



DURAPLAY[®]
We make it happen

“Natural wood finish”

Make it happen with Duraplay veneered

Panels covered with natural veneers provide your projects with exclusivity and beauty due to the **unique and unrepeatable patterns, grains and tones of tree species**, and the type of cut of every single board

A) BENEFITS

- Beauty and durability.
- Provides a warm look.
- High-end finishes and elegance.
- Portfolio with the most recognized species in the market.

B) APLICATIONS

- Manufacture of high-end furniture.
- Decoration of spaces (wall covering).
- Commercial areas such as restaurants, boutiques, hotels, among others.

C) TECHNICAL SPECIFICATIONS

PRODUCT	CORE	DIMENSIONS			TOLERANCES				
		Thickness	Lenght (in)	Width (in)	Thickness	Lenght	Width	Squareness (in)	Warping (in / ft)
Veneered PB	Duraplay®	1/2	96	48	.0118	.078	.078	.078	.042
		5/8, 3/4	96	48	.0118	.078	.078	.078	.030
Veneered MDF	Fibraplay® MDF Standard	1/4, 3/8, 1/2	96	48	.0118	.078	.078	.078	.042
		5/8, 3/4	96	48	.0118	.078	.078	.078	.030
	Fibraplay® MDF Ligth	1/2	96	48	.0118	.078	.078	.078	.042
		5/8, 3/4	96	48	.0118	.078	.078	.078	.030
Veneered Lamcore	Lamcore	7/16	96	48	.0118	.078	.078	.078	.042
		1/2	96	48	.0118	.078	.078	.078	.042
		9/16, 11/16, 3/4, 1	96	48	.0118	.078	.078	.078	.030

*Certified product ANSI/HPVA HP-1-2016.

**Product available on request EPA TSCA Title VI.

***A board without Back or with a different veneer or species on its faces is an unbalanced board and may present Warping. The measurements or characteristics of the board can be modified without prior notice.

****Thickness tolerances for boards made from Okoume veneer will be approximate. 0.01575"

PRODUCT	CORE	Thickness Comercial (in)	Thickness Comercial (mm)	Thickness Core (in)	Thickness Core (mm)	Thickness Final (in)	Thickness Final (mm)	Pieces / Unit
Veneered PB	PARTICLEBOARD Duraplay® PB	1/2"	12.0	0.4724	12.0	0.5118	13.0	54
		5/8"	16.0	0.5708	14.5	0.6102	15.5	40
		3/4"	19.0	0.6875 0.7480	17.5 18.8	0.7283 0.7795	18.5 19.8	34
Veneered MDF	MDF Fibraplay® MDF Standad	1/4"	6.0	0.1771	4.5	0.2188	5.5	100
		3/8"	9.0	0.3543	9.0	0.3937	10.0	70
		1/2"	12.0	0.4331	11.0	0.4724	12.0	53
		5/8"	16.0	0.5938	15.0	0.6299	16.0	45
		3/4"	19.0	0.7087	18.0	0.7480	19.0	35
Veneered MDF	Fibraplay® MDF Ligth	1/2"	12.0	0.4331	11.0	0.4724	12.0	53
		5/8"	16.0	0.5938	15.0	0.6299	16.0	45
		3/4"	19.0	0.7087	18.0	0.7480	19.0	35
Veneered Lamcore	Lamcore	1/2"	12.0	0.4331	11.1	0.4763	12.1	60
		5/8"	16.0	0.5625	14.3	0.6023	15.3	50
		3/4"	19.0	0.6875	17.5	0.7283	18.5	40

** Product available upon request EPA TSCA Title VI.

D) STORAGE AND HANDLING

- Keep the straps when moving the material through a mechanical way; this facilitates the loading and unloading of the product and avoids slipping and rubbing between one board and another.
- Store indoors and in a dry place.
- Covering the boards with plastic or tarps protects and preserves them in climates or extreme conditions.
- Avoid extreme variations in temperature and humidity.
- Do not allow the surfaces and edges of the board are in direct contact with water.
- Maximum height of a package: 32 inches.
- Maximum stowage height: 7 packages.
- In the stowage, use separators between packages (preferably 4) placed approx. 28 in between them., taking care of the
- Alignment of packages. This practice also helps keep the board from absorbing moisture from the floor.
- Maintain a minimum distance between pallets of 8 inches approx.
- Do not stow vertically.

E) RECOMMENDATIONS

- **Manual cut:** Use a thin metal saw.
- **Cut with a jigsaw:** Use a fine-tooth saw with sway control.
- **Saw cut:**
 - The cut should be made with the decorative side facing up.
 - If the board is laminated on both sides, using a scoring disc 0.2mm wider than the main saw.
 - Use a motor with a minimum of 2 hp and 3,500 to 5,000 r.p.m.
 - Using a tungsten carbide tooth is recommended.
 - Choosing a saw with a smaller diameter increases stability and cut quality.
 - Choose preferably between 48 and 72 teeth (for thicknesses greater than 5/16").
 - Choose preferably between 72 and 108 teeth. (for thicknesses less than 5/16").
 - Height of saws on the material to cut between 1/2 and 1 inch.
- **Drilling:** Use a high-speed drill with a straight-pointed steel bit. The perforations in the edges. They must be in the center and not exceed 50% of the thickness of the board.
- **Grooving:** The groove must have a maximum depth of 50% of the thickness of the board, groove thickness, not more than 1/3 of the thickness.
- **Screws:** Before inserting a screw, drill 1/64 "smaller than the same.
 - Use only special screws.
 - It is not recommended to use a nail, preferably to use a staple (on the surface).

ANNEXED I

ROTARY-CUT WP & STRIPS

READ OAK				
DESCRIPTION	GRADE "B"		GRADE "C"	GRADE "D"
	Read Oak	White Oak		
Sapwood	10-20%	Yes	Yes	Yes
Heartwood	Yes	Yes	Yes	Yes
Color variation	Yes		Yes	Yes
Book Matched (PS)	Specified		N/A	N/A
Pin knots	Of 16 to 24 up to 1/4"		Unlimited	Unlimited
Knots sound & repaired	4		8	10 x board, solids of 1" and repaired of 3/4"
Knots repaired	4 up to 1/8"		4 up to 1/2"	5
Mineral streaks	Few up to 8"		Yes, to 1/2"	Yes
Rough cut	Slight		Slight	2 area of 8 sq in of in diameter or equivalent
Resin marks	Up to 20%		Yes	Yes
Repaired separations	Four 1/8" x 8"		Four 3/16" x 8"	Six of 1/4" x 10"

BIRCH, MAPLE, ASH					
DESCRIPTION	GRADE "B"			GRADE "C"	GRADE "D"
	Albura	Duramel	Natural		
Sapwood	Yes	No	Yes	Yes	Yes
Heartwood	No	Yes	Yes	Yes	Yes
Color variation	Yes			Yes	Yes
Book Matched (PS)	Specified			N/A	N/A
Pin knots	Of 8 to 16 up to 1/4"			Unlimited	Unlimited
Small conspicuous burls	1/2" maximum			Unlimited	Unlimited
Knots sound & repaired	4			8	10
Knots repaired	4 up to 1/8"			4 up to 1/2"	5 up to 3/4"
Mineral streaks	Few			Yes	Yes
Worm tracks	Yes			Yes	Yes
Bark	Few to 1/8" x 1"			Few of 1/4" x 2"	Few of 1/4" x 2"
Rough cut	Few			2 area of 8 sq. in of in diameter or equivalent	5% of board
Repaired separations	Four 1/8" x 8"			4 3/16" x 8"	6 of 1/4" x 10"

PLAIN-SLICED PS

RED OAK				
DESCRIPTION	GRADE "B"		GRADE "C"	GRADE "D"
	Red Oak	White Oak		
Sapwood	10-20%	Yes	Yes	Yes
Heartwood	Yes	Yes	Yes	Yes
Color variation	Yes		Yes	Yes
Book Matched (PS)	Specified		N/A	N/A
Pin knots	Of 16 to 24 up to 1/4"		Unlimited	Unlimited
Knots sound & repaired	4		8	10 x board, solids of 1" and repaired of 3/4"
Knots repaired	4 up to 1/8"		4 up to 1/2"	5
Mineral streaks	Few up to 8"		Yes, to 1/2"	Yes
Rough cut	Slight		Slight	2 area of 8 sq. in of in diameter or equivalent
Resin marks	Up to 20%		Yes	Yes
Repaired separations	4 of 1/8" x 8"		4 of 3/16" x 8"	6 of 1/4" x 10"

ALDER

DESCRIPTION	GRADE "B"	GRADE "C"
Sapwood	Yes	Yes
Heartwood	Yes	Yes
Color variation	Yes	Yes
Book matched (PS)	N/A	N/A
Pin knots	Unlimited	Unlimited
Small conspicuous burls	Any quantity any size	Any quantity any size
Knots sound & repaired	2" may contain dark centers	Any quantity any size
Knots repaired	6 maximum 3/4"	Any quantity up to 1 1/2"
Mineral streaks	Yes	Yes
Rough cut	Small area allowed	Small area allowed
Repaired separations	3 of 1/8" x 10"	Any quantity 1/8" x 12"
Components per sheet	3" no more than 1/3 of pieces	3" no more than 1/3 of pieces

WALNUT

DESCRIPTION	FACE		BACK
	GRADE "B"	GRADE "C"	2
Sapwood	Yes	Yes	Yes
Heartwood	Yes	Yes	Yes
Color variation	Yes	Yes	Yes
Book matched (PS)	According to the request	According to the request	According to the request
Pin knots	Up to 10 1/8 "in diameter, scattered	Up to 10 1/8 "in diameter, scattered	Up to 10 1/8 "in diameter, scattered
Small conspicuous burls	Yes, scattered	Yes, scattered	Yes
Knots sound	4 up to 3/8" scattered	8 up to 1/2" scattered	12 up to 3/4" scattered
Knots sound & repaired	4 up to 1/8" scattered	8 up to 1/4" scattered	8 up to 1/2" scattered
Knots open	No	No	4 up to 1/2" scattered
Mineral streaks	Yes, small	Yes, scattered	Yes
Rough cut	Small areas allowed	Up to 5% of the surface	Up to 10% of the surface
Repaired separations	4 of 1/8" x 1"	4 of 1/8" x 1"	4 of 1/4" x 1"
Open joins	No	4 of 1/8" x 1" scattered	10 of 1/8" x 8" scattered
Components per sheet	Between 3" to 4"	Between 3" to 4"	Between 3" to 4"
Wormholes	No	No	Yes
Bark	Very few of 1/8" x 1"	Very few of 1/8" x 1"	Very few of 1/8" x 1"
Bark bags	No	No	Yes up to 1/4 "

BACK (OAK, BIRCH, MAPLE, FRESNO, ASPEN)

BACK	1	2	3	4
Sapwood	Yes	Yes	Yes	Yes
Discolouration	Yes	Yes	Yes	Yes
Bark	1/8" wide repaired	1/4" wide repaired	Yes	Yes
Fixed knots	16 from to 3/8"	16 from to 3/4"	16 from to 1 1/2"	Yes
Open knots	No	8 from to 1/2"	All of 3/8" from to 1"	Up to 4"
Shoot marks	Shallow, vertical, up to 1/16 "in diameter	Shallow, vertical, up to 1/16 "in diameter	Yes	Si
Repaired knots	Pin 1/4"	All repaired	Yes	Without repair
Conspicuous burls	Yes	Yes	Yes	Yes
Mineral streaks	Yes	Yes	Yes	Yes
Rough	2 area of 8 sq in 2	Yes	Yes	Without repair
Knife marks	2 area of 8"	Yes	Yes	Yes
Irregular cuts	2 area of 8"	Yes	Yes	Yes
Divisions and Unions	6 of 1/8" x 12" repaired	6 of 3/16" x 12" repaired	3/8" along 25% of the board	1" along 25% of the board, 1/2 up to 50%, 1/4" across board

OKOUME

CLASS	B	BACK	
		1	4
Openings, gradual decrease	8 de 1/8" x 8" (204 mm) scattered with resane matched to the color of the veneer	12 of 1/4" x 66" (1680 mm)	1 "for 25% of board length, 1/2" for 50% of board length, 1/4 "across the all length of the board
Albura and Duramen, mixed	Yes	Yes	Yes
Roughness	Up to 10%	Up to 20%	Yes
Resin bags	Up to 6 de 1/2 x 2" scattered	Up to 8" x 42"	Yes
Irregular cuts	Yes, cover the substrate	Yes	Permitted
Fold of veneer	Yes, if corrected when repairing	Yes	Yes
Blade marks	Yes (tenuous)	Yes	Yes
Resin marks (adhesives)	Up to 15% of the surface	Up to 25% of the surface	Permitted
Shoot marks	Up to 10% of the surface dispersed	Up to 25% of the surface	Permitted
1 light / dark color mix	Yes	Yes	Allows unmatched color
Knots sound & repaired	8 x 2" solid board diameter repairing the fissures of 1/4" inside the knot, up to 6 1/2" knots	16 x 4" diameter solid board repairing the cracks 1/4" x 1" inside knot, up to 40 1/2" knots	Allows unmatched color Allows, without sight repair view, agreement with the client.
Small or small knots curved streaks	Up to 15 de 1/4"	Up to 30 of 1/4"	Allows, without repair or Mutual agreement
Rough	Up to 5%, if it does not affect the quality of the joint when pressing	Up to 10%, if it does not affect the quality of the joint when pressing.	Allows, without repair or Mutual agreement
Assembled strips, common customer agreement	Yes, color not matched with separations of 1/16" x 12" (305 mm).	Yes, color not matched with separations of 1/16" x 12" (305 mm).	Yes
Sliced	If possible (polished)	If possible (polished)	If possible (polished)

* Unpolished or polished, common agreement

HAYA

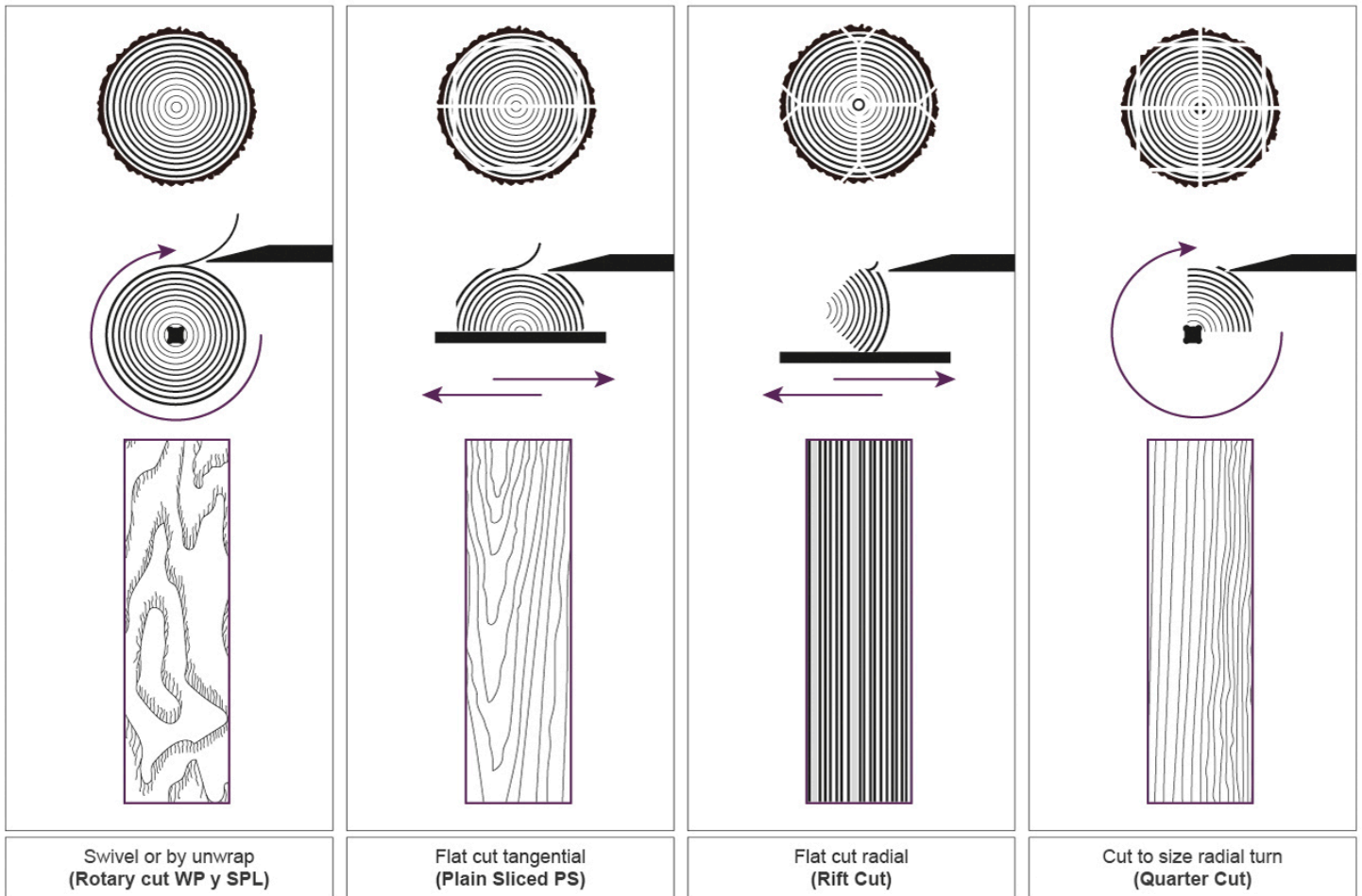
DESCRIPTION	FACE		BACK
	GRADE "B"	GRADE "C"	2
Sapwood	Yes	Yes	Yes
Heartwood	Yes	Yes	Yes
Color variation	Yes	Yes	Yes
Book Matched (PS)	According to the request	According to the request	According to the request
Pin knots	Up to 10 of 1/8" scattere in diameter	Up to 10 of 1/8" scattere in diameter	Up to 10 of 1/8" scattere in diameter
Small conspicuous burls	Yes, scattered	Yes, scattered	Yes
Knots sound	4 up to 3/8" scattered	8 up to 1/2" scattered	12 up to 3/4" scattered
Knots sound & repaired	4 up to 1/8" scattered	Yes up to 1/2 "	8 up to 1/2" scattered
Knots open	No	No	4 up to 1/2" scattered
Mineral streaks	Yes, small	Yes, scattered	Yes
Rough cut	Limited areas	Up to 5% of the surface	Up to 10% of the surface
Repaired separations	4 de 1/8" por 1"	4 of 1/8" x 1"	4 of 1/4" x 1"
Open joins	4 of 1/8" x 1"	8 up to 1/2", scattered	12 up to 3/4", scattered
Repaired knots	No	4 1/8" x 1" repaired	10 of 1/8" x 8" repaired
Components per sheet	Between 3" to 4"	Between 3" to 4"	Between 3" to 4"
Wormholes	No	No	Yes
Bark	Few of 1/8" x 1"	Few of 1/8" x 1"	Few of 1/8" x 1"
Bark bags	No	No	Yes up to 1/4"

VISTAPLAY PLUS	BIRCH	OTRA ESPECIE
DESCRIPTION	GRADE "D"	GRADE "4 "
Sapwood	Mixed	Yes
Heartwood	Mixed	Yes
Color variation	Uniform	Yes
Solid pin knot	Acceptable	Yes
Small knots or small curved streaks	From 4 to 8 up to 1/8"	Yes
Conspicuous small curved streaks	1/2" maximum	Yes
Fixed knots	Up to 4 of 1/8"	Yes
Knots repaired	Up to 4 of 1/8"	Not Repaired
Mineral lines	Few Light Lines	Yes
Vine shoot marks	Not Accept	Yes
Cortex	Light of 1/8" x 1"	Yes
Rough cut	2 per piece 6"	Yes
Repaired openings matched gradual decline	2 in each end	4 of 1/8" per 8"
Unrepaired openings	1/16" x 10" in each end	Yes

CHARACTERISTICS & CUT OF VENNERS

VENEER CUT	SPECIES	FACE	BACK	VENEER CUT	SPECIES	FACE	BACK
Rotary-Cut WP & SPL	Red Oak	B, C, D	1, 2, 3, 4	PS Plain-Sliced	Red Oak	B, C, D	2
	Birch	B, C, D	1, 2, 3, 4		Maple	B, C, D	
	Maple	B, C, D	1, 2, 3, 4		Alder	B, C,	
	Ash	B, C, D	1, 2, 3, 4		Haya	B	
	Okoume	B	1, 4		Walnut	B	

TYPES OF CUTTING





Note: Products available on request with emissions
EPA TSCA Title VI.