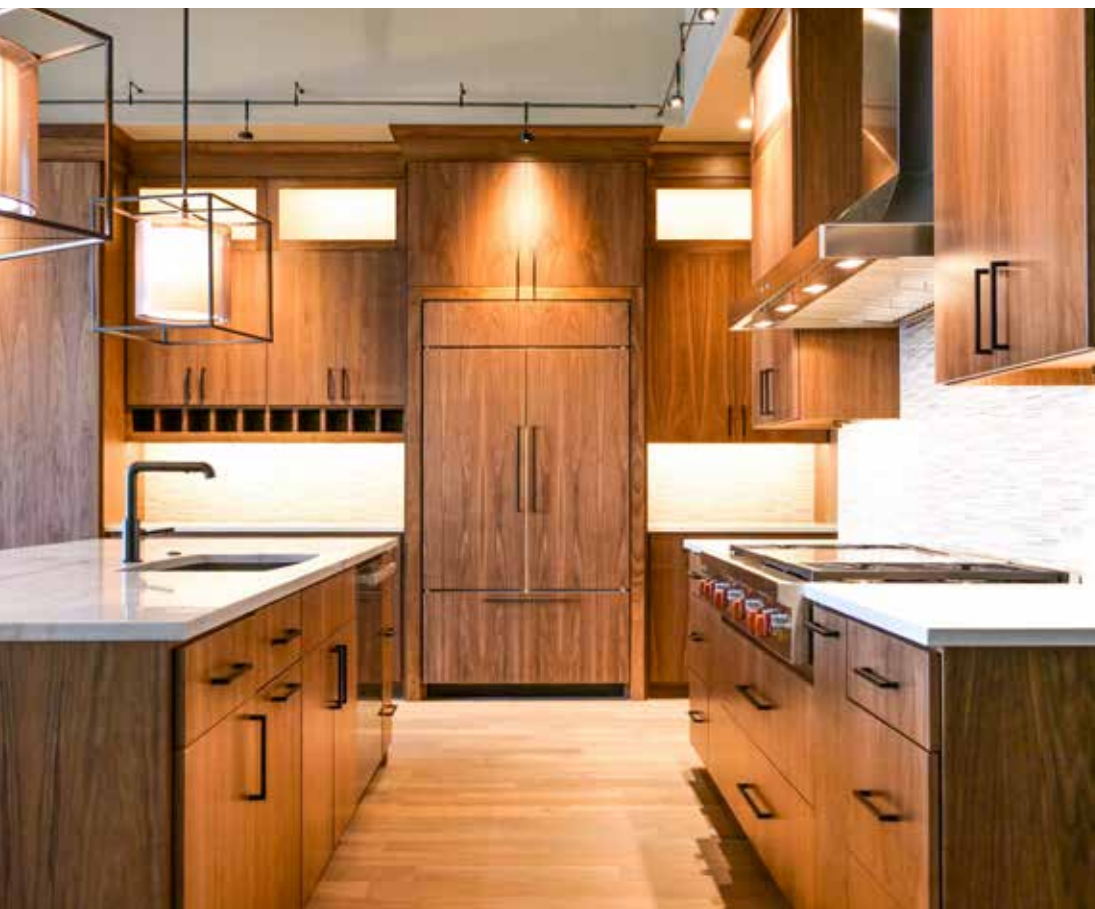


Roseburg  
**SkyPly**<sup>®</sup>  
Hardwood Plywood



Hardwood Plywood by Roseburg offers a wide variety of panel options including beautiful hardwood veneer faces that are hand graded and sorted into a range of species, types of veneer cuts and matches. Paired with a huge range of core options engineered for different applications, Roseburg SkyPly is ideal for cabinetry, furniture, custom casework, fixtures, and wall panels.



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Roseburg  
**SkyPly**<sup>®</sup>  
Hardwood Plywood

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Since 1936 Roseburg has focused on building value with timberland, safe and efficient manufacturing, and passionate capable people. Vertically integrated, Roseburg sustainably manages approximately 600 acres of timberland in Oregon, Virginia, and North Carolina, and operates manufacturing facilities across North America. Our hardwood plywood is produced domestically in Dillard, OR.

- Mixed product shipment availability
- Integrated manufacturing facilities
- Broadest wood product mix from a single-source producer



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# Sliced Veneers

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Cherry



Walnut



White Maple



Red Oak



Alder



White Oak



Calico Hickory



European Steamed Beech



Ribbon Sapele



Quartered Caramel Bamboo



Plain Sliced Jatoba



Plain Sliced Natural Bamboo



# Rotary Veneers

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Natural Birch



White Birch



Red Oak



Natural Maple



White Maple



Red Birch







## Core Options

### Veneer

Constructed using innerplies composed of Western softwoods. Veneer core panels are lightweight, dimensionally stable and have excellent screw-holding capacity.

### HXB Veneer

Combines the smooth finish of a hardwood veneer crossband beneath the hardwood face and back with the strength and durability of western softwood veneer innerplies. Together they create an excellent hardwood plywood panel that is smoother and has less potential for core telegraphing.

### CFC

Combination Fiber Core (CFC) combines MDF cross bands with softwood veneer innerplies. The MDF crossbands provide an ultra smooth surface to reduce telegraphing through the face, while the veneer innerplies maintain the strength and screw-holding power of a veneer core panel. This option is recommended for high-end veneers.



# Core Options

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## **Particleboard**

Multi-layered substrate produced using a blend of western softwoods. The core consists of pre-consumer recycled wood fiber. The combination of sanding to extremely smooth, tight and grainless surfaces on both sides, with a controlled distribution pattern of particles in the core, results in a uniform, dimensionally stable panel.

## **Medium Density Fiberboard**

Makes for a very smooth, consistent panel. This is a great substrate for high-end veneer and for applications where routing and shaping are required. The MDF core consists of pre-consumer recycled wood fiber.

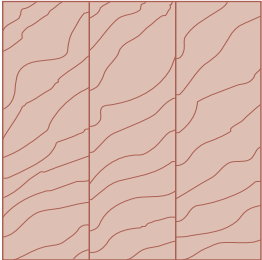
## **Medite FR MDF**

The same advantages of creating a hardwood plywood panel on MDF core exist with Medite FR. It is an ideal substrate for high-end veneers. Medite FR is a Class 1(A) certified panel that is also no added formaldehyde, so the resulting SkyPly Hardwood Plywood product can be used where flame retardant materials are required.

# Veneer Matching

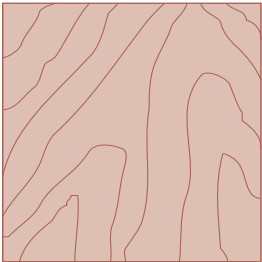
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Natural coloration and arrangement of veneer, comprising the panel face, determine the resulting visual effect. Different matching techniques are used for specific panel applications.



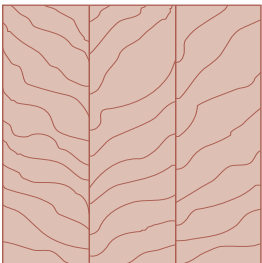
## Slip Match

Adjacent veneer sheets are joined side by side, same sides up, for a uniform grain pattern.



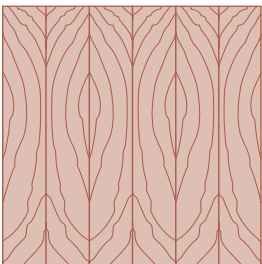
## Whole Piece

One single piece of veneer is used, with continuous grain characteristics running across the sheet.



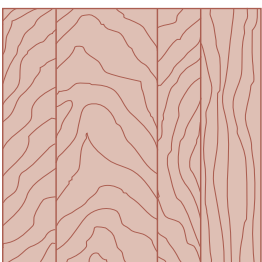
## Pleasing Match

Veneers are matched by color or similarity, not necessarily by grain characteristics.



## Book Match

Every other piece of adjacent veneer is turned over, resulting in identical, but opposing patterns.



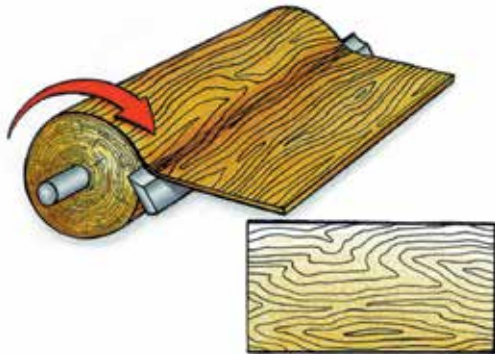
## Random Match

Veneers intentionally do not match at the joints, providing a casual effect.

# Slicing Options

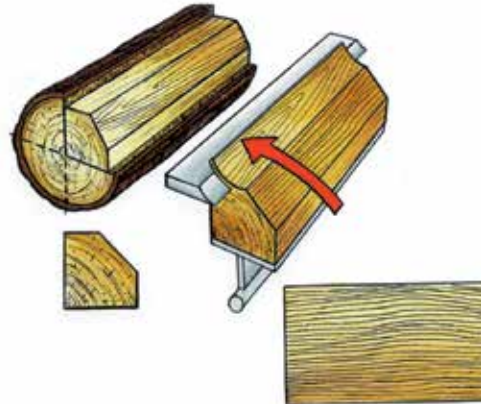
## Types of Veneer Cuts

Depending on the manner in which a log is cut, strikingly different visual effects can be achieved with the wood's grain and characteristics. Two logs of the same species, cut in different ways, produce distinctive, individual veneers.



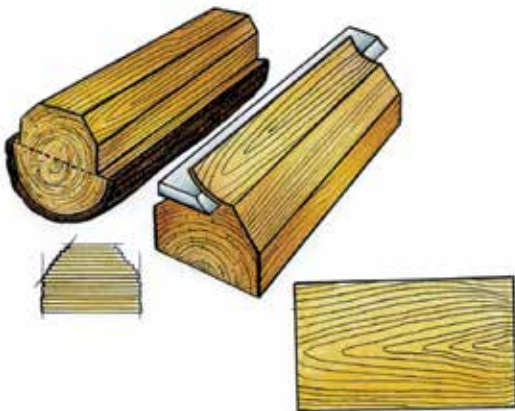
### Rotary

The entire log is cut or "peeled." It can yield full sheets of veneer with broad grain pattern and no plain or quarter-sliced appearance.



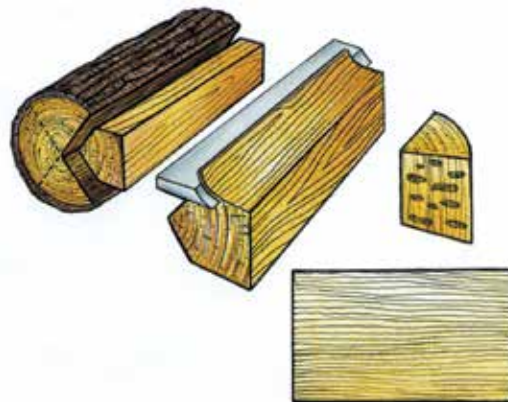
### Rift Cut

A cut angle of 15 degrees to the radius of the flitch is used to minimize the ray flake affect in oak.



### Plain Slicing

The half log, or flitch, is mounted with the heart side flat against the flitch table of the slicer. The slicing is done parallel to a line through the center of the log to produce a distinct figure.



### Quarter Slicing

This method produces a series of stripes – straight in some woods, varied in others. A flake pattern is produced when slicing through medullary rays in some species, principally oak. Most species produce the same look as rift cut.

# Panel Finish Options

## RediPly Hardwood Panels

RediPly combines our hardwood veneer face with a Duramine® Thermally Fused Laminate (TFL) back. RediPly panels are available with a pre-finished UV clear topcoat that provides a smooth durable finish to the face.

### Panel Options

BACK	CORE	OVERLAY
Duramine (TFL) Size: 4' x 8' Thickness: 5/8", 3/4"	Particleboard MDF	291 white, 055 hard rock maple 016 almond, other solids and woodgrains available



## RediFinish Hardwood Panels

RediFinish panels are prefinished using an automated system consisting of sanding, sealing, curing, and top coating each panel. All of SkyPly Hardwood Plywood panels are finished using Epoxy Arylate UV coating that is 100% solids and have no VOC emissions. Our coatings have additives that make them scratch- and mar-resistant and they are regularly tested to ensure they maintain and exceed KCMA standards. We make panels in four standard gloss reflection levels, low (20-30), satin (30-40), medium (50-60) and high (70-80). Custom gloss reflection levels are available within +/- 5% reflectivity with a 200 face minimum.

### Availability:

Thickness: 5.2mm, 1/4", 3/8", 1/2", 5/8", 3/4", 1", 1-1/8", 1-1/4"  
Lengths: 8' & 10' Widths: 4'

One or two sides on a variety of cores: Veneer, HXB, MDF, Particleboard and CFC.



## RediBead Hardwood Panels

RediBead panels have a tongue and groove appearance and can be used for cabinet doors and backers, wainscoting, wall paneling or any other interior design application where the warmth and beauty of hardwood is desired.

### Availability:

Thickness: 1/4", 1/2", 5/8", 3/4", 1" Lengths: 8' & 10' Widths: 4'

Species: Any hardwood veneer Bead Pattern: 1-1/2" o.c.

Core Options: MDF provides the best groove and bead appearance for all thicknesses.



# Technical Information

Panel: **Roseburg SkyPly Hardwood Plywood Panels**

**Overview** All Roseburg hardwood panels are produced domestically from the finest hardwood veneer and cores available. The entire product line is third party certified to meet the requirements of EPA TSCA Title VI and is ULEF Exempt. The product can contribute to LEED® v4. SkyPly, RediPly and RediFinish hardwood plywood panels are UL GREENGUARD Certified for low VOC emissions.

## Specifications

Lengths	8' & 10'		Widths	4'	
Thickness	<u>Core</u>		<u>Thickness</u>	<u>Plys</u>	
			1/4"	3	
Veneer core panels			3/8", 1/2"	5	
			5/8", 3/4"	7	
			3/4"	9 (specified)	
			1", 1-1/8", 1-1/4"	9, 11	
			<u>Core</u>	<u>Thickness</u>	<u>Plys</u>
			Particleboard core panels	1/2", 5/8", 3/4", 1"	3
			MDF core panels	5/32", 3/16", 5.2mm, 1/4", 3/8", 1/2", 5/8", 3/4", 1"	3

**Face**

**Rotary, plain sliced, quarter sliced, rift cut hardwood panels** are faced with hand selected hardwood veneers that, when applied to a laminating substrate, create a panel that has the rich beauty of hardwood.

**RediFinish hardwood panels** are produced using a high performance UV cure burnishing sealer and a mar-resistant UV cure topcoat applied to the hardwood veneer face.

**RediPly hardwood panels** combine hardwood veneer faces with a thermally fused laminate back.

**RediBead Panel** combines the look and feel of real wood with a tongue and groove appearance.

**Back** Hardwood veneer, Thermally Fused Laminate, Balancing backer, Glueable backer

Core Options	Veneer	Particleboard	MDF
	Western Softwood Veneer (White Fir)		
	Combination Fiber Core (CFC)		
	Hardwood Cross Band (HXB)		

**Finish Options** Natural unfinished, UV-cured clear topcoat, beaded

**Slicing Options** Rotary, Rift Cut, Plain Slicing, Quarter Sawn. Slicing option is based on desired hardwood veneer.

**Veneer Matching Options** Slip, Whole Piece, Pleasing, Book, Random. Natural coloration and arrangement of veneer, comprising the panel face, determine the resulting visual effect. Different matching techniques are used for specific panel applications.

**Dimensional Tolerances** Refer HPVA ANSI/HPVA HP-1-2016

**Resin** ULEF Resin. View Safety Data Sheet on [www.Roseburg.com](http://www.Roseburg.com)

**Sanding** 180-220 grit

**Flame Spread Rating** Class C or Class III. Class 1/A when manufactured on Medite FR MDF core.

**Certifications** SkyPly is GREENGUARD Certified for low VOC emissions. Refer to certificates on [www.roseburg.com](http://www.roseburg.com) or [www.greenguard.org](http://www.greenguard.org). Complies with EPA TSCA Title VI and is ULEF Exempt, under Executive Order N-18-038cc, and N-18-038vc

**Manufacturing Locations** Dillard, OR

# Maintaining Quality

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## **Proper handling and storage**

Between the time panels are manufactured and put into their final application, there are many opportunities for hardwood plywood panels to be damaged. The following handling and storage tips should be observed at every step along the route to ensure the panels reach their final destination unscathed.

### **Handling**

**Minimize Movement** – The best way to minimize handling damage is by handling the panels as little as possible. Plan your warehousing and process flow operations to minimize the need to handle the panels.

**Proper Strapping** – When you do need to move panels, make sure that they are properly secured and strapped. This will minimize the chances that the units will unexpectedly shift during transport.

**Dunnage** – Keep the panels properly protected until they are ready for use on the job site. The proper dunnage will absorb many handling dings and nicks before they reach the panels.

**Training** – Properly trained employees are your best defense against damage. Make sure all employees are trained in the proper and safe use of fork trucks, pallet jacks, and other handling equipment. If your employees are careful and know how to handle panels, your panels will stay in good shape.

### **Storage**

**Proper Stacking** – Proper stacking is vitally important to protecting panels. Make sure you maintain clean stacks with no protruding edges. When stacking units, keep similar lengths of similar product together and maintain proper alignment and quality of stacking sticks to avoid bending or flexing panels. The sticks should be thick enough to allow fork truck tines to pass unobstructed between units

**Temperature** – Wood is a natural material and is negatively affected by extreme swings in temperature. Also, wood stored in direct sunlight may heat up enough to warp. To minimize damage, storage temperatures should be maintained between 60–90°F.

**Moisture** – Extreme swings in humidity and direct contact with water can both damage the appearance and performance of hardwood panels. It is extremely important to store panels in a climate controlled environment to eliminate the impacts of moisture. The storage environment's relative humidity should mimic the anticipated service environment, usually 30–55% RH.

**Light** – Although most wood will change color upon exposure to sunlight, the effect is more pronounced in some of the species commonly used in hardwood panels. Cherry, for example, will begin to change color within a few hours of exposure to sunlight. For that reason, panels should be neatly stacked and covered during storage.

**Coverings** – Roseburg's hardwood plywood is packaged in attractive unit covers that also help protect the panels from damage. Each panel is end stamped with the grade, species and standards. Special services, such as barcoding are also available upon request.

## **Delivery and Fabrication**

**Acclimation Period** – Do not deliver panels to the job site until they are needed and the site is ready, but allow at least 48 hours for the panels to acclimate to the use environment before installation. Panels that aren't given enough time to acclimate on the job site prior to fabrication may warp during use.

### **Machining**

The panel is constructed to provide the best possible machining results when sawn, routed, shaped and drilled. Proper nails, screws and other fasteners may be placed near the edge without splitting the panel.

### **Finishing**

It is recommended that fine-grit sandpaper and sanding sealer be used prior to staining. Because hardwoods react differently to certain finishes, a test sample should be done first, to determine the desired appearance before final finishing.

# Sustainable Features

## A Focus on Sustainability

The construction of a hardwood plywood panel is an innovative and efficient use of trees. Compared to a solid hardwood product, a tree is peeled into thin veneers and those veneers are stitched together in a variety of ways offering the beauty of the wood grain but yielding far more material from one tree. These sheets of veneer are laminated to a core that can be constructed of various forms and species of wood – including the recycled waste from the production of lumber and other wood manufacturing by-products.

## Compliance:

Title VI of the Toxic Substances Control Act (TSCA) is a federal formaldehyde emissions standard for composite wood products including hardwood plywood. Prior to EPA TSCA Title VI, formaldehyde emissions from hardwood plywood were regulated by California under the CARB Air Toxic Control Measure 93120. Roseburg's Hardwood Plywood is third party certified (TPC-1) to meet the requirements of EPA TSCA Title VI and is CARB ULEF Exempt (CA Executive Orders N-18-038cc and N-18-038vc. Certificates available at [www.roseburg.com](http://www.roseburg.com).

Lacey Act – Roseburg is firmly committed to complying with the Lacey Act and legally trading in wood products. Roseburg exercises due diligence as a means to ensure compliance with all applicable wood standards and associated laws. For more information visit [www.roseburg.com/Regulatory-info](http://www.roseburg.com/Regulatory-info)

## Voluntary Certifications:



UL GREENGUARD  
Certified by UL for low total VOC emissions.



Most SkyPly panels are available with the option of FSC certification. FSC-C017580



EPD – Type III product specific EPD  
(4786969381.107.1)



ECC – Roseburg particleboard and MDF used as the cores in SkyPly are certified to the Composite Panel Association ECC



SCS – Roseburg MDF used as the cores in SkyPly are certified for recycled content by Scientific Certification Systems.



Guardian Fire Rating – Medite FR, a Class 1/A certified MDF can be used as a core for SkyPly, resulting in a product that can be used where Class 1 certified products are required.



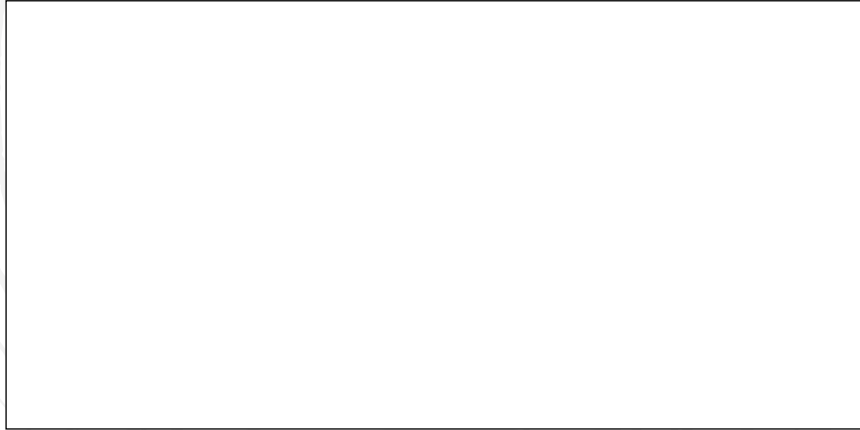
SkyPly Hardwood Plywood by Roseburg supports the following LEED v4 credits:

- Materials & Resources – Building Product Disclosure & Optimization
  - Environmental Product Declarations
  - Sourcing of Raw Materials – Leadership Extraction Practices (opt. 2)
  - Wood products certified by the Forest Stewardship Council
  - Recycled Content
- Indoor Environmental Quality Credit – Low Emitting Materials
  - Composite Wood Evaluation

For downloadable support documentation, go to [www.roseburg.com](http://www.roseburg.com)



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