Cabinet Construction

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Cabinet Materials

General

- True frameless method of construction: full-overlay doors, fully-concealed hinges, no face frame, and vertical borings at 32mm increments.
- Cabinet materials are 5/8"-thick, furniture-grade, medium-density, particleboard laminated on both sides with thermoset melamine. Particleboard is certified as EPP Environmentally Preferred Panels by the Composite Wood Council. All Plywood Construction is an option for cabinets with Wood doors.
- All cabinet connections (except backs) are wooden dowels and glue. Backs are rabbet-and-groove, glued and pin-nailed.
- Shelves are 5/8" thick, edgebanded front and back, full-depth and adjustable, with steel shelf pegs unless otherwise noted.
- Vertical stretchers are doweled to the front and back of the bottom of Base and Vanity cabinets. The front stretcher is set back 1mm from the toe kick notch and 1/4" off the floor. The back stretcher is set back 18mm (3/4") from the back cabinet edge and 1/4" off the floor.
- Horizontal stretchers are doweled to the front and back of Base and Vanity cabinets. The front stretcher is set flush with the face and top edge of the end panels. The back stretcher is set flush with the top of the end panels and captures the back.
- Cabinets 42" and wider (except cabinets with doors prepared for glass and sink base cabinets) and all 24" deep cabinets 39" and wider, have a center support stile. Center support stiles are 1" x 1¼" (1¼" x 2½" in blind base cabinets). Cabinets with Wood door styles have center stiles in coordinated wood veneer. Cabinets with Melamine, Thermofoil, Metal and Acrilux door styles have center stiles in white or neutral woodgrain melamine.

Cabinet Interiors and Exteriors

- See Program Summary on pages D1.7-D1.13.
- Standard cabinet case is finished in white or neutral woodgrain melamine.
- Coordinated finished backs, bottoms and tops are not available, use optional paneling.
- Finished Exterior Ends are available for exposed ends only and must be specified. (See Program Summary charts for Finished Ends material.)
- Finished Interiors are an available option and must be specified. Finished Interiors are available only in finishes coordinated to the cabinet exterior.

Edgebanding

Cabinets feature matte PVC edgebanding. The top, bottom, and back of each cabinet and the front and back of each shelf are edgebanded in neutral woodgrain or white PVC. The face exposed edges of all cabinets are edgebanded in coordinated PVC edgebanding.

Edgebanding exceptions: Cabinets with exposed wood veneer interiors feature coordinated wood veneer edgebanding. Cabinets with Acrilux door styles feature aluminum silver edgebanding on the front of the cabinet and the front and back of exposed cabinet shelving.

Fillers

All fillers may be scribed to accommodate exact openings. Fillers are shipped unassembled. All overlay fillers are designed to be applied flush with face of cabinet doors. They are profiled and door height. Sub-fillers are applied flush with cabinet front. Fillers for Cellini and Edison door styles are 5/8" thick and have an eased edge. Fillers for Brooklyn and Denver are 7/8" thick and have a tapered edge.

Heat Shields for Thermofoil Door Styles

Properly-installed heat shields (page D10.3) required or warranty is void. One set of white heat shields are shipped with every Thermofoil sink base ordered. Black heat shields are available upon request at time of order.

Toe Kick Cover

Toe kick cover material is not included and must be ordered as an accessory. See page D7.1.

Toe Kick Platform

All Tall cabinets are shipped with an unattached Toe Kick Platform. See page D7.1. Toe Kick Platforms are undersized to provide a recessed end.

Hinges

Standard hinges are fully-concealed, 107°, clip-on, steel, self-closing, spring-loaded and can be individually adjusted six ways (at least 2mm each direction) to ensure accurate door alignment. See page D1.5. Doors automatically close when within 10° of the cabinet. Optional free-swinging hinges are used on most cabinets with touch latches. Certain corner wall and base cabinets use a 170° hinge. Optional soft-close pistons are available to clip onto the hinge to reduce door-closing noise. Hinges carry a lifetime manufacturer's warranty.

Drawers & Pull-outs

Drawers are available in Wood Dovetail Drawer or Metal Drawer systems. Which ever system is selected must be used on the entire cabinet, mixing drawer systems is not allowed. Drawer glide systems carry a lifetime manufacturer's warranty.

Wood Dovetail Drawer with Soft Close is standard on cabinets with all door styles except Acrilux. Natural-finish, solid wood drawer box. Drawer front, sides, and back are 5/8" thick with dovetail joinery at each corner. Drawer bottom is 1/4" thick and fully-captured. Full-extension, tandem, undermount glide system with Soft Close allows smooth and silent closing, Drawer glides are rated to 75 pounds active load. Soft Close is only available on drawers in cabinets 12", 15", 18", 21" and 24" deep.

Drawer fronts are secured to the Wood Dovetail Drawer box with either two adjustable screws or metal fittings between the drawer front and drawer box. Final security of the drawer front to the drawer box is achieved with decorative hardware screws. If no hardware is used, fixing screws must be used.

Wood Dovetail Pull-outs are the standard pull-outs on cabinets with all door styles except Acrilux. Natural finish, solid wood drawer box. Front, sides, and back are 5/8" thick with dovetail joinery at each corner. Bottom is 1/4" thick and fully-captured. Glide system is Full-extension, tandem undermount glide with a 75-pound active load rating. Soft Close is available as an upgrade on cabinets 12", 15", 18", 21" and 24" deep.

Metal Drawer with Soft Close is the standard drawer system on cabinets with Acrilux door styles. It is an option for cabinets with all other door styles. The drawer box sides are gray steel. The drawer bottom and back are 5/8"-thick, gray melamine. It has a built-in, full-extension drawer glide and is available on drawers for cabinets 12", 15", 18", 21" and 24" deep. Drawer front is attached to metal drawer box sides with INSERTA brackets.

Metal Pull-outs with Soft Close are the standard pull-outs on cabinets with Acrilux door styles. They are an option for cabinets with all other door styles. Sides, front and back are gray steel. Bottom is 5/8"-thick, gray melamine. It has a built-in, full-extension drawer glide. Available on cabinets 12", 15", 18", 21" and 24" deep. Special widths are not available.

Drawer glide systems are detailed on page D1.6-D1.7.

Drawer fronts for all top drawers are 6⅛" in height unless otherwise noted.

Doors and Drawer Fronts

Door styles are available in Melamine, Thermofoil, Wood, Stainless Steel, Aluminum and Acrilux in thousands of color and finish combinations.

Melamine – A melamine resin is pressure- and heat-fused through a layer of color into 5/8"-thick, industrial-grade, particleboard. Melamine doors and drawer fronts are dimensionally stable, moisture resistant, and do not promote the growth of bacteria. Cabinets should be cleaned using a soft cloth (not paper towels) and a mild, non-abrasive cleanser and dried immediately. See Melamine Program Summary on page D1.7.

Thermofoil – Rigid thermofoil (RTF) doors are rigid vinyl heat-and-vacuum applied over a sculpted, 3/4"-thick, medium-density fiberboard (MDF) core. Cabinets should be cleaned using a soft cloth (not paper towels) and a mild, non-abrasive cleanser and dried immediately.

Thermofoils are susceptible to heat and may delaminate if exposed to heat generated from ovens or other countertop appliances. Factory-supplied Heat Shields must be properly installed flush to the face edge of the door on cabinets adjacent to ovens. Counter top appliances such as toaster ovens and coffee makers should be pulled forward on the countertop out from under the cabinetry before use. Radiant warming lamps should only be used with adequate ventilation to prevent damage to adjacent cabinetry. Damage caused by excessive heat is not covered by warranty. See Thermofoil Program Summary on page D1.9-D1.10.

Wood – Wood doors are 3/4"-thick and available in Oak, Rustic Alder, Maple, Rustic Cherry, Cherry, Red Birch, and Bamboo. Backs of Wood doors are stained to match the fronts but are not distressed, antiqued or glazed. Doors are manufactured of solid wood or veneers or a combination of both. Wood doors are manufactured using panel and frame construction. Door frames are made using mortise-and-tenon or mitered joining methods. Mitered doors are not recommended in areas of high humidity where climate controls are not always in use.

Some drawers 27" or wider have a double insert panel for stability. Long doors on tall cabinets also have a double insert panel to maintain panel stability. As with wood furniture, wood doors should be cleaned using a soft cloth (not paper towels) and a mild, non-abrasive cleanser and dried immediately. See Wood Program Summary on pages D1.11-D1.13.

Stainless Steel – 20-gauge, 304 stainless steel with a #4 brushed finish. Fronts and edges of doors are Stainless Steel, door backs are high pressure laminate. Fillers cannot be field cut without special tools and may be ordered in special sizes. Cabinets should be cleaned using a soft cloth (not paper towels) and a mild, non-abrasive cleanser and dried immediately. See Metal Program Summary on pages D1.8.

Aluminum – Commercial aluminum with a clear A-1 finish. Door is available in frame-style Aluminum only with opaque sandblasted glass or acrylic inset center panel. Acrylic center panel is susceptible to discoloration and should not be used above a range. Cabinets should be cleaned using a soft cloth (not paper towels) and a mild, non-abrasive cleanser and dried immediately. See Metal Program Summary on pages D1.8.

Acrilux – Constructed by laminating a sheet of acrylic or polyethylene terephthalate – both thermoplastic materials – to an MDF substrate. Acrilux is susceptible to scratching and should be cleaned using a soft cloth (not paper towels) and a mild, non-abrasive cleanser and dried immediately. See Acrilux Program Summary on page D1.7.

Wood Species Characteristics

Natural Wood Characteristics

All solid wood species are products of nature in which naturally-occurring variations in color, grain, pattern, textures, and density are unique and beautiful. Solid wood expands and contracts with fluctuations in temperature and humidity.

Oak – Light tan to brown heartwood, creamy white to gray sapwood. Very hard, dense, and heavy wood. Moderately open grain takes finish well. Oak is more resistant to effects of the environment.

Rustic Alder – A moderately light and slightly soft hardwood with color varying from white and light tan to pale, pinkish brown. Tight knots, pitch pockets, and character marks.

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Maple – Creamy white to off-white sapwood, tinged occasionally with slight red-brown heartwood. Very hard, heavy, and strong. Closed grain with uniform texture takes finish well. Maple is very resistant to abrasive wear.

Cherry – Red to deep reddish-brown heartwood, white to yellowish sapwood. Medium density and weight. Moderately hard, stiff, and strong. Fine closed grain. Takes a finish well, but light to natural finishes are recommended. Beautiful markings. Red color will darken to a rich, reddish-brown with age.

Rustic Cherry – All the characteristics of cherry but with even more natural beauty. Tight knots, pitch pockets, and character marks.

Red Birch – Light reddish-brown to pink heartwood, creamy white to yellowish sapwood. Hard wood, medium weight. Uniform, fine grain with small pores. Takes finish very well. Very durable and strong.

Bamboo – Neutral, natural blonde with beautiful growth patterns, grains, and growth joints unique to Bamboo. An eco-friendly, renewable and sustainable resource. Much harder than Oak and much more stable than most hardwoods. Takes stains well.

Natural variances are accommodated by constructing doors with strips of wood glued together, using stiles and rails to form a frame and letting a center panel float within the frame, or using wood veneers. Wood veneers are naturally beautiful, real wood, and have a more uniform appearance than solid wood without the expansion and contraction variances.

All woods will change in color due to exposure to sunlight and natural mellowing with age. Color changes are not noticeable from day to day but may be significant over a long period of time. This natural process can cause noticeable differences between product samples and finished cabinets especially on Cherry wood products. Exact color match with replacement parts is not guaranteed. Variations, within company standards, between samples and the cabinets received will not be reason for replacement.

Wood Finishes
All wood products undergo a multi-step process to achieve a high-quality, fine-furniture finish noted for its attractive, medium sheen. Wood doors can be finished with clear or solid stains or paints. Certain door styles do not lend themselves to certain finishes or finishing techniques. See wood finish program summary for availability

Painted Finish – The wood is primed and painted with solid color paint. Due to the inevitable movement of the wood joints the paint may show some cracking at the joints. This is not considered a defect

Distressed Finish – The wood is painted, randomly dented, sanded to reveal bare wood on edges and high points, and sealed with a clear top coat. Veneer door styles and accessory parts cannot be distressed Back of door is not distressed.

Antiqued Finish – The wood is painted, sanded to reveal bare wood on edges and high points, and sealed with a clear top coat. Back of door is not antiqued.

Glazed Finish – Glazing is a hand applied process and unique to each door. The wood is stained or painted, then distressed or antiqued if preferred. A glaze is applied and hand-rubbed away leaving it mainly in crevices in the door's design. A glaze is not a stain and will not obscure the natural characteristics of the wood. Back of door is not glazed.

Vintage Finish – The wood is primed and painted with a solid-color paint, then treated with an innovative blend of light glazing, rasping, rub-off, and worm holes, then sealed with a clear top coat. Back of door is painted without the Vintage treatment.

Vintage finishes are not recommended on all door styles. See page D1.11 for availability. We strongly recommend that a door sample be purchased before making your selection.

Due to natural variations of and environmental effects on wood species and finishes, a signed "Finish Awareness Form" must accompany all orders. See page U10.

Decorative Hardware

Decorative hardware is required and not included. See pages D10.7-D10.10. Care should be taken, to allow for clearance of adjacent cabinets, when using decorative hardware in corner applications.

In keeping with our policy of continuous refinement, we reserve the right to alter specifications, styles and finishes without general notice or obligation to make similar changes in previously-produced products.