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, 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

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**LEADING APPLICATIONS**

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

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**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.
### Table A: Requirements for Grades of Particleboard

<table>
<thead>
<tr>
<th>Grade</th>
<th>Dimensional Tolerances</th>
<th>Physical and Mechanical Properties</th>
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<tbody>
<tr>
<td></td>
<td>Length &amp; Width Tolerance (mm inch)</td>
<td>Thickness Tolerance</td>
</tr>
<tr>
<td></td>
<td>Panel Average Thickness from Specified mm (inch)</td>
<td>Variance from Panel Average Thickness mm (inch)</td>
</tr>
<tr>
<td>H-1</td>
<td>±2.0 (±0.080)</td>
<td>±0.200 (±0.008)</td>
</tr>
<tr>
<td>H-2</td>
<td>±2.0 (±0.080)</td>
<td>±0.200 (±0.008)</td>
</tr>
<tr>
<td>H-3</td>
<td>±2.0 (±0.080)</td>
<td>±0.200 (±0.008)</td>
</tr>
<tr>
<td>M-0</td>
<td>±2.0 (±0.080)</td>
<td>±0.200 (±0.008)</td>
</tr>
<tr>
<td>M-1</td>
<td>±2.0 (±0.080)</td>
<td>±0.200 (±0.008)</td>
</tr>
<tr>
<td>M-S</td>
<td>±2.0 (±0.080)</td>
<td>±0.200 (±0.008)</td>
</tr>
<tr>
<td>M-2</td>
<td>±2.0 (±0.080)</td>
<td>±0.200 (±0.008)</td>
</tr>
<tr>
<td>M-3i</td>
<td>±2.0 (±0.080)</td>
<td>±0.200 (±0.008)</td>
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<tr>
<td>LD-1</td>
<td>±2.0 (±0.080)</td>
<td>+0.125 (+0.005)</td>
</tr>
<tr>
<td>LD-2</td>
<td>±2.0 (±0.080)</td>
<td>-0.375 (-0.015)</td>
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### Table B: Requirements for Particleboard Flooring Products and Building Code Grades

<table>
<thead>
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<th>Grade</th>
<th>Dimensional Tolerances</th>
<th>Physical and Mechanical Properties</th>
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<td></td>
<td>Length &amp; Width Tolerance (mm inch)</td>
<td>Thickness Tolerance</td>
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<tr>
<td></td>
<td>Panel Average Thickness from Specified mm (inch)</td>
<td>Variance from Panel Average Thickness mm (inch)</td>
</tr>
<tr>
<td>PBU</td>
<td>+0 (+0)</td>
<td>±0.375 (±0.015)</td>
</tr>
<tr>
<td>D-2</td>
<td>±2.0 (±0.080)</td>
<td>±0.375 (±0.015)</td>
</tr>
<tr>
<td>D-3</td>
<td>±2.0 (±0.080)</td>
<td>±0.375 (±0.015)</td>
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<tr>
<td>M-3</td>
<td>±2.0 (±0.080)</td>
<td>±0.200 (±0.008)</td>
</tr>
</tbody>
</table>

**Ring Particleboard has excellent machining characteristics, which is important when postforming high pressure laminate countertops.**

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...
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.”

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**CONTINUED FROM PAGE 48**

ADVANCES IN PAPER, DECOR PRINTING AND RESIN TECHNOLOGY ALLOW FOR THE PRODUCTION OF TEXTURED THERMALLY FUSED LAMINATES ON PARTICLEBOARD. 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.

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

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nothing to hide

allusion

Fennec Fox

Vicuna

Nightengale

Walking Stick

Maltese

Snowy Owl
<table>
<thead>
<tr>
<th>COMPANY AND MILL LOCATION</th>
<th>BRAND NAMES</th>
<th>WOOD SPECIES</th>
<th>CERTIFIED WOOD</th>
<th>PRESS SIZE (FT.)</th>
<th>THICKNESS RANGE (IN.)</th>
<th>DENSITY RANGE (LBS/FT²)</th>
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<tr>
<td>ARAUCO NORTH AMERICA</td>
<td>Durablaze®, Vesta, Vesta ULEF/NAF</td>
<td>Douglas Fir, Hemlock</td>
<td>FSC</td>
<td>C, DC, FR, HD, M, MR</td>
<td>4 x 24, 6 x 26</td>
<td>3/8 - 1-1/2</td>
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<tr>
<td>Bennettsvile, South Carolina</td>
<td>UltraPB®, Plus, Vesta ULEF, MR, Custom</td>
<td>Pine</td>
<td>FSC</td>
<td>C, DC, LD, M, MR</td>
<td>10 x Continuous</td>
<td>9/32 - 1-1/4</td>
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<td>St. Stephen, New Brunswick</td>
<td>UltraPB®, Vesta ULEF</td>
<td>Spruce</td>
<td>FSC</td>
<td>B, CS, FO, FR, LP, M, MN, PA, PF, PR</td>
<td>2x - 4' Continuous, 8 x 32</td>
<td>3.0mm - 1-1/8</td>
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<tr>
<td>BESTBOARD IMPULSORA S.A. DE C.V.</td>
<td>Pine (Some Recycled)</td>
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<td></td>
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<td>FLORIDA PLYWOODS, INC.</td>
<td>Southern Yellow Pine</td>
<td></td>
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<td>BE, CS, LP, PA, S, V, W</td>
<td>5 x 12, 5 x 24</td>
<td>5/16 - 5/8</td>
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<td>GEORGIA-PACIFIC WOOD PRODUCTS LLC</td>
<td>Temstock</td>
<td>Southern Pine</td>
<td>FSC</td>
<td>BE, CS, EF, HD, LD, MR, M, S</td>
<td>4 x 24</td>
<td>1/4 - 1-1/6</td>
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<td>Hope, Arkansas</td>
<td>Temstock</td>
<td>Southern Pine</td>
<td>FSC</td>
<td>C, DC, LD, MR</td>
<td>9 x 25</td>
<td>3/8 - 1-1/2</td>
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<td>Diboll, Texas</td>
<td>Temstock</td>
<td>Southern Pine</td>
<td>FSC</td>
<td>FR, LD, MR</td>
<td>4 x 24</td>
<td>1/4 - 1-1/6</td>
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<td>Thomson, Georgia</td>
<td>Temstock</td>
<td>Southern Pine</td>
<td>FSC</td>
<td>LD, MR</td>
<td>4 x 24</td>
<td>3/8 - 1-1/4</td>
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<tr>
<td>MADERAS CONGLOMERADAS S.A. DE C.V.</td>
<td>Pine / Softwood</td>
<td></td>
<td></td>
<td>CS, LP, P, PA, PE, W</td>
<td>8 x Continuous</td>
<td>1/16 - 5/16</td>
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<tr>
<td>Tlalnepantla, Mexico</td>
<td>MACOPAN</td>
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<tr>
<td>MARSHFIELD DOORSYSTEMS, INC.</td>
<td>Uni-Cor ST, Uni-Cor ST Lite, Uni-Cor FR</td>
<td>Aspen, Basswood, Northern Hardwoods</td>
<td>FSC</td>
<td>CS, DC, SR, FR, LB, LD</td>
<td>7 x 9</td>
<td>1-1/8 - 2-1/4</td>
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<td>COMPANY</td>
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<td>COMPANY PRODUCTS</td>
<td>SPECIES</td>
<td>TREATMENTS</td>
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<td></td>
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<td></td>
<td>Bennettsville, South Carolina</td>
<td>UltraPB®, Plus, Vesta ULEF, MR, Custom Pine</td>
<td>FSC</td>
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<td></td>
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<td></td>
<td>St. Stephen, New Brunswick</td>
<td>UltraPB®, DuraFR, Vesta ULEF</td>
<td>Spruce</td>
<td>FSC</td>
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<tr>
<td><strong>B E S T  B O A R D  1  C O M P A N Y</strong></td>
<td><a href="http://www.bestboard1.com">www.bestboard1.com</a>  •   (619) 819-6064</td>
<td></td>
<td>Tijuana, Mexico</td>
<td>Pine (Some Recycled)</td>
<td></td>
<td></td>
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<tr>
<td><strong>B O I S  B C</strong></td>
<td><a href="http://www.bc.com/manufacturing">www.bc.com/manufacturing</a>  •   (888) 264-7372</td>
<td></td>
<td>La Grande, Oregon</td>
<td>Boise Select®, Boise Evergreen™, Anchor™ Western Pine</td>
<td>FSC</td>
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<td>Klamath Falls, Oregon</td>
<td>Collins Pine Particleboard</td>
<td>Western Pine</td>
<td>FSC</td>
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<td>Durango, Mexico</td>
<td>Duramel Sense, Duracore, Duralam</td>
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<td><strong>F L O R I D A  P L Y W O O D S ,  I N C .</strong></td>
<td><a href="http://www.flply.com">www.flply.com</a>  •  (850) 948-2211</td>
<td></td>
<td>Greenville, Florida</td>
<td>Southern Yellow Pine</td>
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<td>Plummer, Idaho</td>
<td>Western Softwoods</td>
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<td>Houghton, Michigan</td>
<td>Southern Pine</td>
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<td><strong>T A F I S A  C A N A D A  I N C .</strong></td>
<td><a href="http://www.tafisa.ca">www.tafisa.ca</a>  •  (888) 882-3472</td>
<td></td>
<td>Lac-Mégantic, Quebec</td>
<td>Tafipan® Evolo®, Tafipan®</td>
<td>Spruce, Pine, Fir, Maple, Birch, Aspen</td>
<td>FSC</td>
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<td>Hermosillo, Sonora</td>
<td>Western Pine, White Fir</td>
<td>FSC</td>
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<td>FSC</td>
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<td>La Conner, Washington</td>
<td>Western Pine, White Fir</td>
<td>FSC</td>
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<tr>
<td><strong>U N I B O A R D</strong></td>
<td><a href="http://www.uniboard.com">www.uniboard.com</a>  •  (800) 263-5240</td>
<td></td>
<td>Houghton, Michigan</td>
<td>Cypress, Pine</td>
<td>FSC</td>
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<td>Houghton, Michigan</td>
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<td><strong>UNIBOARD</strong></td>
<td><a href="http://www.uniboard.com">www.uniboard.com</a>  •  (800) 263-5240</td>
<td></td>
<td>Sayabec, Quebec</td>
<td>Uniboard PB, NU Green SOYA™, NU Green®</td>
<td>Softwood, Hardwood</td>
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<td>Val-d’Or, Quebec</td>
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<td>London, England</td>
<td>Pine</td>
<td>FSC</td>
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</table>

**PARTICLES**<br>**B O A R D**<br>**S P E C I A L  I T E M S  A N D  T R E A T M E N T S:** 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 (HW), Lamine 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)<br><br>*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.*

Additional company contact information can be found on pages 110–112.
KRONOSPAN LLC
EASTABOGA PLANT
1 Kronospan Way, Eastaboga, Alabama 36260
(256) 741-8755 Fax (256) 741-8757
dfsales@kronospanusa.com
www.kronospanusa.com
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lgaskey@mjbwood.com
www.mjbwood.com
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www.ahlstrom-munksjo.com
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www.olon.com
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DECORATIVES DIVISION
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www.omnova.com
• OVERLAY MANUFACTURER

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www.omnova.com
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www.panpacificproducts.com
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solutions@panel.com
www.panel.com
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Temple, Texas 76504
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customer.service@panelspec.com
www.panelspec.com
• LAMINATOR

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Huntsville, Ontario P1H 2J7
(800) 672-6652 Fax (708) 789-6658
www.panolam.com
• PARTICLEBOARD MANUFACTURER
• 20 Progress Drive
Shelton, Connecticut 06484
(203) 925-1556 Fax (203) 225-0050
www.panolam.com
• OVERLAY MANUFACTURER
• LAMINATOR

PATRICK INDUSTRIES, INC.
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Elkhart, Indiana 46515
(574) 294-7511 Fax (574) 524-7708
schrammj@patickind.com
www.patickind.com
• LAMINATOR

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(844) 722-3939
sales@pembrokemdf.com
www.pembrokemdf.com

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(208) 777-2202
p.carey@plummerforest.com
www.enstron.com
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awilzoch@premiereurocase.com
www.premiereurocase.com
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26200 Town Center Drive, Suite 135
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info@riken-usa.com
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davidsm@rfpco.com
www.Roseburg.com

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tomwa@rfpco.com
www.easternsales.roseburg.com
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• PARTICLEBOARD MANUFACTURER
• LAMINATOR
• COATER

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Maryland Heights, Missouri 63043
(314) 400-6100 Fax (314) 400-6123
t.haffner@schattddecor.com
www.schattddecor.com
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STEVENS INDUSTRIES, INC.
704 West Main
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(217) 857-7100
bill@stevenswood.com
www.stevenswood.com
• LAMINATOR

STIMSON LUMBER COMPANY
520 Southwest Yamhill Street, Suite 700
Portland, Oregon 97204
(800) 445-9759 Fax (503) 295-1849
gconnolly@stimsonlumber.com
www.stimsonlumber.com
• HARDBOARD

SURFACE SOURCE INTERNATIONAL
961 Route 10E, Unit 2-I
Randolph, New Jersey 07869
(973) 598-0152 Fax (973) 598-0156
info@ssnorthamerica.com
www.ssnorthamerica.com
• OVERLAY MANUFACTURER

SURFACTOR AMERICAS LLC
1420 Marvin Road, Suite C #230
Lacey, Washington 98516
(360) 827-0994
roy.not@surfactor.com
www.surfactor.com
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SURTECO NORTH AMERICA
1175 Harrerlon Boulevard
Myrtle Beach, South Carolina 29577
BauschLinnemann Sales: (800) 992-3936
tim.val@us.surteco.com
www.surteco.com
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• LAMINATING ADHESIVE SUPPLIER

SYNERGY THERMAL FOILS, INC.
12175 NW 39th Street
Coral Springs, Florida 33065
(954) 420-9553 Fax (966) 783-4381
info@synergythermofoils.com
www.synergythermofoils.com
• OVERLAY MANUFACTURER

TAFA CANADA INC
4660 Villeuve
Lac-Megantic, Quebec G6B 2C3
(888) 882-3472 Fax (888) 711-3472
tafisa@tafisa.ca
www.tafisa.ca
• PARTICLEBOARD MANUFACTURER
• LAMINATOR

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ron.rodeck@ti-films.com
www.syndecor.com
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(315) 298-8465 Fax (315) 298-8822
alward@felix-schoeller.com
www.felix-schoeller.com
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TECNOTAbla
6339 2nd Avenue North
St Petersburg, Florida 33710
(727) 365-4853
ejallen@tecnotalla.com
www.tecnotalla.com
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