

Cabinet Components, Inc.
Specifications Book
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General Machined Component Part Specifications

Cabinet Components and Distribution, Inc.

(Specifications the door and face frame departments use in building finished products)

Component width	+/- .015", or 1/64"
Component length	+/- .015", or 1/64"
Component warp/bow	+/- .031", measured at the center of the component
Door size, width and length	+/- 1/32" for single panel doors. Multiple panel doors will be +/-1/32" per panel.
Assembled face frame size, width and length	+/- 1/32" for single opening frames. Multiple openings will be +/-1/32" per opening.
Door or face frame squareness	+/- .031" per lineal foot
Joint opening on mitred doors	.015", or 1/64" maximum allowed

- Notes:
- * Components include door stiles and rails, and assembled face frame stile and rails.
 - * Components are assured of meeting machine tolerance related specifications from time of shipment until 5 days after being received.
 - * Mitre joint gaps are assured of meeting tolerance levels at time of shipment.

Unacceptable defects or characteristics

Following is a list of wood defects or characteristics that are generally unacceptable on any finished part, face or back.

- Bark, wane
- Cracks
- End checks
- Honeycomb
- Shake
- Advanced or dry rot
- Loose or unsound knots
- Carpenter ant, or grub holes

Following is a list of machining defects that are generally unacceptable on any finished part, face or back.

- Fuzzy grain
- Corrugated grain
- Layered grain
- Chipped grain
- Torn grain
- Chip marks
- Glazed surface
- Burn marks
- Chatter
- Washboard surface
- Snipe, other dips
- Taper
- Skips
- Drive wheel marks
- Saw marks

Other defects to be aware of that are generally unacceptable on any finished part.

- Fingerprints, from handling with wet hands, or using hand lotion
- “Dings” or other handling defects from bumping during handling
- “Drag marks”, from dragging across another surface, after final sanding
- Open joint fits, on either doors or assembled face frames

	Red oak specifications for all door components					
	Premium grade		Standard grade		Natural grade	
	Face	Back	Face	Back	Face	Back
Air check	yes, repaired	yes, repaired	yes, repaired	yes, repaired	yes, repaired	yes, repaired
Bark pockets	no	2/sq. ft.	no	2/sq. ft.	1/8x2", 1/sq. ft., sound	no limit
Bird peck	no	no limit	no	no limit	4/sq. ft.	no limit
Colors accepted	2-5	all	2-6	all	all	all
Color match rule	skip zero rule	n/a	skip one rule	n/a	skip two rule	no rule
Incipient rot	no	no limit	no	no limit	no	no limit
Knots, open *	no	no	no	1/2", 2/sf max	no	1/2"max, repaired
Knots, pin	4/sq. ft., no clusters	no limit	8/sq. ft., no clusters	no limit	yes	no limit
Knots, sound	no	2/sq. ft.	no	1/2", 2/sf max	1/4" max., 2/sq. ft.	no limit
Mineral streaks	1/16x1.5", 1 per 2 sq. ft.	no limit	1/8x2", 1/sq. ft.	no limit	1/4x4", 1/sq. ft.	no limit
Pitch pockets	no	no limit	no	no limit	1/4x4", 1/sq. ft., sound	no limit
Stains (see below)	no	yes, not to edges	no	yes, not to edges	no	no limit
Worm holes	no	yes, repaired	no	yes, repaired	yes, repaired	yes, repaired
Worm tracks	no	no limit	no	no limit	yes	no limit
Minimum stave width	2.375", no more than 2 per panel		2.375", no more than 4 per panel		1.5", no more than 4 per panel	

	Character grade		Rustic grade		Knotty grade	
	Face	Back	Face	Back	Face	Back
Air check	yes, repaired	yes, repaired	yes	no limit	yes, repaired	yes, repaired
Bark pockets	2/sq. ft., must be sound	no limit	yes, must be sound	no limit	1/4x4", 1/sq. ft.	no limit
Bird peck	yes	no limit	yes	no limit	4/sq. ft.	no limit
Colors accepted	all	all	all	all	all	all
Color match rule	no rule, no tiger stripes	no rule	no rule	no rule	skip two rule	no rule
Incipient rot	no	no limit	yes	no limit	no	no limit
Knots, open *	no	1/2" max, 2/sf	no	no limit	yes, can't see through	no limit
Knots, pin	yes	no limit	yes	no limit	yes	no limit
Knots, sound	1/4" max., 2/sq. ft.	no limit	1/4" max, 2/sq.ft.	no limit	3" max. diameter	no limit
Mineral streaks	1/2" x 1/3 length of part	no limit	yes	no limit	1/4x4", 1/sq. ft.	no limit
Pitch pockets	yes, must be sound	no limit	yes	no limit	1/4x4", 1/sq. ft.	no limit
Stains (see below)	no	no limit	no	no limit	no	no limit
Worm holes	yes, repaired	yes, repaired	yes, repaired	yes, repaired	yes, repaired	yes, repaired
Worm tracks	yes	no limit	yes	no limit	yes	no limit
Minimum stave width	1.0", unlimited amounts		1.5", no more than 4 per panel		1.5", no more than 4 per panel	

Note: All knotty grades will have a minimum of one knot per panel; stiles and rails may or may not have any knots. Knots can be sliced, or 1/2 knots.

We assure that knotty grade knots will be stable.

CCDI does not grain match on any of our panels.

Quarter sawn material is not allowed on premium grade, with minimal amounts allowed on all other grades.

[Redacted] = In stock parts. Non-stock parts must be given 10 working days of lead time. For material that must be special ordered,

the 10 days will start after we have received the material. Pricing will vary, call for quotes.

Stains include; bacteria, iron, water and sticker.

* Open knots must be sound

Updated:

Except in Premium grade, specs in panel, stile/rail and edge profiles can be more tolerant than the rest of the part

	Hard maple specifications for all door components				Rustic grade	
	Premium grade		Standard grade		Face	Back
	Face	Back	Face	Back		
Air check	yes, repaired	yes, repaired	yes, repaired	yes, repaired	yes	no limit
Bark pockets	no	1 per 2 sq. ft.	1/8x2", 1/sq. ft.	1 per 2 sq. ft.	yes, must be sound	no limit
Bird peck	no	no limit	no	no limit	yes	no limit
Colors accepted	1-6	all	1-6	all	all	all
Color match rule	skip 1 rule	no rule	skip two rule	no rule	no rule	no rule
Incipient rot	no	no limit	no	no limit	yes	no limit
Knots, open *	no	no	no	1/2" max, 2/sf	no	no limit
Knots, pin	4/sf. blend color w/door	no limit	8/sf blend color w/door	no limit	yes	no limit
Knots, sound	no	2/sq. ft.	no	1/2", 2/sf max	1/4" max., 2/sq. ft.	no limit
Mineral streaks	1/16x1.5", 1/ sq. ft.	no limit	1/8x2", 1/sq. ft.	no limit	yes	no limit
Pitch pockets	no	no	1/8x2", 1/sq. ft.	no	yes, must be sound	no limit
Stains (see below)	no	yes, not to edges	no	yes, not to edges	no	no limit
Worm holes	no	yes, repaired	no	yes, repaired	yes, repaired	no limit
Worm tracks	4/sq. ft. 2" max length	no limit	8/sq. ft. 2" max length	no limit	yes	no limit
Minimum stave width	2.375", no more than 2 per panel		2.375", no more than 4 per panel		1.5", no more than 4 per panel	
	Knotty grade					
	Face	Back				
Air check	yes	yes				
Bark pockets	yes must be sound	yes				
Bird peck	yes	yes				
Colors accepted	all	all				
Color match rule	skip two rule	no rule				
Incipient rot	yes	yes				
Knots, open *	yes, can't see through	yes				
Knots, pin	yes	yes				
Knots, sound	3" max. diameter	yes				
Mineral streaks	yes	yes				
Pitch pockets	yes	yes				
Stains (see below)	no	yes				
Worm holes	yes, repaired	yes, repaired				
Worm tracks	yes	yes				
Minimum stave width	1.5", no more than 4 per panel					

Note: All knotty grades will have a minimum of one knot per panel; stiles and rails may or may not have any knots. Knots can be sliced, or 1/2 knots.

We assure that knotty grade knots will be stable.

CCDI does not grain match on any of our panels.

Bird's eye maple is not allowed in premium grade, while minimal amounts are allowed in all other grades.

█ = In stock parts. Non-stock parts must be given 10 working days of lead time. For material that must be special ordered, the 10 days will start after we have received the material. Pricing will vary, call for quotes.

Stains include; bacteria, iron, water and sticker.

* Open knots must be sound

Except in Premium grade, specs in panel, stile/rail and edge profiles can be more tolerant than the rest of the part

Updated:

8/2/2004

	Cherry specifications for all door components					
	Premium grade		Standard grade		Rustic grade	
	Face	Back	Face	Back	Face	Back
Air check	yes, repaired	yes, repaired	yes, repaired	yes, repaired	yes	yes
Bark pockets	no	yes	no	yes	yes, must be sound	yes
Bird peck	no	yes	no	yes	yes	yes
Colors accepted	2-10 (no sap)	all	2-10 (no sap)	all	all	all
Color match rule	skip one rule	no rule	skip two rule	no rule	no rule	no rule
Incipient rot	no	yes	no	yes	yes	yes
Knots, open *	no	no	no	1/2" max, 2/sf	no	yes
Knots, pin	6/sq. ft.	yes	8/sq. ft.	yes	no limit	yes
Knots, sound	no	2/sq. ft.	1/4" max., 1 per 2 sq. ft.	1/2", 2/sf max	1/4" max., 4/sq. ft.	yes
Mineral streaks	1/16x1.5", 1/sq. ft.	yes	1/8x2", 1/sq. ft.	yes	yes	yes
Pitch pockets	1/16x1/2, 2/sq. ft.	yes	1/8x1, 6/sq. ft.	yes	yes, must be sound	yes
Stains (see below)	no	yes, not to edges	no	yes, not to edges	no	yes
Worm holes	no	yes, repaired	no	yes, repaired	yes	yes
Worm tracks	no	yes	no	yes	yes	yes
Minimum stave width	2.375", no more than 2 per panel		2.375", no more than 4 per panel		1.5", no more than 4 per panel	
	Knotty grade					
	Face	Back				
Air check	yes	yes				
Bark pockets	yes, must be sound	yes	Due to the natural photosensitive darkening process, we strongly recommend that you finish cherry products immediately upon receipt.			
Bird peck	yes	yes				
Colors accepted	all	all				
Color match rule	skip two rule	no rule				
Incipient rot	yes	yes				
Knots, open *	yes, can't see through	yes				
Knots, pin	yes	yes				
Knots, sound	3" max. diameter	yes				
Mineral streaks	yes	yes				
Pitch pockets	yes	yes				
Stains (see below)	no	yes				
Worm holes	yes	yes				
Worm tracks	yes	yes				
Minimum stave width	1.5", no more than 4 per panel					

Note: All knotty grades will have a minimum of one knot per panel; stiles and rails may or may not have any knots. Knots can be sliced, or 1/2 knots.

We assure that knotty grade knots will be stable.

CCDI does not grain match on any of our panels.

█ = In stock parts. Non-stock parts must be given 10 working days of lead time. For material that must be special ordered, the 10 days will start after we have received the material. Pricing will vary, call for quotes.

Stains include; bacteria, iron, water and sticker.

* Open knots must be sound

Except in Premium grade, specs in panel, stile/rail and edge profiles can be more tolerant than the rest of the part

Updated:

8/2/2004

	Hickory specifications for all door components					
	Standard grade		Rustic grade		Knotty grade	
	Face	Back	Face	Back	Face	Back
Air check	yes, repaired	yes, repaired	yes	yes	yes	yes
Bark pockets	1/8x4", 1/sq. ft.	yes	yes, must be sound	yes	yes, must be sound	yes
Bird peck	8/sq. ft.	yes	yes	yes	yes	yes
Colors accepted	all	all	all	all	all	all
Color match rule	color blend	no rule	color blend	no rule	color blend	no rule
Incipient rot	no	yes	yes	yes	yes	yes
Knots, open *	no	1/2", 2/sf max	yes, 1/2" max. diameter	yes, 1/2" max.	yes, can't see through	yes
Knots, pin	8/sq. ft.	yes	yes	yes	yes	yes
Knots, sound	1/4" max., 2/sq. ft.	yes	yes	yes	3" max. diameter	yes
Mineral streaks	1/8x4", 1/sq. ft.	yes	yes	yes	yes	yes
Pitch pockets	1/8x4", 1/sq. ft.	yes	yes, must be sound	yes	yes	yes
Stains (see below)	no	yes, not to edges	no	yes	no	yes
Vining	yes	yes	yes	yes	yes	yes
Worm holes	no	yes, repaired	yes	yes	yes	yes
Worm tracks	4/sq. ft.	yes	yes	yes	yes	yes
Minimum stave width	2.375", no more than 2 per panel		1.5", no more than 4 per panel		1.5", no more than 4 per panel	

	Soft maple specifications for all door components					
	Uniform (white) grade		Natural grade			
	Face	Back	Face	Back		
Air check	yes, repaired	yes, repaired	yes, repaired	yes		
Bark pockets	1/8x2", 1/sq. ft.	1 per 2 sq. ft.	yes, must be sound	yes		
Bird peck	no	yes	yes, must be sound	yes		
Colors accepted	1-6	all	all	all		
Color match rule	skip two rule	no rule	no rule	no rule		
Incipient rot	no	yes	no	yes		
Knots, open *	no	1/2", 2/sf max	no	yes, repaired		
Knots, pin	1/sq. ft.	yes	yes	yes		
Knots, sound	no	1/2", 2/sf max	yes	yes		
Mineral streaks	1/8x2", 1/sq. ft.	yes	yes	yes		
Pitch pockets	1/8x2", 1/sq. ft.	no	yes, solid or repaired	must be solid		
Stains (see below)	no	yes, not to edges	yes	yes		
Worm holes	no	yes, repaired	yes, repaired	yes, repaired		
Worm tracks	4/sq. ft.	yes	yes, not spongy	yes		
Minimum stave width	2.375", no more than 4 per panel		1.0", unlimited amounts			

Note: All knotty grades will have a minimum of one knot per panel; stiles and rails may or may not have any knots. Knots can be sliced, or 1/2 knots.

We assure that knotty grade knots will be stable.

CCDI does not grain match on any of our panels.

= In stock parts. Non-stock parts must be given 10 working days of lead time. For material that must be special ordered, the 10 days will start after we have received the material. Pricing will vary, call for quotes.

Stains include; bacteria, iron, water and sticker.

* Open knots must be sound

Except in Premium grade, specs in panel, stile/rail and edge profiles can be more tolerant than the rest of the part

Updated:

8/2/2004

Alder specifications for all door components				
	Standard grade		Knotty grade	
	Face	Back	Face	Back
Air check	yes, repaired	yes, repaired	yes, repaired	yes, repaired
Bark pockets	yes, must be sound	yes	yes, must be sound	yes
Bird peck	4/sq. ft.	yes	4/sq. ft.	yes
Colors accepted	2-10	all	all	all
Color match rule	skip two rule	no rule	no rule	no rule
Incipient rot	no	yes	no	yes
Knots, open *	no	1/2", 2/sf max	yes, can't see through	yes
Knots, pin	4/sq. ft.	yes	no limit	yes
Knots, sound	no	1/2", 2/sf max	3" max. diameter	yes
Mineral streaks	1/8"x2", 2/sq. ft.	yes	1/8"x2", 2/sq. ft.	yes
Pitch pockets	no	yes	no	yes
Stains (see below)	no	yes, not to edges	no	yes, not to edges
Worm holes	no	yes	no	yes
Worm tracks	no	yes	no	yes
Minimum stave width	2.375", no more than 4 per panel		1.5", no more than 4 per panel	

Pine specifications for all door components				
	Standard (knotty) grade		Clear	
	Face	Back	Face	Back
Air check	yes, repaired	yes, repaired	yes, repaired	yes
Bark pockets	yes	yes, repaired	yes	yes
Colors accepted	all	all	all	all
Color match rule	no rule	no rule	no rule	no rule
Incipient rot	no	yes	no	yes
Knots, open *	yes, can't see through	yes	no	1/2", 2/sf max
Knots, pin	yes	yes	4/sq. ft.	yes
Knots, sound	5" max. diameter	yes	no	yes
Mineral streaks	yes	yes	yes	yes
Pitch pockets	yes	yes	yes	yes
Stains (see below)	no	yes	no	yes, not to edges
Worm holes	no	yes	no	yes
Worm tracks	yes	yes	yes	yes
Minimum stave width	2.375", no more than 4 per panel		2.375", no more than 4 per panel	

Note: All knotty grades will have a minimum of one knot per panel; stiles and rails may or may not have any knots. Knots can be sliced, or 1/2 knots.

We assure that knotty grade knots will be stable. There are no size limitations.

CCDI does not grain match on any of our panels.

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Stains include; bacteria, iron, water and sticker.

* Open knots must be sound

Except in Premium grade, specs in panel, stile/rail and edge profiles can be more tolerant than the rest of the part

Updated:

8/2/2004

	Birch specifications for all door components					
	Premium grade (white)		Natural (color blend)		Red birch	
	Face	Back	Face	Back	Face	Back
Air check	yes, repaired	yes, repaired	yes, repaired	yes, repaired	yes, repaired	yes, repaired
Bark pockets	no	yes	yes, must be sound	yes	no	yes
Bird peck	no	yes	1/sq.ft.	yes	no	yes
Colors accepted	1-6	all	all	all	7-8	all
Color match rule	skip 1 rule	no rule	color blend	no rule	skip zero rule	no rule
Flecking	max. 20/sq. ft.	yes	yes	yes	n/a	n/a
Incipient rot	no	yes	yes	yes	no	yes
Knots, open *	no	no	no	1/2", 2/sf max	no	no
Knots, pin	4/sf. blend color w/door	yes	2/sq. ft.	yes	1/sq. ft.	yes
Knots, sound	no	no	1/4" max., 2/sq. ft.	1/2", 2/sf max	no	no
Mineral streaks	1/8x2", 1/sq. ft.	yes	yes	yes	yes	yes
Pitch pockets	no	yes	yes, must be sound	yes	no	yes
Stains (see below)	no	yes, not to edges	no	yes, not to edges	no	yes, not to edges
Worm holes	no	yes, repaired	yes, repaired	yes	no	yes, repaired
Worm tracks	4/sq. ft. 2" max. length	yes	yes, not spongy	yes	4/sq. ft.	yes
Minimum stave width	2.375", no more than 2 per panel		2.375", no more than 4 per panel		2.375", no more than 4 per panel	
	Standard grade					
	Face	Back				
Air check	yes, repaired	yes, repaired				
Bark pockets	1/8x2", 1/sq. ft.	1 per 2 sq. ft.				
Bird peck	no	no limit				
Colors accepted	1-6	all				
Color match rule	skip three rule	no rule				
Flecking	max. 30/sq. ft.	no limit				
Incipient rot	no	no limit				
Knots, open *	no	1/2", 2/sf max				
Knots, pin	2/sq. ft.	no limit				
Knots, sound	no	1/2", 2/sf max				
Mineral streaks	1/8x4", 1/sq. ft.	no limit				
Pitch pockets	1/8x4", 1/sq. ft.	no				
Stains (see below)	no	yes, not to edges				
Worm holes	no	yes, repaired				
Worm tracks	8/sq. ft. 2" max. length	no limit				
Minimum stave width	2.375", no more than 4 per panel					

Note: All knotty grades will have a minimum of one knot per panel; stiles and rails may or may not have any knots. Knots can be sliced, or 1/2 knots.

We assure that knotty grade knots will be stable. There are no size limitations.

CCDI does not grain match on any of our panels.

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Stains include; bacteria, iron, water and sticker.

* Open knots must be sound

Except in Premium grade, specs in panel, stile/rail and edge profiles can be more tolerant than the rest of the part

Updated: 8/2/2004

Specifications for all assembled face frame components

	Standard red oak		Knotty red oak		Standard hard maple	
	Face	Back ~	Face	Back ~	Face	Back~
Air check	yes, repaired	yes	yes, repaired	yes	yes, repaired	yes
Bark pockets	no	yes	yes	yes	no	yes
Bird peck	yes	yes	yes	yes	no	yes
Colors accepted	all	all	all	all	1-6	all
Color match rule	skip two rule	no rule	no rule	no rule	skip two rule	no rule
Incipient rot	no	yes	no	yes	no	yes
Knots, open *	no	yes	yes	yes	no	yes
Knots, pin	yes	yes	yes	yes	yes	yes
Knots, sound	yes, 1/4" diam. one/piece	yes	yes	yes	no	yes
Mineral streaks	yes, 1/8x2", one/piece	yes	yes	yes	yes, 1/8x2", one/piece	yes
Pitch pockets	no	yes	yes	yes	no	yes
Stain (see below)	no	yes	no	yes	no	yes
Worm holes	no	yes	no	yes	no	yes
Worm tracks	no	yes	yes	yes	no	yes
	Knotty hard maple		Standard cherry		Knotty cherry	
	Face	Back ~	Face	Back ~	Face	Back ~
Air check	yes, repaired	yes	yes, repaired	yes	yes, repaired	yes
Bark pockets	yes	yes	no	yes	yes	yes
Bird peck	yes	yes	yes	yes	yes	yes
Colors accepted	all	all	2-10	all	all	all
Color match rule	no rule	no rule	skip two rule	no rule	no rule	no rule
Incipient rot	no	yes	no	yes	no	yes
Knots, open *	yes	yes	no	yes	yes	yes
Knots, pin	yes	yes	yes	yes	yes	yes
Knots, sound	yes	yes	no	yes	yes	yes
Mineral streaks	yes	yes	yes, 1/8x2", one/piece	yes	yes	yes
Pitch pockets	yes	yes	yes, 1/8x1", one/piece	yes	yes	yes
Stains (see below)	no	yes	no	yes	no	yes
Worm holes	no	yes	no	yes	no	yes
Worm tracks	yes	yes	yes	yes	yes	yes

~ Back sides can have defects and/or characteristics so long as they don't interfere with the face side.

= In stock parts. Non-stock parts must be given 10 working days of lead time. For material that must be special ordered, the 10 days will start after we have received the material. Pricing will vary, call for quotes.

Stains include; bacteria, iron, water and sticker.

* Open knots must be sound

Specifications for all assembled face frame components

	Standard hickory		Rustic hickory		Paint grade	
	Face	Back	Face	Back	Face	Back
Air check	yes, repaired	yes	yes, repaired	yes	yes, repaired	yes
Bark pockets	yes, 1/8x4", one/piece	yes	yes	yes	yes, sound or repaired	yes
Bird peck	yes, 4/piece	yes	yes	yes	yes	yes
Colors accepted	all	all	all	all	all	all
Color match rule	no rule	no rule	no rule	no rule	no rule	no rule
Incipient rot	no	yes	no	yes	yes	yes
Knots, open *	no	yes	no	yes	yes, repaired	yes
Knots, pin	yes	yes	yes	yes	yes	yes
Knots, sound	yes, 1/piece, 1/4" max.	yes	yes	yes	yes	yes
Mineral streaks	yes, 1/8x4", one/piece	yes	yes	yes	yes	yes
Pitch pockets	yes, 1/8x4", one/piece	yes	yes	yes	yes, sound or repaired	yes
Stains (see below)	no	yes	yes	yes	yes	yes
Worm holes	no	yes	yes	yes	yes, sound or repaired	yes
Worm tracks	yes	yes	yes	yes	yes	yes
	Standard alder		Knotty alder		Pine	
	Face	Back	Face	Back	Face	Back
Air check	yes, repaired	yes	yes, repaired	yes	yes, repaired	yes
Bark pockets	yes, 1/8x2", one/piece	yes	yes	yes	yes	yes
Bird peck	yes	yes	yes	yes	yes	yes
Colors accepted	all	all	all	all	all	all
Color match rule	no rule	no rule	no rule	no rule	no rule	no rule
Incipient rot	no	yes	no	yes	no	yes
Knots, open *	no	yes	yes	yes	yes	yes
Knots, pin	yes	yes	yes	yes	yes	yes
Knots, sound	no	yes	yes	yes	yes	yes
Mineral streaks	yes, 1/8x2", one/piece	yes	yes	yes	yes	yes
Pitch pockets	yes, 1/8x2", one/piece	yes	yes	yes	yes	yes
Stains (see below)	no	yes	no	yes	no	yes
Worm holes	no	yes	yes	yes	no	yes
Worm tracks	yes	yes	yes	yes	yes	yes

* knots on knotty face frames must be solid so as not to affect the stability of the components. Open knots must be solid so as to not see through.

~ Back sides can have defects and/or characteristics so long as they don't interfere with the face side.

☐ = In stock parts. Non-stock parts must be given 10 working days of lead time. For material that must be special ordered, the 10 days will start after we have received the material. Pricing will vary, call for quotes.

Stains include; bacteria, iron, water and sticker.

^ Open knots must be sound

Specifications for all mouldings, random length S4S and face frame

	Red oak		Hard maple		Cherry	
	Face	Back	Face	Back	Face	Back
Air check	yes	yes	yes	yes	yes	yes
Bark pockets	no	yes	no	yes	no	yes
Bird peck	yes	yes	yes	yes	yes	yes
Colors accepted	2-8	all	1-4	all	2-8	all
Incipient rot	no	yes	no	yes	no	yes
Knots, open *	no	yes	no	yes	no	yes
Knots, pin	yes	yes	yes	yes	yes	yes
Knots, sound	1/8" max., 1/ two lf.	yes	no	yes	no	yes
Mineral streaks	yes, 1/8x2", 1/lf.	yes	yes, 1/8x2", 1/lf.	yes	yes, 1/8x2", 1/lf.	yes
Pitch pockets	no	yes	no	yes	yes, 1/8x1", 1/lf.	yes
Stains (see below)	no	yes	no	yes	no	yes
Worm holes	no	yes	no	yes	no	yes
Worm tracks	yes	yes	yes	yes	yes	yes
	Hickory		Pine		Birch	
	Face	Back	Face	Back	Face	Back
Air check	yes	yes	yes	yes	yes	yes
Bark pockets	yes, 1/lineal ft.	yes	no	yes	no	yes
Bird peck	yes	yes	no	yes	yes	yes
Colors accepted	all	all	all	all	1-3	all
Incipient rot	no	yes	no	yes	no	yes
Knots, open *	no	yes	yes	yes	no	yes
Knots, pin	yes	yes	yes	yes	yes	yes
Knots, sound	yes	yes	yes	yes	no	yes
Mineral streaks	yes	yes	yes	yes	yes, 1/8x2", 1/lf.	yes
Pitch pockets	yes	yes	yes	yes	no	yes
Stains (see below)	no	yes	no	yes	no	yes
Worm holes	no	yes	no	yes	no	yes
Worm tracks	yes	yes	yes	yes	yes	yes

Note: Parts ordered in random length form can have a maximum of 2 defects* per 8 foot piece. Parts ordered to a specific length will be defect-free.

Stains include; bacteria, iron, water and sticker.

* Open knots must be sound

Glossary of Terms and Abbreviations

Advanced Rot-Rot that has advanced to the stage where it is soft and punky. Typically this is always a defect.

Air Check-A small separation of wood fibers that occurs along the grain and results from stresses set up during the wood drying process. Typically these are not defects if repaired.

Arch Shape - Any type of arch-like shape cut into a rail or panel, as when building doors.

Back - The bottom surface of a door, drawer front, moulding, face frame, drawer side, component, or stave; typically backsides are graded differently than the front face.

Bark - Rough, corky protective layer on the outside surface of trees and shrubs. Typically if left on finished product this is a defect.

Bark Pocket – A bark-filled blemish in the board. This may or may not be a defect, depending on the finished grade.

Bird Peck – A patch of distorted grain resulting from birds pecking through the growing cells in the tree and sometimes containing a hole and/or ingrown bark. This may or may not be a defect, depending on the finished grade.

Bird's Eye - Small areas in wood fiber or in the grain pattern that are contorted to form small circular figures that resemble birds' eyes. Typically this isn't considered a defect.

Blank - A board or piece of lumber cut to size and defect free in the rough mill that is ready for machining.

Board Foot - A unit of measurement used in woodworking that is equal to one square foot. Typically measured as one inch thick, twelve inches wide and twelve inches long (1"x12"x12"). This is typically how sales and productivity are measured.

Bow - One of many terms used to describe a warp in lumber. This may be a defect in wood products, depending on the severity and customers' requirement.

Burly Grain - A distortion of wood grain, resulting in a curly or wavy appearance. Typically this isn't a defect.

Cabinet Door - Any type of door located on a kitchen, utility or bathroom cabinet.

Cathedral Shape - Any type of arch shaped into a rail or panel.

Characteristic - Any deviation from totally clear wood, such as knot, wormhole, or mineral streak. Characteristics may or may not be considered defects, consult the Customer Specification Book.

Check - See “Air Check”.

Chop – To cross cut a board, usually in the process of removing characteristics or defects.

Chop saw – A type of saw used to chop or cross cut.

Clear – Wood that is free from knots or other characteristics.

Climb Cut – A cutting process in which the rotation of a cutting head is turning in the same direction as the piece of wood is traveling.

Closed Knot (also called tight knot) – Closed knots have a flat face with no openings in the lumber surface. There isn't a size limitation.

Color blend – A color matching rule, whereby the colors will vary in the wood (such as in hickory or red birch), and a pleasing blend must be done versus an actual match.

Component – A constituent part, usually of a cabinet or assembled face frame.

Cope – To cut a shape or profile into a piece of wood, typically but not always, on the ends of the piece.

Corner Blend – The matching of the lineal and end grain profiled area, typically on a profiled panel or assembled door.

Cross Cut – Any cut made across or perpendicular to the direction of the wood grain.

Cross-grain scratches – Scratches made by the sanding process when sanding across the grain of the wood. These are typically considered defects unless removed by hand sanding.

Cutting Head – A tool or device to which knives are attached, and is used to cut a shape or profile into a wood piece.

Dado – A rectangular groove cut in wood across the grain.

Defect – A wood characteristic considered undesirable.

Door Assembly Clamp – A machine that clamps and fastens together a cabinet door or face frame.

Drag Marks – Marks on door parts or panels caused by poor handling of parts through the various workstations. Caused by not picking up the piece on top completely, but dragging it across the piece underneath it.

Drawer End – The front and back components of an interior drawer box.

Drawer Front – The face of the cabinet drawer, which is seen at all times

Drawer Side – The side components of an interior drawer box.

Dry Rot – Decay of wood tissue resulting in wood fiber that can be easily crushed and has a dry, powdery texture. Typically this is always a defect.

Dust Collection – A plant-wide system to remove sawdust from individual work centers by suction and collecting it in a central location.

Efficiency – The ratio of useful output to total input; typically used to determine productivity rates.

End Grain – Wood grains seen on the end of a board where a crosscut has been made.

End Checking – Air checks or cracking that extends from the inner area of a blank or stave to the end of the blank or stave. This is typically a defect.

Equalize – To cut a board to exact length and squareness.

Fall Off – A rip or cutting not applied to a specific order that is used to maximize yield.

Face – The top surface and four edges of a door, drawer front, moulding, face frame, drawer side, component or stave; typically face sides are graded differently than back sides.

Face Frame – The framework at the front of a cabinet to which the doors are mounted.

Face Laminate – Two or more boards being glued together on the face side instead of at the edges.

Feathering - Excess wood slivers at the ends of rails caused by cope set-up and feed speeds.

Feed Speed – The rate at which a piece of wood moves through a machine; usually measured in lineal feet per minute.

Finished Size – The dimension of the fully machine part according to customer specifications or requirements.

Finished Goods – Packaged material ready for shipment to the customers.

Flat Sanding – To sand either face of a panel, door or other component, usually on a wide belt sander, to a specified grit according to customer needs.

Fleck, or Flecking – These are spots or marks on the surface of wood (usually birch) caused by irregularities in the grain or by irrelevant matter; very similar to worm tracking. Depending on the amount, this may or may not be a defect.

Fluorescent Stain – A stain in the wood, which is only visible with the aid of a black light. Typically this isn't a defect.

FPM (Feet per Minute) – Measurement of the operating rate of a machine.

Frequency Gluer – A gluing machine that uses radio frequency waves to cure and dry the glue. It will achieve this in a matter of just a few minutes.

Gang Saw – Any saw (usually used for ripping) that is equipped with two or more saw blades and makes several cuts simultaneously.

Gluer, or Clamp Carrier – A large clamping machine that applies glue and clamps the wood pieces (staves) together until the glue dries.

Grain – The direction, size, arrangement or appearance of wood fibers and growth rings.

Grinding – 1) To shape, sharpen or refine by using friction to remove material from tooling. Typically this process is used in the grinding or tool room or, 2) Grinding of waste wood scraps, to create chips for ease of collection.

Grit – The tiny abrasive particles that are components of sandpaper.

Groover – A type of cutter that resembles a large or thick saw blade, used to cut a groove in a wood piece.

Growth Ring – The annual production of wood by a tree, consisting of springwood and summerwood.

Hand Shaper – A machine that cuts or shapes a pattern into a wood piece and is fed or operated by hand.

Hardwood – A type of tree that has broad leaves that are shed each fall; has no reference to the density of the wood itself.

Heartwood – The wood extending from the center of the tree to the sapwood; typically heartwood is darker than sapwood.

Hog – 1) To shred or pulverize scrap wood pieces to a uniform consistency, or 2) a machine that does the grinding, shredding and pulverizing of the wood.

Hook Angle – The difference between the angle at which a knife is inserted into a cutterhead and the radius of that cutterhead.

Honeycomb – Large checks or other deteriorations of wood fibers in the center of a board. Typically these are so severe as to cause the wood to be un-usable.

Incipient Rot – Early stages of rot identified by a slight discoloration or bleaching of the wood. Typically this is not a defect, so long as it is on the backside of parts.

Jig – Any device used for holding or guiding a wood piece as it is fed into a tool or machine. Typically used on shapers, or other smaller hand operated machines.

Joint Fit – The machined fit of the stile and rail on an assembled face frame or door.

Kiln Dried – Wood that has had the moisture removed in a kiln for the purpose of improving its usefulness and serviceability.

Knife Marks – Tooling marks left on profiled areas caused by the cutting action of the knife. Used to determine the quality of the finish.

Knives – Pieces of steel or carbide that are inserted into a cutterhead used to cut wood.

Knot – A portion of a branch or limb surrounded by solid wood.

Knot Cluster – A grouping of knots.

Lineal – Refers to length or along the direction of a grain.

Lineal Foot or Feet - Measurement of length in feet.

Lockout – Safety procedure to insure that air, electrical, hydraulic or any other potential power or energy cannot reach the machine during maintenance or set up.

Lumber – Boards that have been sawn off of a log, to be used for building as in cabinets.

Lumber Code – A four-part abbreviation showing lumber thickness, grade and specie that can be found on lumber when brought into the plant.

Lumber Grade – A classification of the quality of the lumber. The higher the grade, the clearer the lumber; the lower the grade, the more knots or other characteristics.

Machining – To cut, shape or finish a part by machine.

Machining Allowance – The amount of excess material removed in the machining process to attain customer quality and size requirements. It is the difference between rough and finish size.

Machining Tolerance – The amount of variance above or below a given dimension, allowable under the terms of various standards.

Material Handling – Method to move stock from one place to another.

Mid-rail – Horizontal face frame or door component used in the middle of such product.

Mineral Streak – A discoloration of the wood caused by minerals taken up by the tree from the soil. Mineral streaks are typically darker than the surrounding wood. These may or may not be a defect, depending on the customers' specifications.

Miter – An end cut of a piece of wood usually at a 45-degree angle.

Miter Saw – Machine used to do miter cuts.

Mortise – A slot cut into a board used to receive a tenon from another board.

Moulder – Machine used to cut a lineal shape or profile into a piece of wood.

Mullion – Vertical face frame or door component used in the middle of such product. May also be called a center stile.

Open Grain – When wood fibers and growth rings are more open than typical. Causes stain color variations.

Open Knot – Knots with open areas on the surface of lumber. These may or may not be defects, depending on the customer's specifications and/or grade required.

Optimizer – A computer driven chop saw that takes the optimum cuttings out of each board, keeping yield as the foremost criteria.

PO Number (Purchase Order Number) – Number used in production to identify and track specific orders.

Packaging – Process used to wrap and band wood parts together for shipping.

Paint Grade – Lumber used primarily for being painted; not any specific specie. Grade varies between customers, but will typically be a normally undesirable color.

Panel – 1) Center part of a cabinet door, or 2) a single, specific product.

Pieces or Piece Count – The actual number of individual parts.

Pin Knot – Knots that are very small and tight, usually smaller than 1/8" in diameter. Typically not a defect, depending on the amount in a certain area.

Pitch Pocket – Openings that run parallel to the growth rings containing resin (usually in cherry). Depending on customers' specifications, these may or may not be a defect.

Pitch Streak – Surface discolorations caused by pitch in wood; no void is visible. Depending on customers' specifications, these may or may not be a defect.

Pith – The small, soft core occurring in the center of a tree, branch, twig or log.

Planer – Machines used to surface or finish either face of a board.

Platen – A piece of heavy felt, wrapped with graphite-impregnated cloth, used to maintain steady down pressure on the sanders.

Power Cut – Rotation of a cutting head so the direction that the knives move through a wood piece in the opposite as the direction in which the piece is traveling.

Production (Productivity) – The act or process of manufacturing a product. How plant efficiencies are measured.

Profile – A shape or pattern cut into a wood piece.

Profile Sanding – To sand a profile by forming the sandpaper to the specific shape or pattern desired.

Rabbet – a groove near the edge of a piece of wood that allows another piece to fit into it to form a joint.

Random Length – Lengths of wood of no specific length, but within a given range of lengths (2-8' long, etc.).

Rail – Any horizontal piece of a cabinet door or face frame.

Re-Rip – To saw wood a second time along the grain to remove characteristics, or to improve the sawn edge, or to obtain a more suitable narrower width.

Rip – To saw wood along or in the direction of the grain.

Roll Case – A system or racks with rollers on them used to move product through the plant, from workstation to workstation.

Rough Size – The dimension of the part in the plant or rough mill.

Route – A groove or pattern machined into either face of a component; typically these grooves do not start or end at the edge or end of a piece of wood.

RPM (Revolutions Per Minute) – A measurement of the speed or rotation of a motor or shaft.

S2S – Abbreviation for “surfaced two sides”; where wood has been planed or moulded on the two face sides to a specific dimension, but the edges have not been given a machined finish, and may or may not have specific dimensions given for the width.

S3S – Abbreviation for “surfaced three sides”; where wood has been planed or moulded on the two faces, and one edge has been cut straight with a saw or moulder, but the other edge has not been cut, therefore no specific width dimension is given or needed.

S4S – Abbreviation for “surfaced four sides”; where wood has been planed or moulded on all four sides to specific dimensions.

Sand Scratch – The texture or appearance of wood after it has been sanded that was caused by the sandpaper grit.

Sanding – To polish or scour with sandpaper.

Sanding Grit – The size of the individual abrasive particles on sandpaper; common range for woodworking is from 280 grit (very fine) to 40 grit (very coarse).

Sapwood – The wood extending from the heartwood to the bark. This is lighter colored than the heartwood.

Score – A pre-cut made with a saw blade to prevent wood fiber tear out or chipping during the final cut. Typically this is done on a tenoner.

Set Up – To arrange or assemble a machine or its components to produce a product to customer specifications.

Shake – A separation of wood along the grain, the greater part of which occurs between the annual growth ring. This is typically always a defect.

Shrink Wrap – A plastic packaging film used to secure parts to each other and the pallet they are stacked on.

Shrink Wrap Machine – A packaging machine that stretches shrink wrap so that it will shrink and form to the finished product for protection from shipping damage.

Skid – A pallet on which wood pieces are stacked, and is suited for moving to and from various areas of the plant; also suitable for shipping.

Skip – Area of a board or component that has not been cut cleanly, and the rough face of the lumber shows through.

Skip One Rule – When color matching for gluing purposes, or when pre-assembling a door; two parts joining together can skip one color number (example, you can put a #3 with a #5, but not a #2 with a #5).

Skip Two Rule – Same as the “Skip one rule”, except that you can skip over two color numbers (you can place a #2 next to a #5).

Skip Zero Rule – Same as the “Skip one rule”, except that no color numbers can be skipped (you may put a #3 next to a #4, but can’t put a #3 with a #5).

Snipe – A deeper than desired cut made in a piece of wood, typically at the end of a board. Caused by improper set up or machine parts being out of line.

Softwood – A type of tree that has needle-like or scale-like leaves that are retained year-round; has no reference to the density of the wood.

Sound – A term used to describe the stability of wood and characteristics such as knots; sound meaning the wood or characteristic is solid, with no loose defects that will break apart during the machining process.

Sound Knot – A knot that is solid across its face, is as hard as the surrounding wood, and shows no sign of decay. Depending on customers’ specifications, this may or may not be a defect. It also has no size limitations.

Stain – 1) Areas of discoloration that alter wood properties. These may or may not be considered defects. They’re caused by mineral (mineral stain), chemical reaction in the wood (sticker or water stain), foreign matter in the wood (iron stain), or bacteria (bacteria stain), or 2) a colored liquid used to enhance, and give color to, wood products.

Stave – One individual piece of wood that is glued together with others to make up a panel.

Sticker – Strips of boards used to separate the layers of lumber in a pile to improve air circulation in the drying process.

Sticker Stain – A discoloration that develops in a board where it has been in contact with a sticker; occurs during the drying process. This is typically a defect on the face side of parts, but not on the backside.

Stile – Any vertical piece of a cabinet door or face frame. Does not include the panel.

Straight-Line Rip Saw – A machine designed to rip a board one edge at a time into various widths.

Tabbing – Excess wood tab at the end of rails caused by cope set up and/or feed speeds.

Tear-out – Chipping or tearing of wood fibers caused by improper cutting techniques such as dull tooling, incorrect feed speed, or improper tools. Can also happen where the grain patterns change abruptly. If the tear-out is light and can be sanded out this isn't a defect. If it's too deep to be able to sand out, then it is considered a defect.

Template – A pattern or gauge, often a thin plate, used in making or duplicating something, such as cutting knives.

Tenon – A tongue or projection on a piece of wood, shaped for insertion into a mortise.

Tenoner – A machine that cuts tenons or other shaper into wood pieces, either on the end grain or the lineal grain.

Tiger Striping – A distortion of grain in a piece of wood resulting in a wavy, striped appearance. Typically this is not a defect.

Tooling – Any cutting tool used to produce wood products; includes but not limited to saw blades, cutting knives, cutter heads.

Transition Stave – One stave with two or more colors that fall outside of the skip one rule. Typically seen in hickory and red birch. A stave that is used for “blending” colors in a panel (see “color blend”).

Unsound Knot – A knot with a portion that is readily removable, and may include areas of decay. Depending on customers' specifications and the grade, this may be a defect.

Vertical Grain – Wood that is sawn so that the flat surface is at a right angle to the growth rings.

Wane – Bark, or lack of wood, along the edge of a board. Depending how it is used, this may or may not be a defect, but is always a defect on finished product.

Warp – Any variation from a straight or true surface; includes bow, cup, twist and crook. This may be a defect, depending on the severity, and customers' requirements.

Waste – Also called scrap, this is unuseful wood that is typically thrown away.

Work Center – A machine center or group of machines that function as a unit or in a similar manner.

Wormholes – Small, round holes in wood caused by wood boring insects. Typically if repaired, these will not be a defect, unless there are numerous holes in one area.

Worm Tracking – Areas where a worm had traveled in the tree, but did not leave an open wormhole. If the tracking isn't soft and spongy, and there aren't numerous tracks in one area, this may not be a defect. This also depends on the grade of the product.

Yield – The percentage of usable product left after all machining processes.