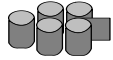


## Raw Materials

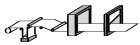


The laminate production process at Wilsonart International begins in the receiving area. Decorative paper, kraft paper, overlay, and other raw materials arrive and are inventoried and distributed to the appropriate holding area.

## Decorative Paper

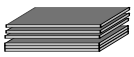


Decorative paper provides the pattern, woodgrain or solid color for a sheet of laminate. Overlay paper gives laminate its surface strength and scratch-resistance.



Overlay paper is taken to the melamine treater area where it is saturated with melamine resin, cured and rerolled.

Both decorative paper and treated overlay paper may be stored in rolls or cut to sheet size and stored until needed.



When the production schedule arrives in the assembly area, sheets of decorative paper and overlay are pulled from the rack system and assembled in sets based on the day's production run.

## Core Paper



Just as decorative papers are readied for press, the kraft paper, which makes up the core of laminate, undergoes a similar process. Kraft paper arrives in the facility by rail and is placed in the kraft paper storage area. From this staging area, the kraft paper is taken to the phenolic treater where it is saturated with phenolic resin, cured and rolled or cut to size.

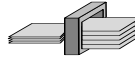


Treated kraft paper is taken to the corestock area where it is assembled based on the sheet makeup required by the production schedule. Each type of laminate (general purpose, postforming, vertical grade) requires a slightly different core lay up.

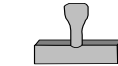
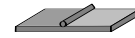
## Assembly/Pressing



The collated material from the corestock area is taken to the pressing department to be collated with the decorative papers from the assembly area. The two processes come together as the decorative paper and core paper are assembled at the press, and cooked for about an hour under high heat and pressure.



The decorative and kraft papers are sandwiched between two stainless steel textured plates which impart the tactile finish (gloss, matte, textured) on the completed laminate sheet.



## Sanding

Once the press cycle is complete, the laminate is taken to the sander. The edges of each sheet are trimmed, and the back is sanded to provide better adhesion in fabrication. At this stage the pattern identification number is printed on the back of each sheet.



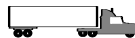
## Cut To Size

Some special order sheets are cut to size for the customer. This takes place in the cut to size area after the laminate leaves the sander.



## Finished Goods

Once the laminate clears the sander and cut to size areas, it is sent to the finished goods staging area where it is stored temporarily prior to being shipped to our market service centers, distributors or direct accounts.



## Shipping

Laminate sheets are pulled from finished goods inventory, packed on skids and loaded aboard Wilsonart International trucks for shipment to regional market centers.