

**Convex / Concave Product Radii**

WalzCraft offers all of the sizes listed below as standard radii for “Traditional”, “Mitered”, Raw MDF Style 500 and Veneered Style 60 Curved Products.

- All Radii are based on ¾" [19.1mm] thick doors.
- All Radii are calculated to the center of a ¾" [19.1mm] thick door.
- (\*) indicates the only radius options available for **Door Styles 20, 30, 2000, 2020, 2500, 2525, 3000, 3030, 3500, 3535, 4000, 5000.**  
(These door styles also have a maximum rail width of 23".)
- Please refer to **Sections E.9 - E.11** for Mitered/French Mitered Profile options available on Curved Products.
  - **C** = Profile available on Curved doors. **FM** = Profile available on French Miter doors.
  - Door styles **10FM** and **10FM\*** are only available in radii 12" and greater.

**D**

“Traditional” and “Mitered” Profiles	Radius In Inches	Radius In Millimeters	Minimum Chord Length	Maximum Chord Length
<i>Slab Door Only</i>	6	152.40	<i>Minimum Chord Lengths will be evaluated on a per order basis.</i>	<i>Half Circle</i>
3" [76.2mm] Increment Between Sizes	9	228.60		
	12 *	304.80		
	15	381.00		
	18 *	457.20		
	21	533.40		
	24 *	609.60		
	27	685.80		
	30	762.00		
	33	838.20		
	36	914.40		
	39	990.60		
	42	1066.80		
	45	1143.00		
	48	1219.20		
	51	1295.40		
	54	1371.60		
	57	1447.80		
	60	1525.00		
	63	1600.20		
	66	1676.40		
	69	1752.60		
72	1828.80			
75	1905.00			
78	1981.20			
81	2057.40			
84	2133.60			
87	2209.80			
90	2286.00			
93	2362.20			
96	2438.40			
12" [304.8mm] Increment Between Sizes	108	2743.20		<i>Quarter Circle</i>
	120	3048.00		
	132	3352.80		
	144	3657.60		
	156	3962.40		
	168	4267.20		
	180	4572.00		
192	4876.80			
204	5181.60			
216	5486.40			
228	5791.20			
24" [609.6mm] Increment Between Sizes	252	6400.80	<i>14 Feet</i>	
	276	7010.40		
	300	7620.00		
	324	8229.60		
	348	8839.20		
	372	9448.80		
	396	10058.40		
	420	10668.00		
	444	11277.60		
	468	11887.20		
492	12496.80			
516	13106.40			

► **For PRICING** ► See Section **D.1** in our current Wholesale Pricing Catalog.

**Ordering & Pricing Notes: Convex/Concave Products**

**Ordering Guidelines**

1	Order Forms	Please use one of the following order forms where applicable: <ul style="list-style-type: none"> <li>• <i>Curved Door Order Form (E•Z Form #11).</i></li> <li>• <i>Curved Drawer Front Order Form (E•Z Form #11.1)</i></li> <li>• <i>Assembled Curved Face Frame Order Form (E•Z Form #11.2).</i></li> <li>• <i>Curved Molding Order Form (E•Z Form #11.3).</i></li> </ul>
2	Gap Dimension	The following information must be noted when placing an order for curved products: <ul style="list-style-type: none"> <li>• The gap dimension between a pair of doors for Convex or Concave overlay.</li> <li>• The gap dimension between a door and face frame for Convex or Concave inset.</li> </ul>
<b>Pricing</b>		
1	Pricing	Please see <i>Section D.1</i> of our current <b>Wholesale Pricing Catalog</b> .

**Technical Notes: Convex/Concave Products**

**Cabinet Door & Drawer Front Options (Chapter B)**

1	Raised Panel Styles	Only available with styles <b>10, 10*, 10FM, 10FM*, 10M, 10M*, 20, 1000, 1010, 1010*, 1941, 2000, 2020, 2271, 2272, 2291L, 2291R, 2500, 2525, 4000, 8000 8020, 8030, 8045, 8050.</b> <ul style="list-style-type: none"> <li>• Vertical grain only.</li> <li>• Door Styles <b>20, 2000, 2020, 2500, 2525, 4000</b> are only available with a 12", 18" or 24" radius, have a maximum rail width of 23", and are not available with applied moldings.</li> <li>• Door styles <b>10FM, 10FM*</b> are only available in radii 12" or greater.</li> <li>• Frame only and mullion lite pattern options in these door styles are also available.                     <ul style="list-style-type: none"> <li>◦ Only available with the following lite pattern options: <b>LP001, LP108, LP109, LP110, LP118.</b></li> </ul> </li> </ul>
2	¼" Flat Panel Styles	Only available with styles <b>30, 40, 40*, 40FM, 40FM*, 40M, 40M*, 3000, 3030, 3271, 3272, 3291L, 3291R, 3500, 3535, 4020, 4030, 4040, 4040*, 4041, 4043, 4044, 4045, 4150, 5000.</b> <ul style="list-style-type: none"> <li>• Vertical or horizontal grain.</li> <li>• Door and drawer front styles with a ¼" flat center panel are only available in radii 12" or greater.</li> <li>• Door styles <b>30, 3000, 3030, 3500, 3535, 5000</b> are only available with a 12", 18" or 24" radius, have a maximum rail width of 23", and are not available with applied moldings.</li> <li>• Door styles <b>40FM, 40FM*</b> are only available in radii 12" or greater.</li> <li>• Frame only and mullion lite pattern options in these door styles are also available.                     <ul style="list-style-type: none"> <li>◦ Only available with the following lite pattern options: <b>LP001, LP108, LP109, LP110, LP118.</b></li> </ul> </li> </ul>
3	Solid Wood Slab Styles	Only available with styles <b>1270, 1270*, 34SQA* and 100SQE*.</b> <ul style="list-style-type: none"> <li>• Vertical grain only.</li> <li>• The radius may be affected by expansion, contraction and moisture issues.</li> <li>• <b>Style #1270</b> doors are constructed with <b>NO battens.</b></li> <li>• Convex/Concave solid wood slab styles will carry no warranty against warpage.</li> </ul>
4	Veneered MDF Slab Styles	Only available with styles <b>60 and 60*.</b> <ul style="list-style-type: none"> <li>• Vertical or horizontal grain.</li> <li>• Only available with Edgeband Treatment options <b>EBT201, EBT201-R, EBT401 and EBT401-R.</b></li> </ul>
5	Raw MDF Slab Styles	Only available with styles <b>500 and 500*.</b>

**Convex / Concave Options (Chapter D)**

1	Identifying Curved Products	This symbol  is used throughout the catalog to represent profiles and options that are available when ordering Convex/Concave Products.
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**Design Options (Chapter G)**

1	Center Panel Face Routing	All Center Panel Face Rout options are available, but limited to Convex products only.
	Decorative Inserts	The Butterfly Insert (BI100) is <i>not an option</i> for a Curved Product.

**Notes Continued on Next Page...**

► For PRICING ► See Section D.1 in our current Wholesale Pricing Catalog.

D

**Technical Notes: Convex/Concave Products...continued**

**Face Frame Options (Chapter J)**

<b>D</b>	<b>1 Face Frame Construction</b>	Convex/Concave Face Frames with a radius of 24" or greater will be constructed with Pocket Screw Joinery.
		Convex/Concave Face Frames with a radius under 24" will be constructed with Domino Tenon Joinery where all rails meet the stiles. <ul style="list-style-type: none"> <li>• Pocket Screw joinery will be used where center stiles meet the rails.</li> </ul>
		All Face Frame profile options ( <b>FS100-FS108</b> ) are available with assembled Convex/Concave face frames. Please see <b>Section J.1</b> for additional profile information.
		Convex/Concave face frames are not available Ready to Assemble ( <b>RTA</b> ).

**Finish Options (Chapter R)**

<b>1</b>	<b>3D Laminate (RTF)</b>	3D Laminate (RTF) is not an option for Curved Products.
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**Functional Options (Chapter F)**

<b>1</b>	<b>Hinge Boring</b>	Convex/Concave doors and drawer fronts are only available with <b>HBP100</b> . Please see <b>Section F.1</b> for additional hinge boring requirements, ordering instructions and compatibility.
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**General Information (Chapter A)**

<b>1</b>	<b>Standard and Non-Standard Part Sizes</b>	Stiles & Rails for doors, drawer fronts and face frames can be ordered from 1½" [38.1mm] wide to 4½" [114.3mm] wide, in ¼" [6.4mm] increments and will not be subject to additional charges. Stiles & Rails ordered in widths outside of these dimensions will incur a Non-Standard Part Size charge.
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**Profile Options**

<b>1</b>	<b>Center Panel Grain Direction Options</b>	WalzCraft prefers that <b>ALL convex/concave solid wood slabs and solid wood center panels</b> have a <b>vertical grain</b> direction, <b>including paint grades</b> , to help ensure quality and avoid any warping, cupping or twisting that may occur.
		Center panels with vertical grain are available in: <ul style="list-style-type: none"> <li>• ¼" [6.4mm] flat panel wood veneers</li> <li>• ⅝" [15.9mm] solid wood raised panels</li> <li>• ⅜" [9.5mm] <b>RVSCP-PR324 (Reversed Solid Center Panel)</b> Profile</li> </ul>
		<b>RVSCP-PR324</b> reversed center panels are also available in ⅜" [9.5mm] Raw MDF or MEDEX® NAUF - MDF, Raw.
		<b>Raw MDF is not an option</b> for any other ⅝" [15.9mm] solid wood raised center panel profile.
		¾" [19.1mm] thick, convex/concave raised panel doors using a ⅝" [15.9mm] thick profiled center panel, will have a center panel that is flush with the stiles and rails on the <b>face only</b> . <ul style="list-style-type: none"> <li>• The center panel will be recessed below the stiles and rails on the back side of the door.</li> </ul>
		<b>Horizontal grain</b> will only be available with: <ul style="list-style-type: none"> <li>• ¼" [6.4mm] Flat Panel wood veneer doors and drawer fronts.                         <ul style="list-style-type: none"> <li>◦ Only available for radii 12" [304.8mm] or greater.</li> <li>◦ Only available for arc lengths 31½" [800mm] or less.</li> <li>◦ Maximum interior visual opening height is 47½" [1197mm].</li> </ul> </li> <li>• <b>Style 60</b> Slab veneer doors</li> </ul>
<b>2</b>	<b>Pre-Finishing Options</b>	Finishing Options for convex/concave doors or drawer fronts with <b>Vertical</b> grain on the center panel: <ul style="list-style-type: none"> <li>• <b>Stain Pre-finishing</b></li> <li>• <b>Priming for Paint only</b></li> <li>• <b>SolidTone®</b> finish</li> <li>• <b>SolidTone® WoodGrain</b></li> </ul>
		Finishing Options for convex/concave doors or drawer fronts with <b>Horizontal</b> grain on the center panel: <ul style="list-style-type: none"> <li>• <b>Stain Pre-finishing</b></li> <li>• <b>SolidTone® WoodGrain</b></li> </ul>

**Notes Continued on Next Page...**

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*Technical Notes: Convex/Concave Products...continued*

**Sizes / Dimensions**

1	<b>Thickness</b>	Available in 3/4" [19.1mm], 1" [25.4mm], 1 1/8" [28.6mm] and 1 1/4" [31.8mm] thicknesses. Raw MDF or MEDEX® NAUF - MDF, Raw <b>Style 500</b> and <b>500*</b> are only available in a 3/4" [19.1mm] thickness.
2	<b>Door / Face Frame Maximum Height</b>	Maximum height for doors and face frames is 96" [2438.4mm].
3	<b>6" Radii</b>	Due to the small size of parts with a 6" radius, additional charges may be incurred to construct fixtures to hold parts, or to use alternate sanding and assembly methods.
4	<b>Maximum Rail Size</b>	The maximum rail height for Convex/Concave doors and drawer fronts is 13".

**D**

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