



Duraflake® industrial particleboard is a premium interior, non-structural panel produced with three-layer technology. This process provides exceptionally smooth faces to facilitate a myriad of finishes from thin laminate and foil to paint or print. Duraflake® particleboard is available in a range of grades engineered for a wide variety of applications.

## Duraflake® Particleboard Specifications (Albany, OR)

PRODUCT DESCRIPTIONS	FEATURES AND BENEFITS
<p><i>Duraflake® particleboard</i> is our panel designed for most industrial end uses, including cabinets, fixtures and furniture components. It is an ideal substrate for overlays including melamine, thin papers, wood veneer and high pressure laminates, and a lower cost option when higher properties are not required.</p> <p><i>Duraflake® Plus particleboard</i> is our enhanced property panel designed to meet M-3 grade specifications when required. Duraflake Plus is highly touted for office furniture applications and many other industrial uses when additional properties are required.</p> <p><i>Duraflake® High Density particleboard</i> is available for those customers with exceptional panel milling and shaping demands.</p> <p><i>Duraflake® FR particleboard</i> is a UL® approved Class A/Class 1-rated fire retardant particleboard for commercial and institutional cabinets, paneling and casework when required by fire safety codes and architectural specifications.</p> <p><i>Duraflake® MR particleboard</i> is an interior moisture-resistant particleboard that is ideal for applications with high humidity and incidental moisture, such as kitchen, bath and laboratory cabinetry.</p> <p><i>Duraflake® Underlayment</i> is a favorite of many home-builders, remodelers, and individuals with do-it-yourself projects where smoothness, uniformity and strength are essential.</p> <p><i>Duraflake® Stair Tread</i> meet FHA/HUD standards, are bullnosed with a tight edge and are available in various lengths.</p> <p><i>Duraflake® Edge Filled Shelving</i> has a bullnose or square edge that is ready for finishing.</p>	<p><i>Smooth Finishing Surface</i> Our multi-layered panel has fine particle distribution on the face layers, which results in a smooth surface for laminating and finishing.</p> <p><i>Strength and Dimensional Stability</i> Duraflake® particleboard is manufactured primarily from Douglas fir, a wood with proven dimensional stability, low linear expansion, and low thickness swell. The multi-layer panel construction enhances the strength and stability of the finished product.</p> <p><i>Low Tool Wear and Excellent Workability</i> Carefully controlled manufacturing processes and a well balanced surface-to-core construction result in an easy-to-handle panel with competitive tool wear, providing excellent results when sawing and routing.</p> <p><i>Wide Range of Products and Sizes</i> A single source for industrial, commercial, residential, and architecturally specified high-quality engineered panel products and cut-to-size components.</p> <div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div data-bbox="914 1604 1036 1776" style="text-align: center;">  <p>COMPOSITE PANEL ASSOCIATION</p> </div> <div data-bbox="1110 1587 1276 1797" style="text-align: center;">  <p>ENVIRONMENTALLY PREFERABLE PRODUCT CPA 2-06 Specification AVAILABLE UPON REQUEST</p> </div> <div data-bbox="1341 1587 1468 1776" style="text-align: center;">  <p>ENGINEERED WOOD</p> </div> </div> <ul style="list-style-type: none"> <li>• Contains 100% Recycled/Recovered Wood Content</li> <li>• Conforms to both ANSI A208.1 Table A* and HUD 24 CFR Part 3280 Formaldehyde Emission Requirements for Particleboard</li> </ul> <p><small>* Duraflake Underlayment conforms to ANSI A208.1 Table B and HUD 24 CFR Part 3280.</small></p> <p><small>* Duraflake FR conforms to HUD 24 CFR part 3280 formaldehyde emission requirements for particleboard</small></p>

# Duraflake® Specifications (Albany, OR)

## APPLICATIONS

- Agricultural Box Ends
- Interior Signage
- Toys, Games, and Sporting Goods
- Elevator Cabs
- Passenger Boarding Bridges
- Architectural Woodwork
- Wainscoting
- Display Panels
- Door Components
- Furniture
- Fixtures
- Commercial Case Goods
- Shelving
- Cabinets
- Countertops

## STORAGE, HANDLING AND INSTALLATION

Duraflake® particleboard should never be stored or used outdoors. The indoor storage area should be clean, dry, well-ventilated, and free of dust, dirt or particles that could

contaminate the particleboard. Store flat on stickers on a level, hard, dry surface. Constant relative humidity and temperature should be maintained. Before use, allow to stabilize to the same conditions as are expected after the panel is installed. Condition 48 to 72 hours prior to lamination. For more information, see *Composite Panel Association Technical Bulletin: Storage and Handling of Particleboard and MDF*.

As with any building project, always wear proper eye, ear and breathing protection and follow local building codes.

Joints between panels to be designed to accommodate movement as per the linear expansion percentage of the specific Duraflake® product; for example, up to .40% movement for Duraflake® FR. Splined or articulated joints for reveals per AWI Section 500, 500A-G-4 “Joints and Transitions” or similar is suggested.

Grade	Duraflake® FR		Duraflake® MR	Duraflake® High Density Particleboard	Duraflake®
	Thickness (in) <sup>1</sup>	<sup>3</sup> / <sub>8</sub> - <sup>3</sup> / <sub>4</sub>	<sup>13</sup> / <sub>16</sub> - 1 <sup>1</sup> / <sub>2</sub>	<sup>3</sup> / <sub>8</sub> - 1 <sup>1</sup> / <sub>8</sub>	<sup>3</sup> / <sub>8</sub> - 1 <sup>1</sup> / <sub>8</sub>
Specification	Class A Class I	Class A Class I	ANSI M-3	ANSI H-2	ANSI M-S
Density (pcf)	47-50	44-47	50-53	53-55	43-46
MOR (psi)	1,600	1,600	3,200	3,000	1,850
MOE (psi)	300	250	500	450	350
Internal Bond (psi)	80	60	150	130	60
Face Screw Hold (lb)	250	250	450	425	200
Edge Screw Hold (lb)	225	175	350	350	175
Linear Expansion (%)	0.40	0.35	0.20	0.35	0.35
Thickness Tolerance (in)	+/- .005	+/- .005	+/- .005	+/- .005	+/- .005
Length and Width (in)	+/- <sup>1</sup> / <sub>16</sub>	+/- <sup>1</sup> / <sub>16</sub>	+/- <sup>1</sup> / <sub>16</sub>	+/- <sup>1</sup> / <sub>16</sub>	+/- <sup>1</sup> / <sub>16</sub>
Squareness (in)	+/- <sup>1</sup> / <sub>8</sub>	+/- <sup>1</sup> / <sub>8</sub>	+/- <sup>1</sup> / <sub>8</sub>	+/- <sup>1</sup> / <sub>8</sub>	+/- <sup>1</sup> / <sub>8</sub>
Hardness (lb)	N/A	N/A	500	1,000	500
Grade	Duraflake® Plus			Duraflake® Underlayment	
	Thickness (in) <sup>1</sup>	<sup>1</sup> / <sub>4</sub> - <sup>3</sup> / <sub>4</sub>	<sup>13</sup> / <sub>16</sub> - 1 <sup>3</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>4</sub> - 1 <sup>3</sup> / <sub>4</sub>	<sup>3</sup> / <sub>8</sub> - <sup>3</sup> / <sub>4</sub>
Specification	ANSI M-3	ANSI M-3	ANSI M-2	ANSI PBU	
Density (lb/cu ft)	45	44	40	40	
MOR (psi)	2,400	2,400	2,100	1,600	
MOE (1,000 psi)	400	400	325	250	
Internal Bond (psi)	100	80	65	60	
Face Screw Hold (lb)	250	250	225	N/A	
Edge Screw Hold (lb)	225	225	200	N/A	
Linear Expansion (%)	0.35	0.35	0.35	0.35	
Thickness Tolerance (in)	+/- .005	+/- .005	+/- .005	+/- .005	
Length and Width (in)	+/- <sup>1</sup> / <sub>16</sub>	+/- <sup>1</sup> / <sub>16</sub>	+/- <sup>1</sup> / <sub>16</sub>	+/- <sup>1</sup> / <sub>16</sub>	
Squareness (in)	+/- <sup>1</sup> / <sub>8</sub>	+/- <sup>1</sup> / <sub>8</sub>	+/- <sup>1</sup> / <sub>8</sub>	+/- <sup>1</sup> / <sub>8</sub>	
Hardness (lb)	500	500	500	500	

1. Metric thickness available.

The above properties are based on averages of normal production. Testing for conformance to the above specifications must be done in accordance with procedures in the American National Standard for Particleboard (ANSI A208.1-1999).