or semi-exposed surfaces.

CUSTOMER & TECHNICAL SERVICES

Roseburg Forest Product's skilled and knowledgeable sales team is highly trained to work with each customer to meet their specific product and service requirements. Located at our largest manufacturing complex in Dillard, Oregon, they provide sales assistance, product information, order processing, scheduling and transportation services.

In addition, Territory Sales Managers (TSMs) are strategically located to serve customers throughout the United States and Canada. These trained professionals provide sales assistance, product and technical support. The TSMs work closely with their customer's sales, purchasing, manufacturing and engineering personnel to assure that Roseburg satisfies their needs.

ROSEBURG MELAMINE & ROSEBURG "ULTRACOLOR" DISTRIBUTORS

Roseburg Melamine is available at over 50 of the country's most respected distributors. Our "UltraColor" distributors stock from 20 to 60 Roseburg Melamine designs On-the-Floor for immediate availability. Call your Roseburg Territory Sales Manager or find your local distributor at www.rfpco.com.

ROSEBURG MELAMINE LITERATURE, SAMPLES & ADDITIONAL INFORMATION

- Contact your local Roseburg Melamine distributor.
- Contact your local Roseburg Territory Sales Manager or Inside Salesperson at 800-245-1115.
- Contact www.rfpco.com - One of the industries most comprehensive wood product websites. Look under "Specialty Panels" - Roseburg Melamine for complete information including, product offering, specificaitons, new updates and a complete list of your local distributor contacts.