

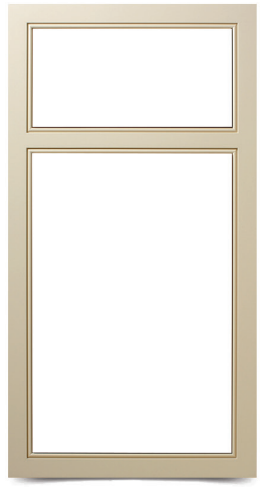
FF101 Face Frame Configuration
Constructed with FS100 Straight Stock





Face Frames With Inset Doors & Drawer Fronts
Precision Sized To Fit Openings

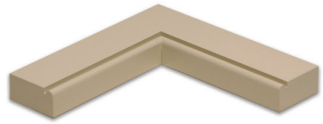
Signature Series Key:
S543 Integrity - Inset With FF101 (FS100)
S541 Carter - Inset With FF101 (FS101 & FS102)



FF101 Face Frame Configuration
Constructed with FS101 & FS102 Beaded Stock



FS100 Square Stock



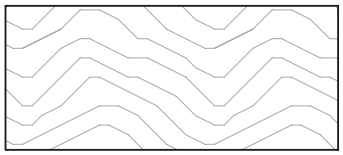
FS100 Beaded Stock

Chapter J Table of Contents

Section #	Section Name/Contents	Page #
J.1	Face Frame Stock	J.1.2
	◦ Face Frame Stock - Square	J.1.2
	◦ Face Frame Stock - Beveled	J.1.3
	◦ Face Frame Stock - Beaded	J.1.4
J.2	Assembled & Ready to Assemble (RTA)	J.2.1
	◦ Assembled & Ready to Assemble (RTA) Face Frames	J.2.1
	◦ Face Frame Joinery Options	J.2.1
	◦ Haunched Joints for Beaded Face Frames	J.2.2
	◦ Dado Groove Placement Guidelines for Face Frames	J.2.2
	◦ Cross-Grain Dadoes on Face Frames *(Not Recommended)*	J.2.3
	◦ Face Frame Configurations - Base & Upper	J.2.4
	◦ Face Frame Configurations - Base	J.2.5
	◦ Face Frame Configurations - Upper	J.2.9
	◦ Face Frame Configurations - Tall	J.2.10
	◦ Face Frame Configurations - Arched Top Face Frame Configurations	J.2.13
	◦ Face Frame Configurations - Inside & Outside Corner (Lazy Susan)	J.2.14
J.3	Face Frame Options - Square/Tapered Foot	J.3.1
J.4	Face Frame Options - Miscellaneous Joinery	J.4.1
J.5	Face Frame Options - Beaded Applied Molding	J.5.1
J.6	Face Frame Options - Inset/Pre-fit Doors	J.6.1
J.7	Face Frame Options - Blind Corner Extension	J.7.1
J.8	Cabinet Fillers - Square, Beaded	J.8.1

Face Frame Stock - Square

FS100	Face Frame Stock - Square



Ordering & Pricing Notes: Face Frame Stock - Square		
		Ordering Guidelines
1	**Order Forms**	Please use ***Face Frame Stock Order Form (E•Z Form #9)***.
		Pricing
1	**Pricing**	Please see ***Section J.1*** of our current **Wholesale Pricing Catalog**.

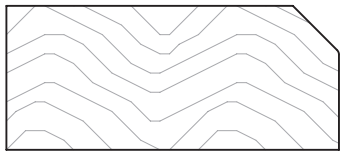
Technical Notes: Face Frame Stock - Square		
		Face Frame Options (Chapter J)
1	**FS100**	Square lineal stock run through a molder.
		Finish Options (Chapter R)
1	**Finishing**	Finishing is available.
		Face frame stock will be stained and sealed on the face, back and all edges, and top coated on the face and all edges.
2	**3D Laminate**	3D Laminate (RTF) face frame stock (**FS100** only) is made of a solid wood core (Maple - Paint Grade) and ***is not*** subject to the same thickness limitations as MDF.
		As a standard, WalzCraft will apply the 3D laminate material to the face and two long edges only. Not available with 3D Laminate on the ends.
		3D Laminate face frame stock is only available with a D33 outside edge profile on the two long edges.
		Sizes / Dimensions
1	**Thickness**	Square face frame stock made from solid wood is available in ½" [12.7mm], ⅝" [15.9mm], ¾" [19.1mm], ⅞" [22.2mm], 1" [25.4mm], 1⅛" [28.6mm] or 1¼" [31.8mm] thicknesses. • See ***Section S.3*** for possible thickness restrictions based on wood species.
2	**Width**	**FS100** Face Frame Stock is available in a minimum width of a ⅝" [15.9mm] and a maximum width of 9" [228.6mm].
		Minimum Width - Dimension for **FS100** face frame stock when used in assembled and ready to assemble (RTA) face frames with pocket screw joinery is ⅝" [15.9mm].
		Minimum Width - Dimension for **FS100** face frame stock when used in assembled and ready to assemble (RTA) face frames with domino tenon joinery is 1" [25.4mm].
		9" [228.6mm] Maximum Width: WalzCraft makes every attempt to produce these parts from one solid piece of wood. Due to lumber availability and/or wood species, widths under 9" [228.6mm] may need to be made from two or more edge glued pieces. For widths over 9" [228.6mm], please refer to our **GUPFS** product found in ***Section M.16***.
3	**Length**	Available in 8' [2438.4mm] Lengths, Cut to Length and Random Lengths. • Face frame stock with 3D Laminate is only available in 8' [2438.4mm] lengths (not available cut to length or in random lengths).
		The minimum length for Cut-to-Length pieces is 3" [76.2mm].
		Random length sizes vary between 36" [914.4mm] and 96" [2438.4mm] long. When measured, we round down to the next nearest ½ foot. Minimum quantity of 200 lineal feet.
		Solid wood face frame stock has a standard length of up to 96" [2438.4mm]. Lengths greater than 8' [2438.4mm] are subject to availability. *Please note that the choice of wood species and grade can impact the availability of lengths greater than 8' [2438.4mm].* • Lengths longer than 8' [2438.4mm] are not available for face frame stock with 3D Laminate.

Face Frame Stock - Square - END

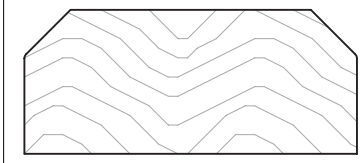
Face Frame Options

Face Frame Stock - Beveled

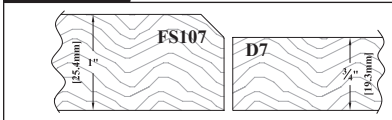
FS107 *Face Frame Stock - Beveled*



FS108 *Face Frame Stock - Beveled*



"Looks" *Inset Door / Face Frame*



• **1" Face Frame w/ ¾" Door**

Shown at ½ Scale



• **¾" Face Frame w/ ¾" Door**

Shown at ½ Scale

Ordering & Pricing Notes: Face Frame Stock - Beveled

		Ordering Guidelines
1	**Order Forms**	Please use ***Face Frame Stock Order Form (E•Z Form #9)***.
		Pricing
1	**Pricing**	Please see ***Section J.1*** of our current **Wholesale Pricing Catalog**.

Technical Notes: Face Frame Stock - Beveled

		Face Frame Options (Chapter J)
1	**Face Frame Stock - Beveled**	Beveled Face Frame Stock is used most often for assembled or ready to assemble (RTA) haunched face frames, with inset doors and drawer fronts.
		The beveled edge is incorporated on one or two sides.
		Finish Options (Chapter R)
1	**Finishing**	Finishing is available.
		Beveled Face Frame Stock will be stained and sealed on the face, back and all edges, and top coated on the face and all edges.
2	**3D Laminate**	Beveled Face Frame Stock is not available with 3D Laminate (RTF).
		Functional Options (Chapter F)
1	**Miscellaneous Joinery**	Miscellaneous Joinery options (*see illustrations in* ***Section F.2***) are only available on **FS107** where there is one side without a bevel.
		Joinery options will be added to the side of the product without a bevel.
		Profile Options (Chapter E)
1	**Additional Profiles Bevel Location**	An additional outside edge cannot be used on the beveled side.
		The bevel is not available on the ends.
		Sizes / Dimensions
1	**Thickness**	Beveled face frame stock made from solid wood is available in ¾" [19.1mm] and 1" [25.4mm] thicknesses. • See ***Section S.3*** for possible thickness restrictions based on wood species.
		¾" [19.1mm] Face Frames - Only available with ¾" [19.1mm] Doors & Drawer Fronts using **D24** Outside edge.
		1" [25.4mm] Face Frames - Only available with ¾" [19.1mm] Doors & Drawer Fronts using **D7** Outside edge.
2	**Width**	Beveled Face Frame stock is available in a minimum width of a 1" [25.4mm] and a maximum width of 9" [228.6mm].
		Minimum Width - Dimensions for beveled face frame stock when used in assembled and ready to assemble (RTA) face frames with pocket screw joinery: **FS107 =** 1" [25.4mm]**, FS108** = 1¼" [31.8mm].
		Minimum Width - Dimensions for beveled face frame stock when used in assembled and ready to assemble (RTA) face frames with domino tenon joinery: **FS107 =** 1⁵⁄₁₆" [33.3mm], **FS108** = 1⅝" [41.3mm]
		9" [228.6mm] Maximum Width: WalzCraft makes every attempt to produce these parts from one solid piece of wood. Due to lumber availability and/or wood species, widths under 9" [228.6mm] may need to be made from two or more edge glued pieces. For widths over 9" [228.6mm], please refer to our **GUPFS** product found in ***Section M.16***.

Continued on next page...

Technical Notes: Face Frame Stock - Beveled...continued		
Sizes / Dimensions...continued		
3	**Length**	Available in 8' [2438.4mm] Lengths, Cut-to-Length and Random Lengths.
		The minimum length for Cut-to-Length pieces is 3" [76.2mm].
		Random length sizes vary between 36" [914.4mm] and 96" [2438.4mm] long. When measured, we round down to the next nearest ½ foot. Minimum quantity of 200 lineal feet.
		Solid wood beveled face frame stock has a standard length of up to 96" [2438.4mm]. Lengths greater than 8' [2438.4mm] are subject to availability. *Please note that the choice of wood species and grade can impact the availability of lengths greater than 8' [2438.4mm].*
4	**Final Sizes**	Be sure to factor the size of the bevel into your overall face frame dimension. End view drawings are to scale.
5	**Bevel Width**	**FS107** and **FS108** use ¼" bevels.

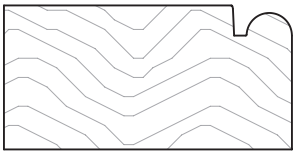
Face Frame Stock - Beveled - END

J

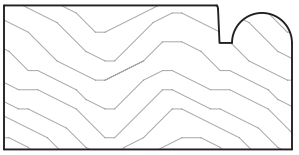
Face Frame Options

Face Frame Stock - Beaded

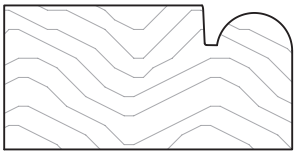
FS101 Face Frame Stock - Beaded



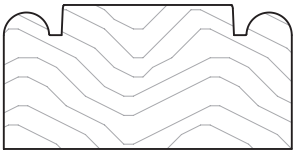
FS105 Face Frame Stock - Beaded



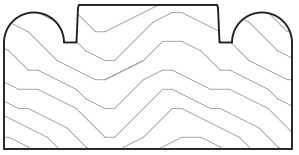
FS103 Face Frame Stock - Beaded



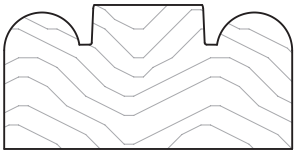
FS102 Face Frame Stock - Beaded



FS106 Face Frame Stock - Beaded



FS104 Face Frame Stock - Beaded



J

Ordering & Pricing Notes: Face Frame Stock - Beaded

		Ordering Guidelines
1	**Order Forms**	Please use ***Face Frame Stock Order Form (E•Z Form #9)***.
		Pricing
1	**Pricing**	Please see ***Section J.1*** of our current **Wholesale Pricing Catalog**.

Technical Notes: Face Frame Stock - Beaded

		Face Frame Options (Chapter J)
1	**Beaded Face Frame Stock Uses**	Beaded Face Frame Stock is used most often for assembled or ready to assemble (RTA) haunched face frames, with inset doors and drawer fronts.
		The beaded edge is incorporated on one or two sides.
		Beaded Face Frame Stock can also be used as base molding.
		Finish Options (Chapter R)
1	**Finishing**	Finishing is available.
		Beaded Face Frame Stock will be stained and sealed on the face, back and all edges, and top coated on the face and all edges.
2	**3D Laminate**	Beaded Face Frame Stock is not available with 3D Laminate (RTF).
		Functional Options (Chapter F)
1	**Miscellaneous Joinery**	Miscellaneous Joinery options (*see illustrations in* ***Section F.2***) are only available on **FS101, FS103** and **FS105** profiles where there is one side without a bead.
		Joinery options will be added to the side of the product without a bead.
		Profile Options (Chapter E)
1	**Additional Profiles Bead Location**	An additional outside edge cannot be used on the beaded side.
		The bead is not available on the ends.
		Sizes / Dimensions
1	**Thickness**	Beaded face frame stock made from solid wood is available in ¾" [19.1mm], ⅞" [22.2mm] , 1" [25.4mm], 1⅛" [28.6mm] or 1¼" [31.8mm] thicknesses. • See ***Section S.3*** for possible thickness restrictions based on wood species.

Continued on next page...

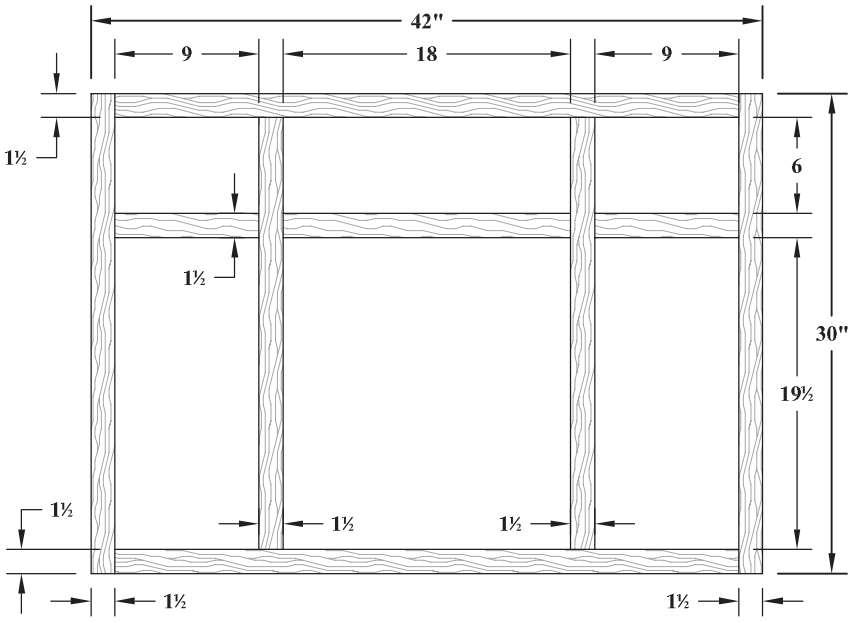
Technical Notes: Face Frame Stock - Beaded...continued		
Sizes / Dimensions...continued		
2	**Width**	Beaded face frame stock is available in a minimum width of 1" [25.4mm] and a maximum width of 9" [228.6mm].
		Minimum Width - Dimensions for beaded face frame stock when used in assembled and ready to assemble (RTA) face frames with pocket screw joinery: • **FS101 =** 1" [25.4mm] • **FS102** = 1¼" [31.8mm] • **FS103** = 1³⁄₃₂" [27.8mm] • **FS104** = 1⁹⁄₁₆" [39.7mm] • **FS105** = 1¹⁄₃₂" [25.8mm] • **FS106** = 1¹³⁄₃₂" [35.7mm]
		Minimum Width - Dimensions for beaded face frame stock when used in assembled and ready to assemble (RTA) face frames with domino tenon joinery: • **FS101 =** 1⅛" [29.6mm] • **FS102** = 1¼" [31.8mm] • **FS103** = 1⅛" [29.6mm] • **FS104** = 1⁹⁄₁₆" [39.7mm] • **FS105** = 1⅛" [29.6mm] • **FS106** = 1¹³⁄₃₂" [35.7mm]
		9" [228.6mm] Maximum Width: WalzCraft makes every attempt to produce these parts from one solid piece of wood. Due to lumber availability and / or wood species, widths under 9" [228.6mm] may need to be made from two or more edge glued pieces. For widths over 9" [228.6mm], please refer to our **GUPFS** product found in ***Section M.16***.
3	**Length**	Available in 8' [2438.4mm] Lengths, Cut-to-Length and Random Lengths.
		The minimum length for Cut-to-Length pieces is 3" [76.2mm].
		Random length sizes vary between 36" [914.4mm] and 96" [2438.4mm] long. When measured, we round down to the next nearest ½ foot. Minimum quantity of 200 lineal feet.
		Solid wood beaded face frame stock has a standard length of up to 96" [2438.4mm]. Lengths greater than 8' [2438.4mm] are subject to availability. *Please note that the choice of wood species and grade can impact the availability of lengths greater than 8' [2438.4mm].*
4	**Final Sizes**	Be sure to factor the size of the bead into your overall face frame dimension. End view drawings are to scale.
5	**Bead Width**	• **FS101, FS102** = ¼" • **FS105, FS106** = ⁵⁄₁₆" • **FS103, FS104** = ⅜"

Face Frame Stock - Beaded - END

J

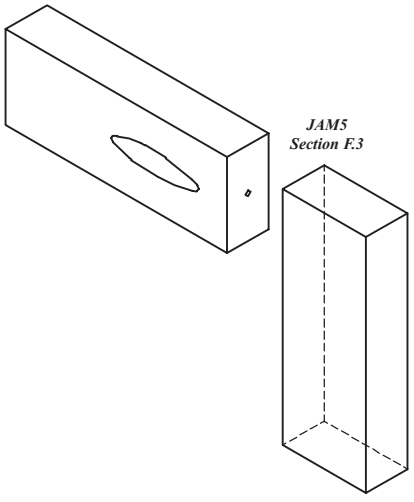
▶ **For PRICING** ▶ *See Section **J.1*** in our current Wholesale Pricing Catalog.

Assembled & Ready to Assemble (RTA) Face Frame



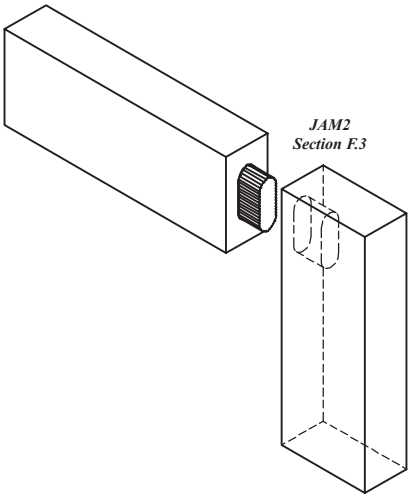
Face Frame Configuration FF179 shown.

Standard Face Frame Joinery - Pocket Screws



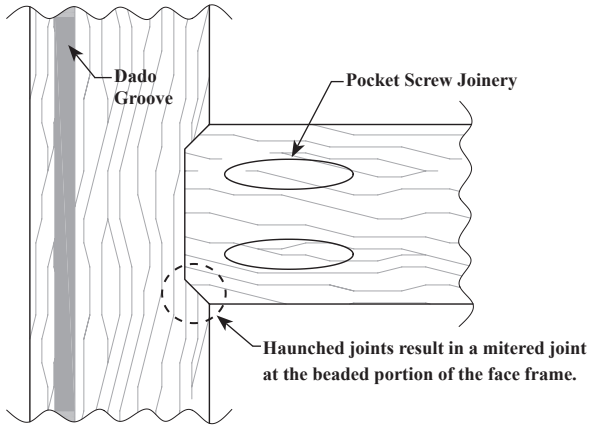
Pocket screws are WalzCraft's preferred method.

Optional Face Frame Joinery - Domino Tenons

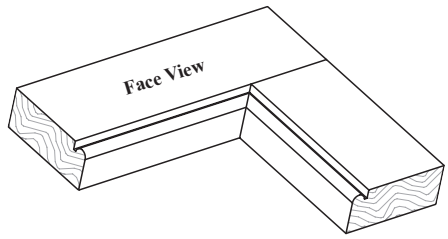


Continued on next page...

Haunched Joint for Beaded Face Frame (FS101 - FS108)

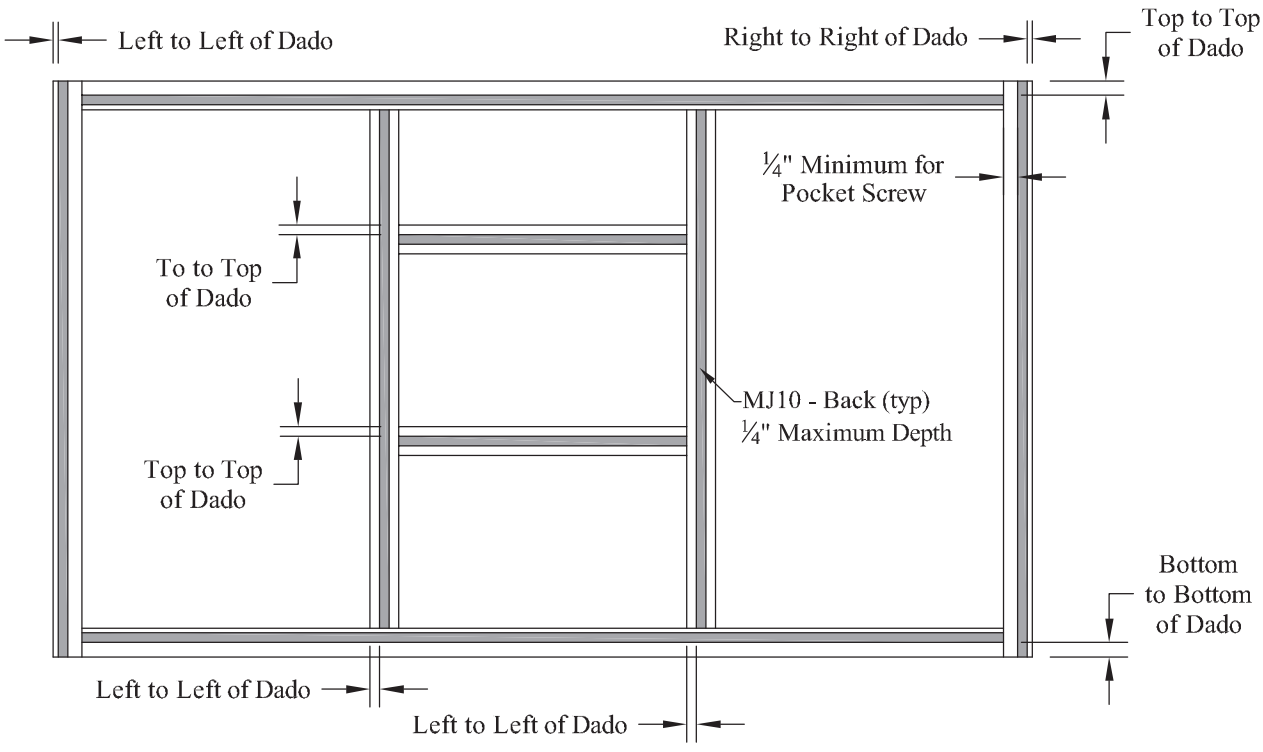


Example of assembled face frame components utilizing beaded face frame stock FS101.



Dado Groove Placement Guidelines for Face Frames

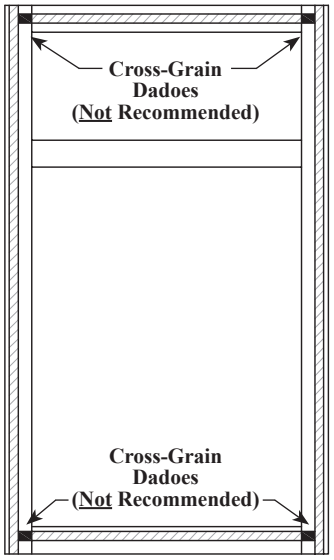
- **Dimensions required for dado placement.**
- **View from back side of face frame.**



Face Frame Configuration FF204 shown.

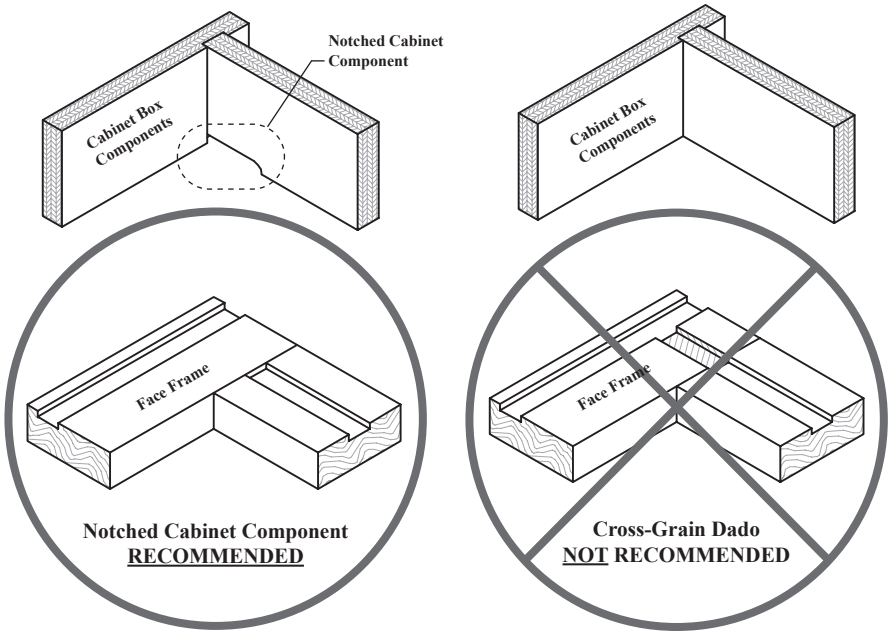
Continued on next page...

Cross-Grain Dadoes on Face Frames (Not Recommended)



Dadoes on Face Frames

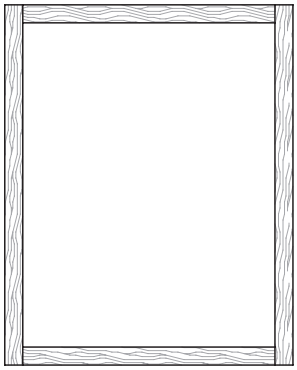
On occasion, we have customers asking WalzCraft to supply face frames with cross-grain dadoes on the stiles as shown in the drawing. Over time, WalzCraft has learned that it is far more efficient to simply notch the horizontal cabinet component. Doing so eliminates the costly and potentially unsafe practice of trying to accurately machine a cross-grain dado on a small part. WalzCraft has recommended the "notching method" to customers in the past, and has also successfully built cabinets for in house purposes using this method. Please consider this method when requesting face frames with dadoes.



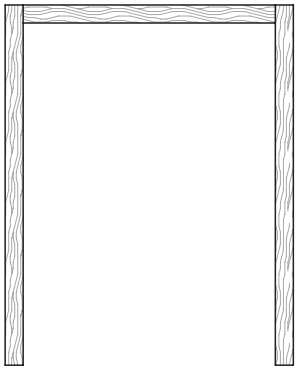
Continued on next page...

J

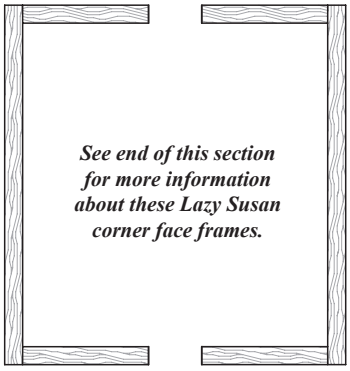
Typical Base or Upper Cabinet Face Frame Configurations



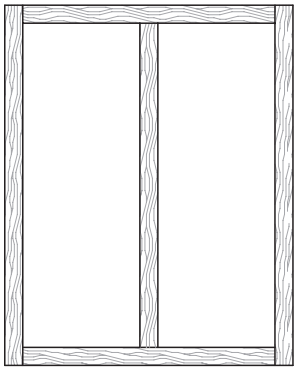
FF100



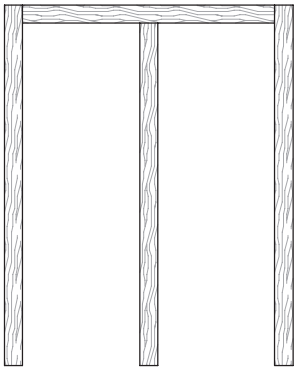
FF109



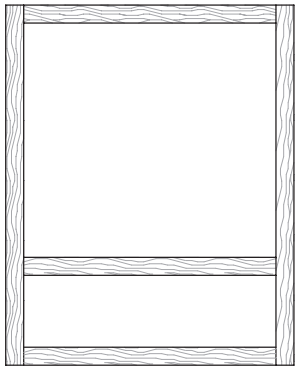
FF111 **FF112**



FF106



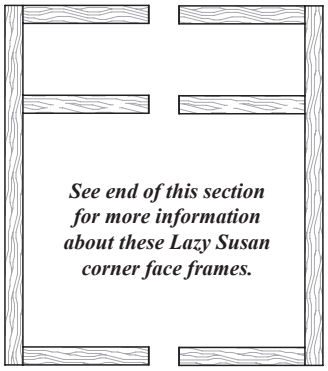
FF129



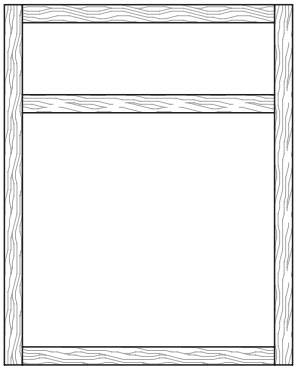
FF296

Continued on next page...

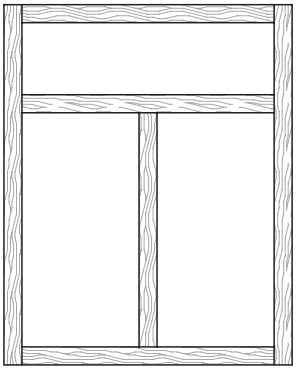
Typical Base Cabinet Face Frame Configurations



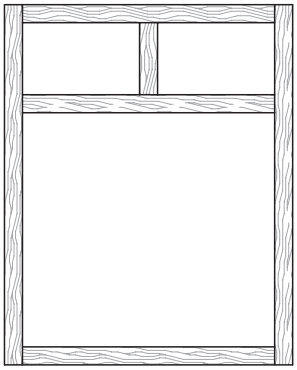
FF113 **FF114**



FF101

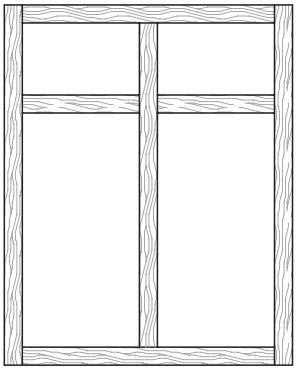


FF107

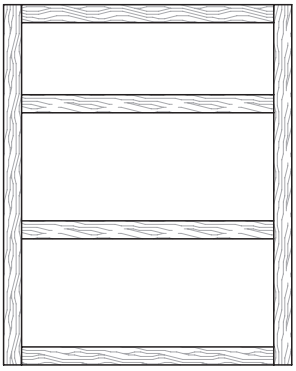


FF105

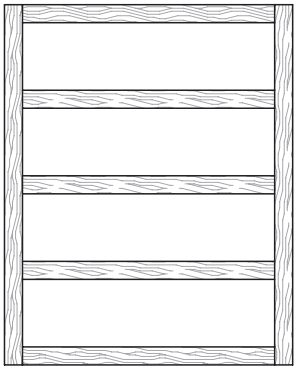
J



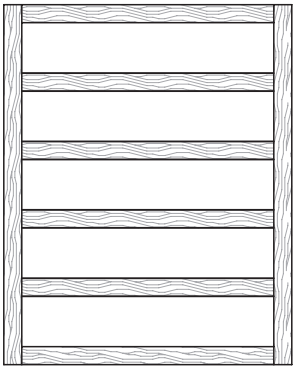
FF108



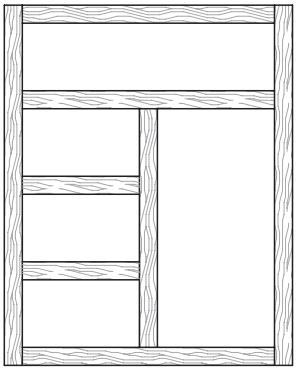
FF103



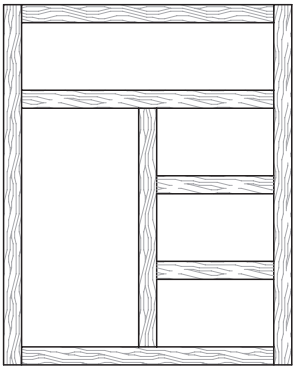
FF104



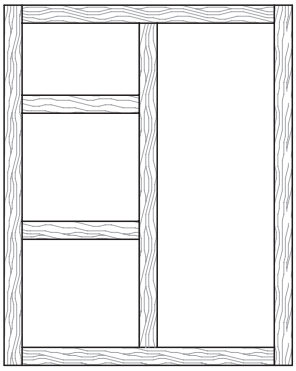
FF123



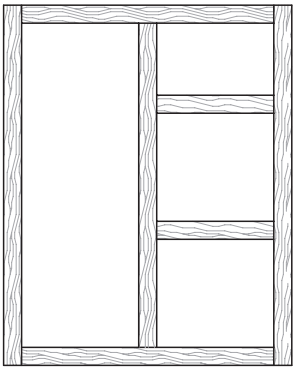
FF168



FF169



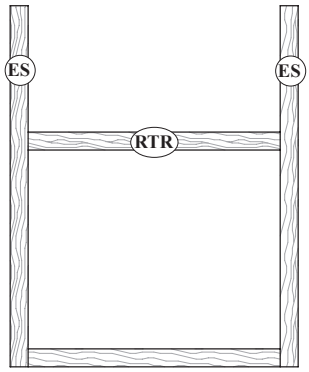
FF141



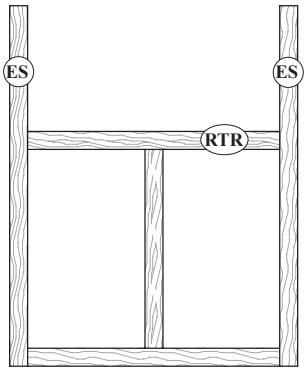
FF142

Continued on next page...

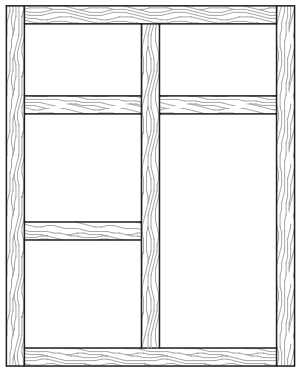
Typical Base Cabinet Face Frame Configurations



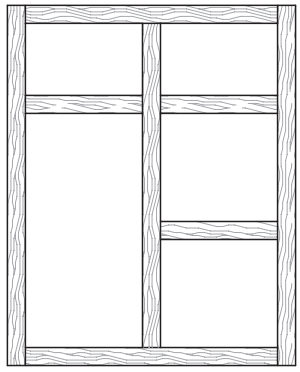
FF269



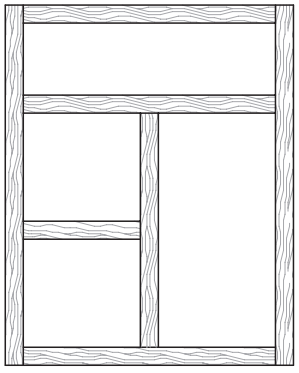
FF137



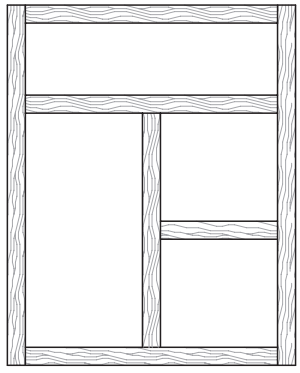
FF144



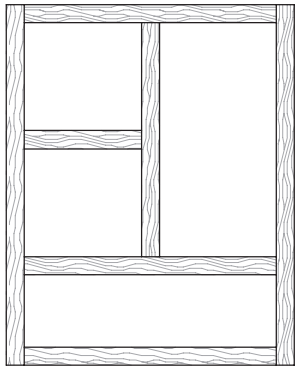
FF145



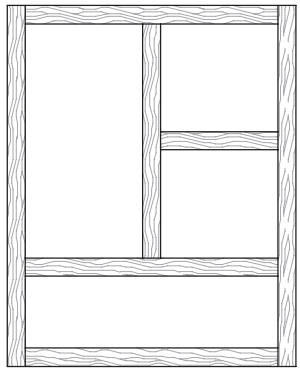
FF147



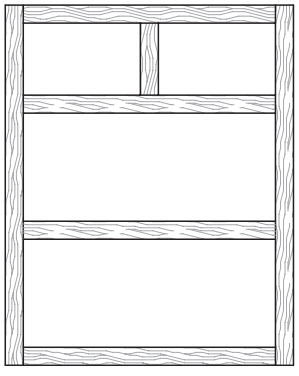
FF148



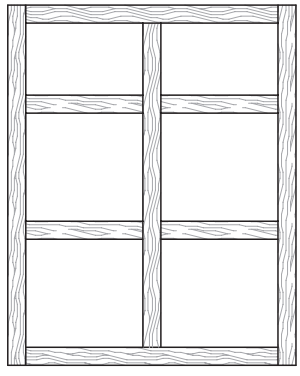
FF156



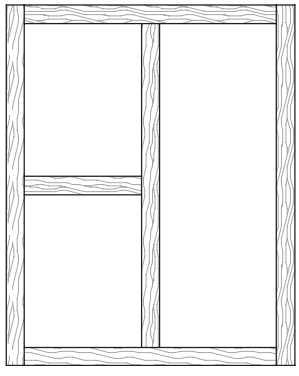
FF157



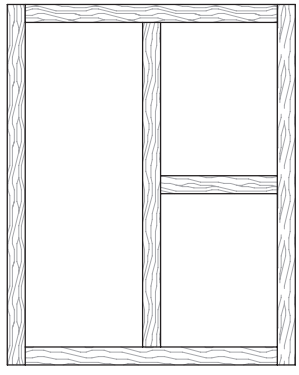
FF158



FF140



FF135

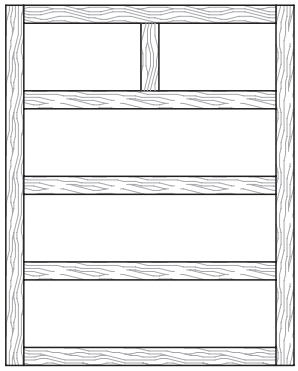


FF136

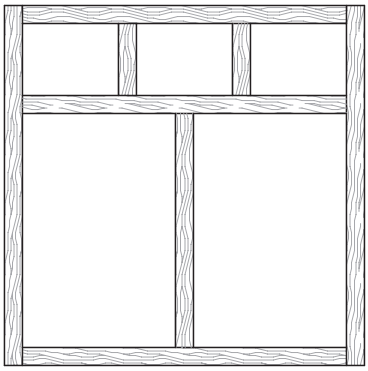
J

Continued on next page...

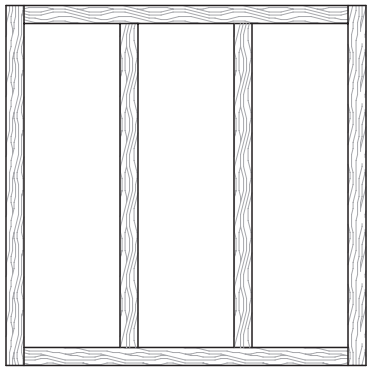
Typical Base Cabinet Face Frame Configurations



FF170

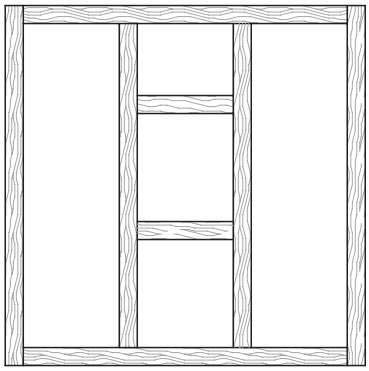


FF184

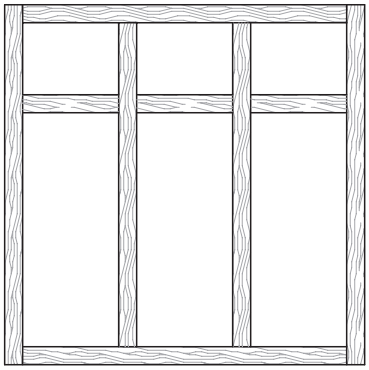


FF176

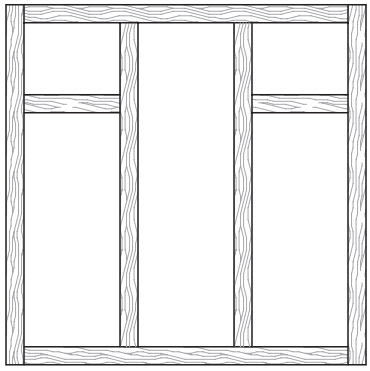
J



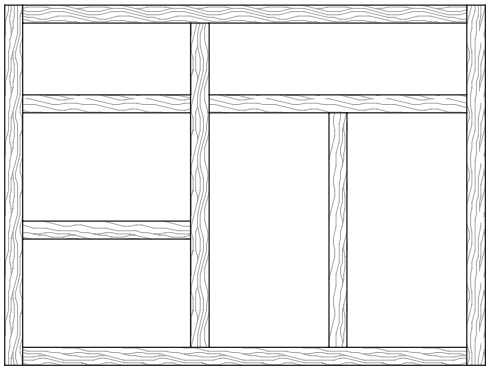
FF204



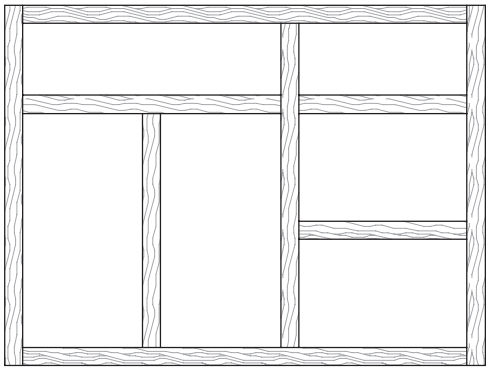
FF179



FF180



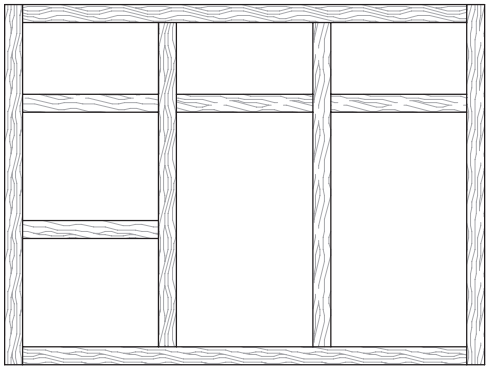
FF213



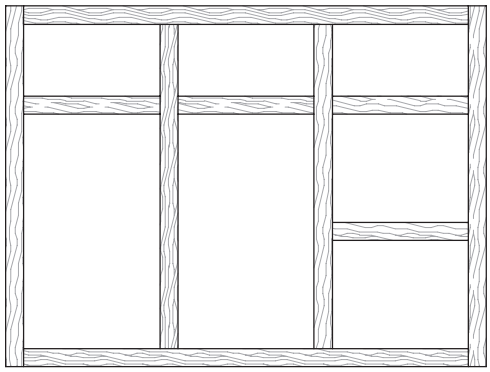
FF214

Continued on next page...

Typical Base Cabinet Face Frame Configurations

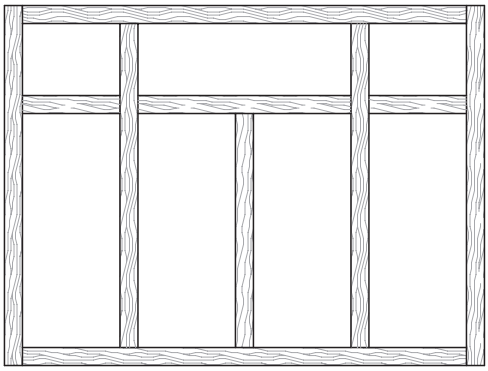


FF202

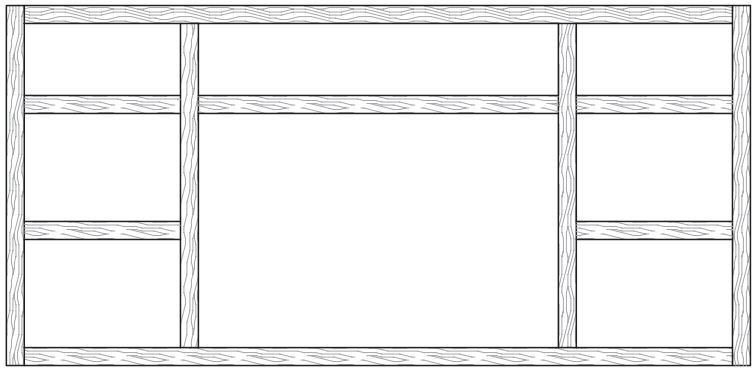


FF203

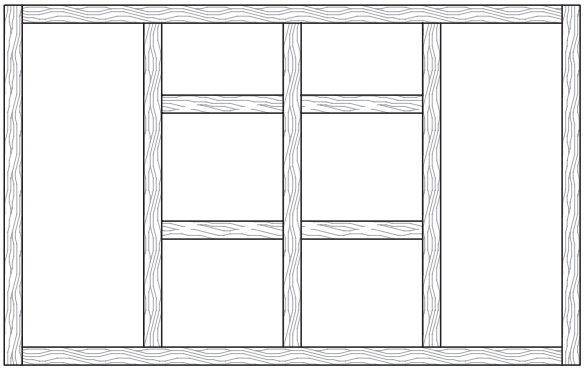
J



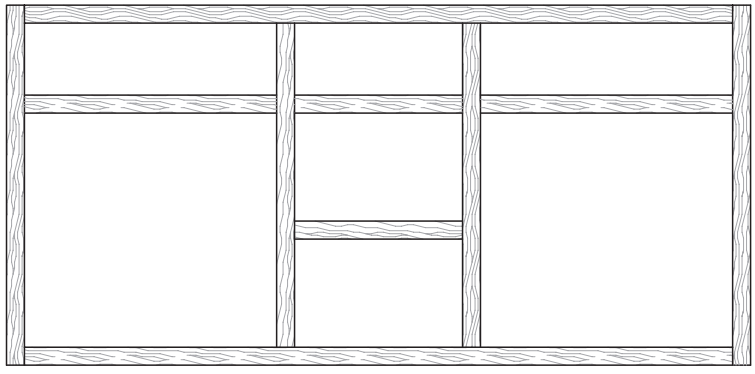
FF242



FF199



FF255

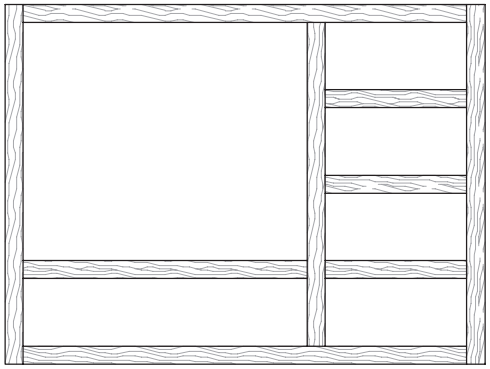


FF200

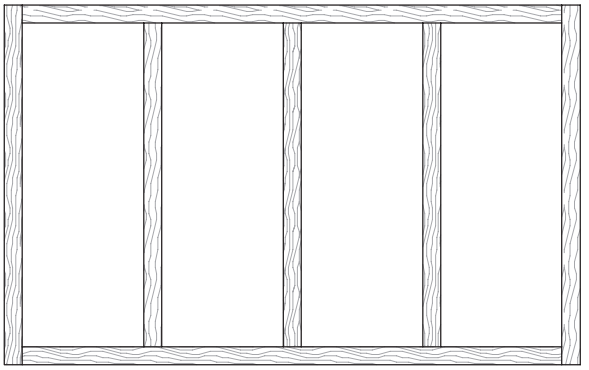
Continued on next page...

▶ **For PRICING** ▶ *See Section **J.2*** in our current Wholesale Pricing Catalog.

Typical Base Cabinet Face Frame Configurations



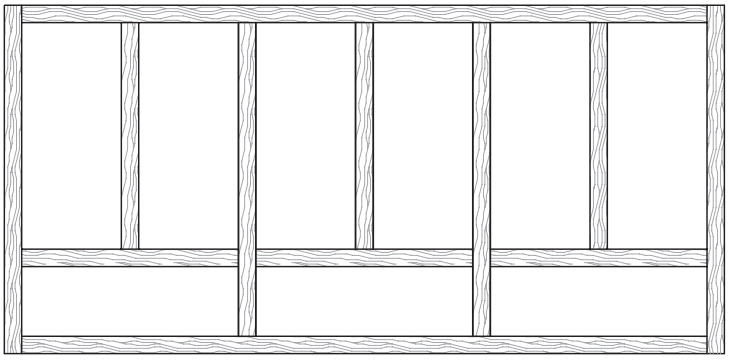
FF301



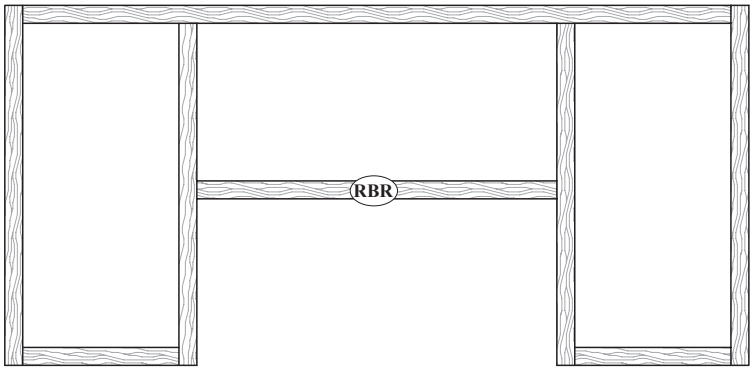
FF302

J

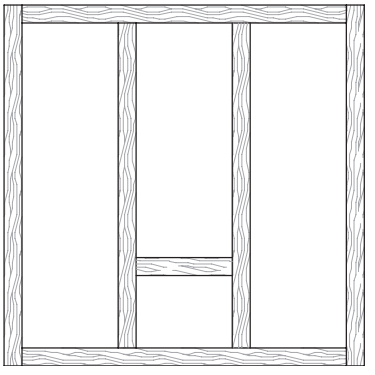
Typical Upper Cabinet Face Frame Configurations



FF294



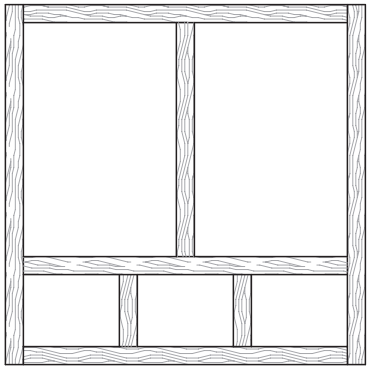
FF196



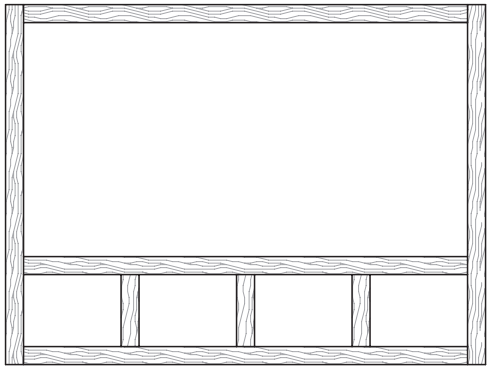
FF295

Continued on next page...

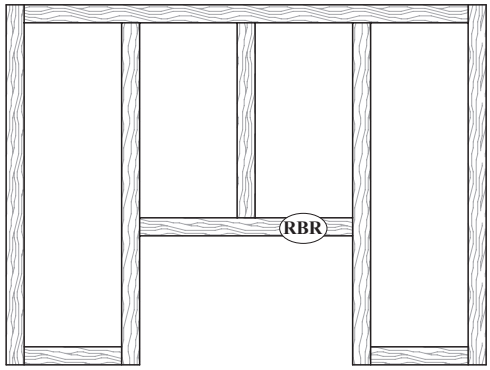
Typical Upper Cabinet Face Frame Configurations



FF187



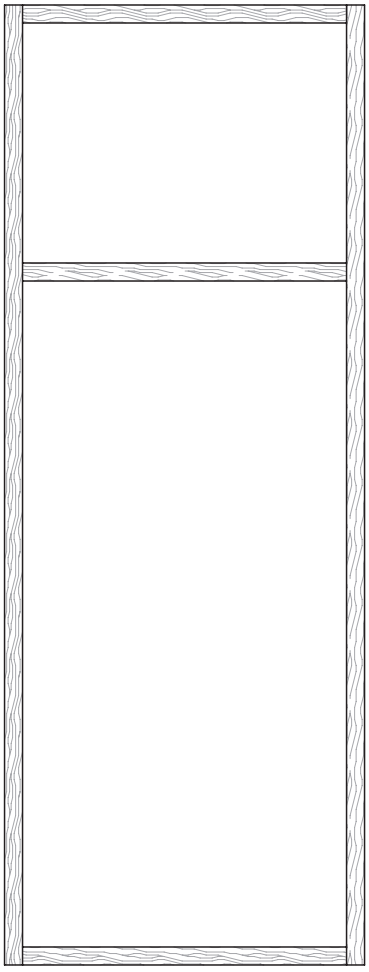
FF249



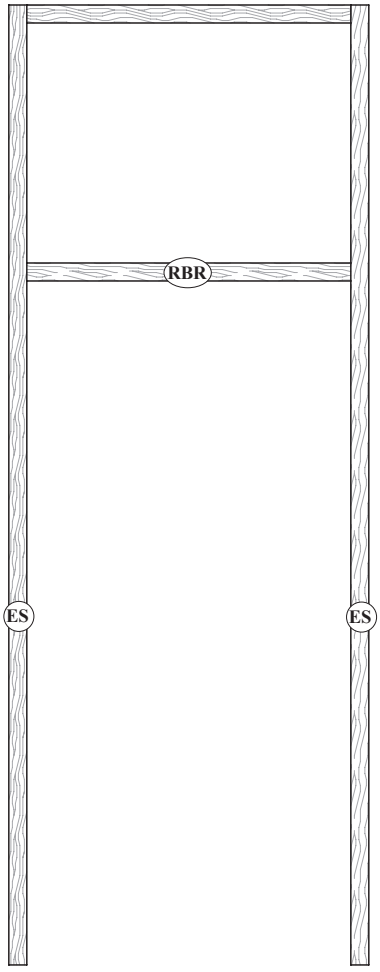
FF250

Typical Tall Cabinet Face Frame Configurations

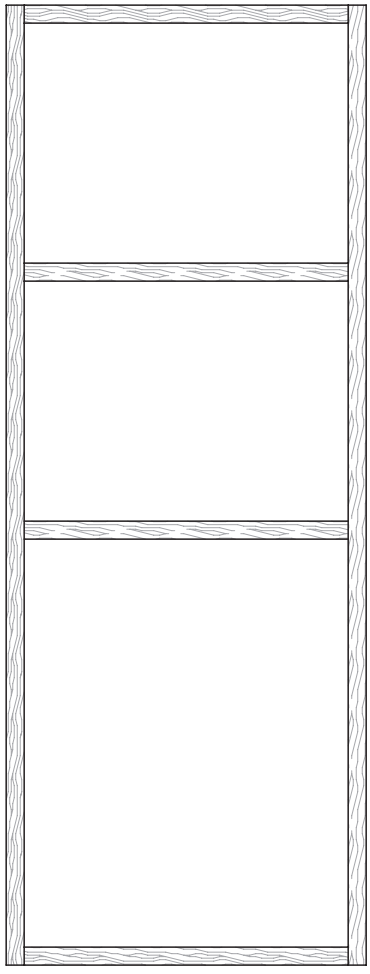
J



FF101



FF268

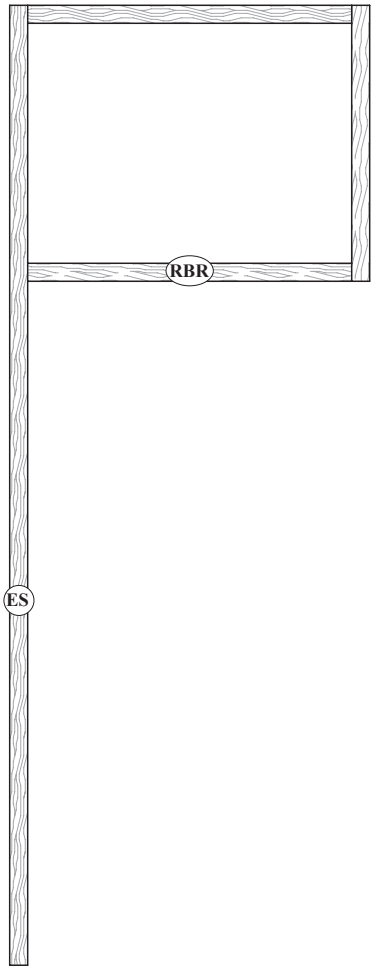


FF103

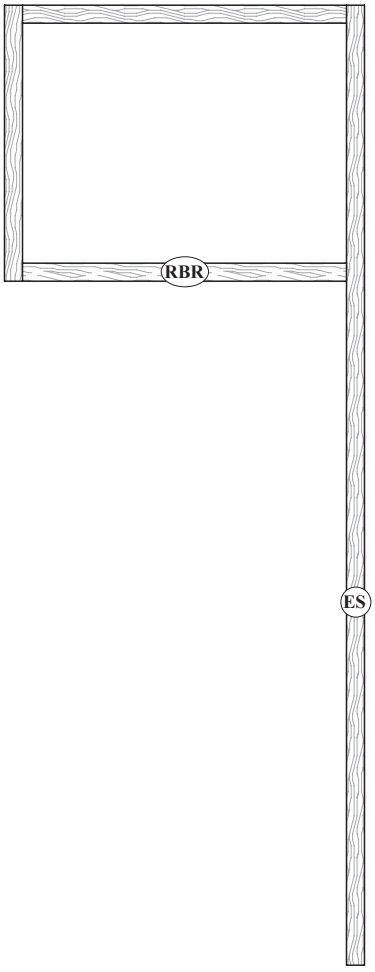
Continued on next page...

▶ **For PRICING** ▶ *See Section **J.2*** in our current Wholesale Pricing Catalog.

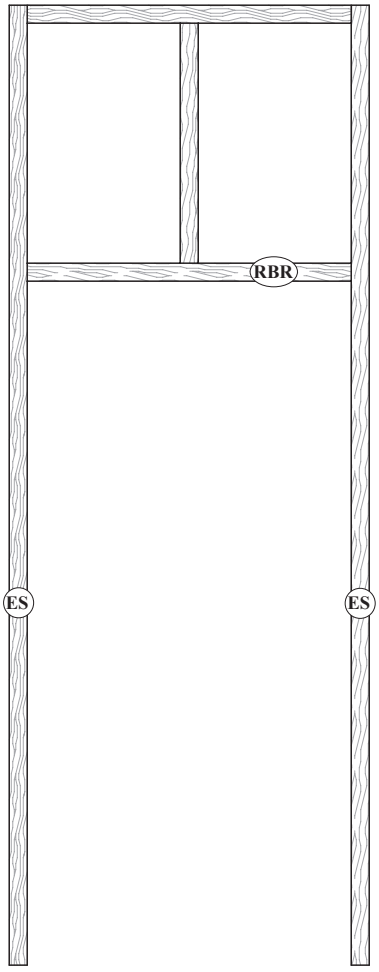
Typical Tall Cabinet Face Frame Configurations



FF270



FF271

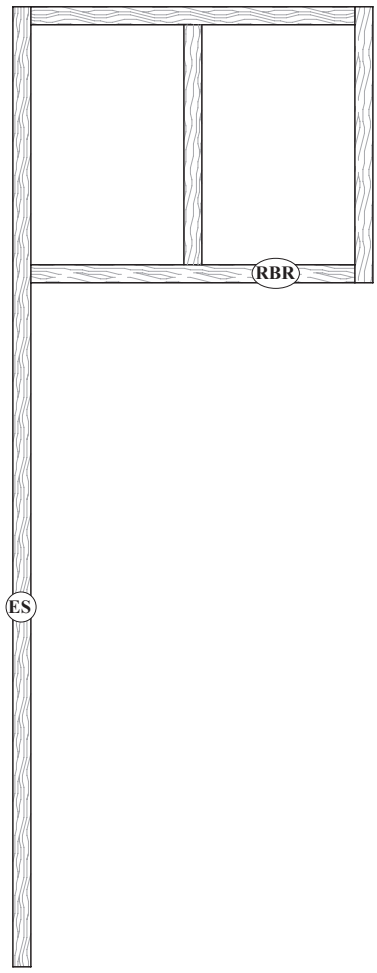


FF138

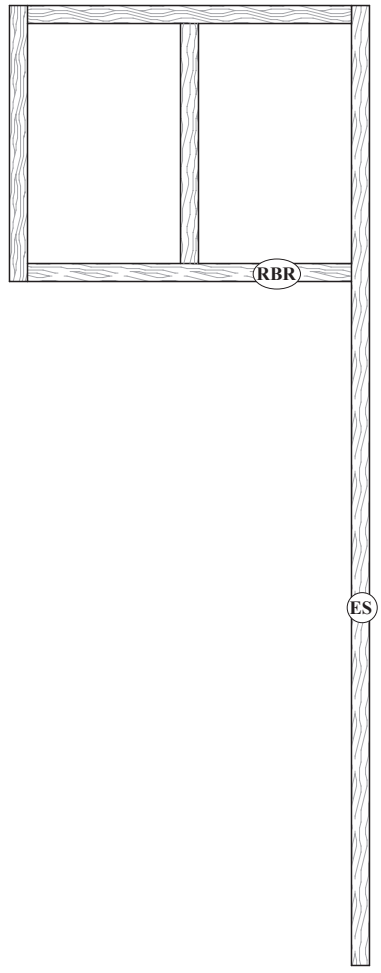
Continued on next page...

J

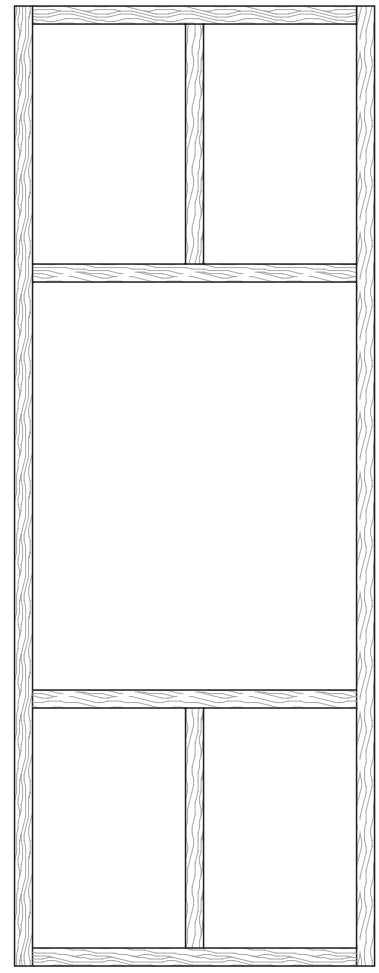
Typical Tall Cabinet Face Frame Configurations



FF277



FF278

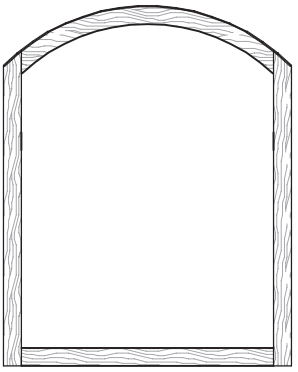


FF143

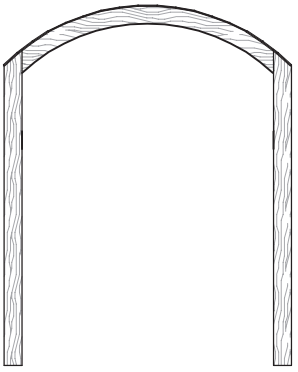
Continued on next page...

J

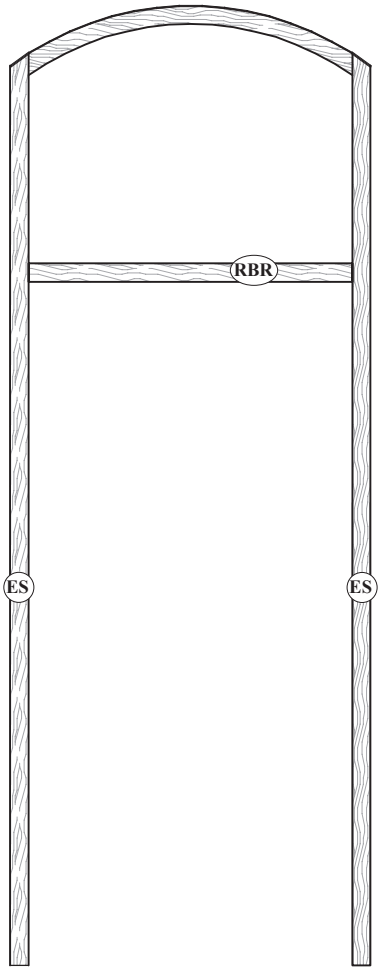
Arched Top Face Frame Configurations



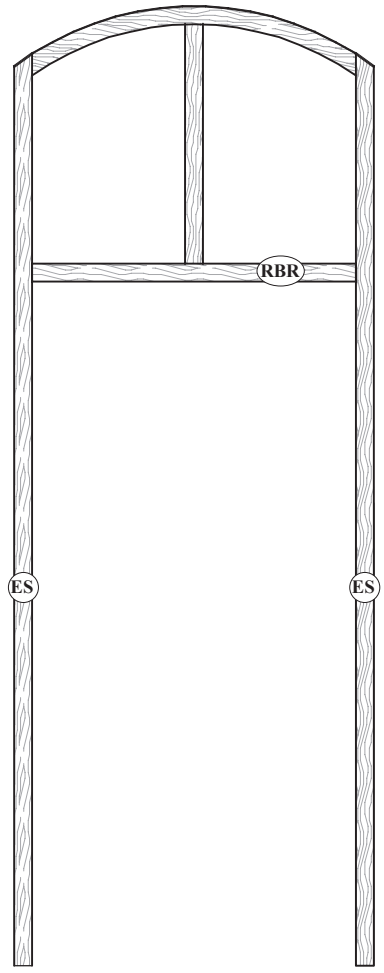
FF297



FF298



FF299

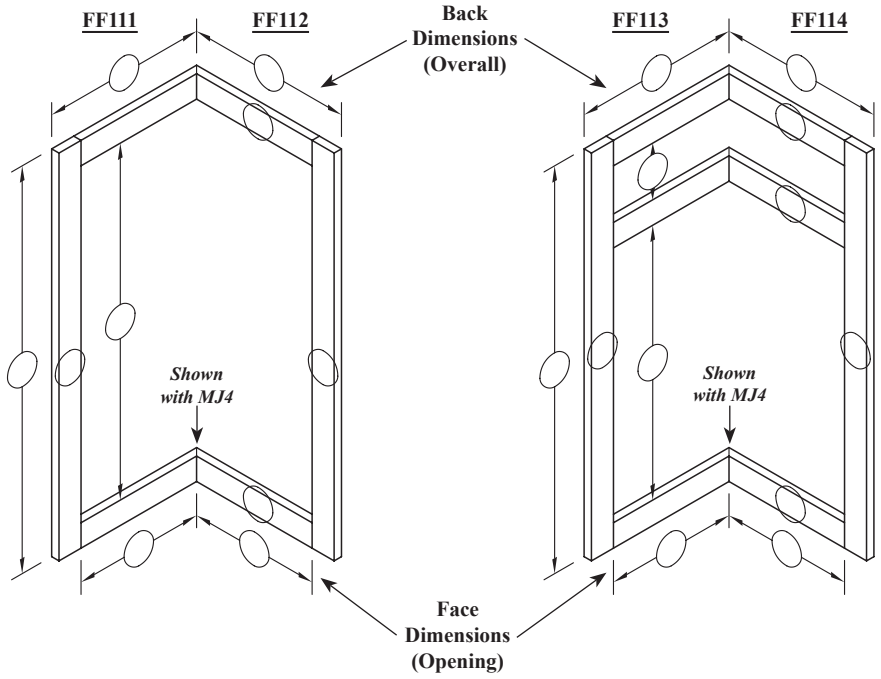


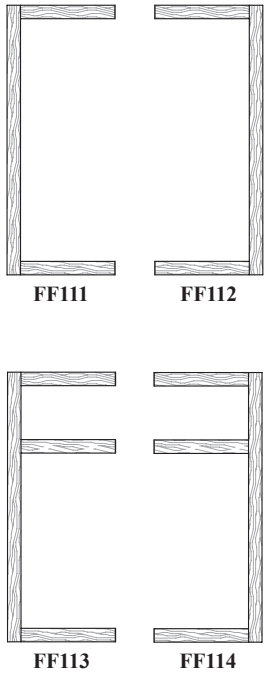
FF300

J

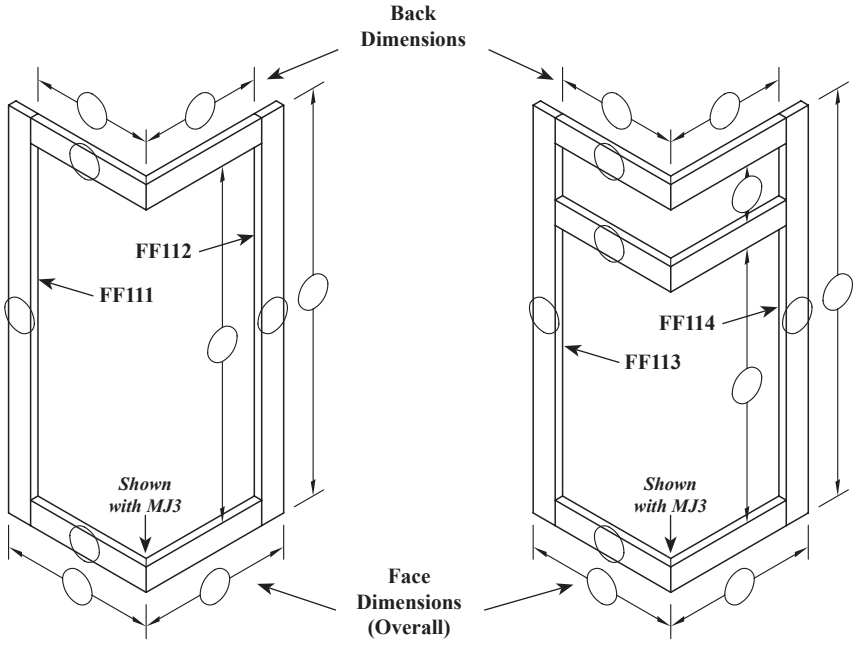
Continued on next page...

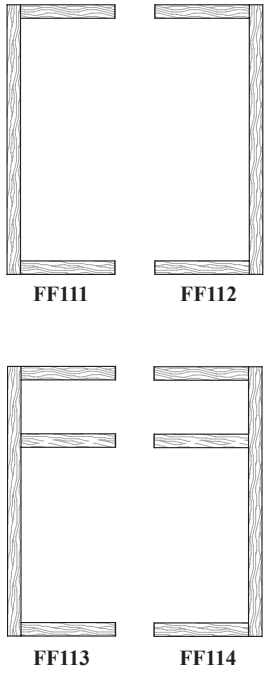
90° Inside Corner Face Frame Configurations (Lazy Susan)





90° Outside Corner Face Frame Configurations (Lazy Susan)



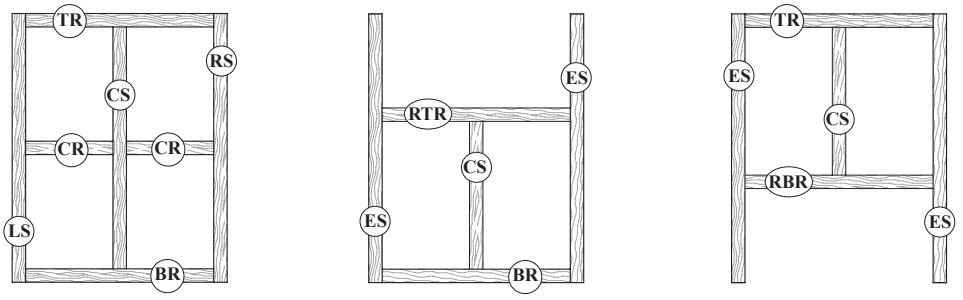


Continued on next page...

▶ **For PRICING** ▶ *See Section **J.2*** in our current Wholesale Pricing Catalog.

Ordering & Pricing Notes: Assembled & Ready to Assemble (RTA) Face Frames

Ordering Guidelines

1	**Order Forms**	Please use ***Assembled & Ready to Assemble (RTA) Face Frame Order Forms (E•Z Forms #15 & 15.1)***.
		You may choose to submit your own configuration drawings in place of ***E•Z Form #15.1***. • Please include ***E•Z Form #15*** with your configuration drawings. • When suppling your own configuration drawings, please provide view as seen from the face.
2	**Ordering Information**	When ordering, please specify: • Face frame stock number (eg: **FS100, FS101, FS103, FS105 or FS107**). • Face frame configuration number (eg: **FF107**). ◦ For 90° Inside Corner and 90° Outside Corner face frames, please provide numbers for both the left half and the right half (eg: **FF111** and **FF112**). • Face frame configuration views should be provided as seen from the face. • Face frame thickness. • Overall width of parts. • Opening dimensions between each part. • Overall width and height dimensions. • Assembled or Ready to Assemble (RTA) construction. • Joinery Method: Pocket Screw or Domino Tenon. • Location of any Miscellaneous Joinery options (**MJ's**) and/or Joint Assembly Methods (**JAM's**).
3	**Dimensions Needed for Ordering**	It is very important that we have all of the dimensions. Overall face frame dimensions ***must equal*** the total of your part sizes and opening sizes. The drawing on ***page J.2.1*** **(FF179)** indicates all of the sizes needed to properly construct a face frame, whether assembled or Ready to Assemble (RTA).
4	**Part Name Definitions**	

When ordering face frames with similar configurations, parts will use the following abbreviations:

TR: Top Rail	**LS: Left Stile**	**ES: Extended Stile**
BR: Bottom Rail	**RS: Right Stile**	**RTR: Repositioned Top Rail**
CR: Center Rail	**CS: Center Stile**	**RBR: Repositioned Bottom Rail**

Pricing

1	**Pricing**	Please see ***Section J.2*** of our current **Wholesale Pricing Catalog**.

Technical Notes: Assembled & Ready to Assemble (RTA) Face Frames

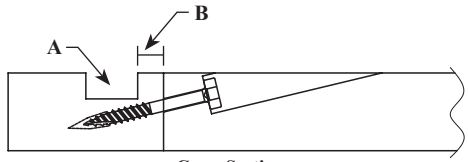
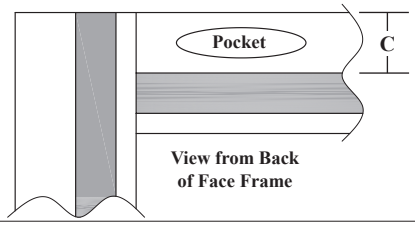
Convex/Concave Options (Chapter D)

1	**Profiles**	Assembled convex/concave face frames are available with all face frame profile options (**FS100-FS108**).

Continued on next page...

Technical Notes: Assembled & Ready to Assemble (RTA) Face Frames...continued

Face Frame Options (Chapter J)

1	**Face Frame Joinery**	Pocket Screw joinery is WalzCraft's preferred method for constructing face frames and will be used unless specified otherwise. • Assembled face frames are precision bored and joints are glued and screwed together. • Ready to Assemble (RTA) face frames are precision bored and shipped with screws specifically designed for use on the backside of the face frame to conjoin the parts. ◦ Each joint is labeled and a drawing is provided with assembly guidelines.
		Please note, under certain conditions, WalzCraft may choose to use a domino tenon at a particular joint instead of the standard pocket screw. • This is most commonly done when center stiles or center rails are narrow, or when dadoes in the rear of a face frame are placed too close to the joint. • When WalzCraft switches a pocket screw to a domino tenon at any of the center stile or center rail joints, it will be done at no additional charge to the customer. • When WalzCraft switches a pocket screw to a domino tenon at any of the outside corner stile & rail joints, the entire face frame will be constructed using domino tenon joinery and additional charges will apply.
		Due to their configuration, the following face frames are only available with domino tenon joinery: • FF109, FF111, FF112, FF113, FF114, FF129. • FF297, FF298, FF299, FF300. • Additional charges will apply.
		Domino tenon joinery will be used on any face frame where ***all*** of the following conditions are met: • Face frame consists of four parts or less, • Face frame is greater than 48" x 84" or 84" x 48". • Top and/or bottom rail is less than 2" wide.
		As an option, you may choose to have all of your face frames constructed using only domino tenon joinery. • Additional charges will apply. • Please choose the Domino Tenon option on your order form (***E•Z Form #15***).
		See ***Section J.2*** of our ***Wholesale Pricing Catalog*** for domino tenon upcharges.
3	**Pocket Screws & Dado/Rabbet Joinery**	When adding a dado or rabbet joint to your assembled or RTA face frame that's using pocket screws for assembly, the following criteria must be met for the combination to be compatible: • **A**: Dado/Rabbet joint can only be a maximum of ¼" deep. • **B**: Dado/Rabbet placement must be a minimum of ¼" from the joint • **C**: A pocket screw requires a ⅝" wide flat space. If any of these criteria are not met, a domino tenon must be used. Additional charges will apply.
		 Cross Section  View from Back of Face Frame
4	**Integral Bevel Option**	When ordering, specify the **FS107** option as shown in ***Section J.1***. • Please factor the size of the bevel into your overall face frame dimension. • Bevel will only be applied to edges of interior openings. It will not be applied to the outside edges of face frame. ◦ For **FF109, FF137, FF138, FF268, FF269, FF298, FF299, FF300**, the bevel will be applied to the three sided interior opening as well. • Stile and rail joints are "haunched" (see illustration at beginning of this section).
5	**Integral Bead Option**	When ordering, specify the **FS101**, **FS103** or **FS105** option as shown in ***Section J.1***. • Please factor the size of the bead into your overall face frame dimension. • Bead will only be applied to edges of interior openings. It will not be applied to the outside edges of face frame. ◦ For **FF109, FF137, FF138, FF268, FF269, FF298, FF299, FF300**, the bead will be applied to the three sided interior opening as well. • Stile and rail joints are "haunched" (see illustration at beginning of this section). • If integral bead molding ***is not*** needed in every opening, an applied option may be substituted for the entire face frame (see ***Section J.5*** for Beaded Applied Molding Options).
6	**Custom Applications**	For custom application requests, please fax your drawings and order forms to our Customer Support Team or email drawings to: **customersupport@WalzCraft.com**.

Continued on next page...

Technical Notes: Assembled & Ready to Assemble (RTA) Face Frames...continued

Face Frame Options (Chapter J)...continued

7	**90° Corner Face Frames**	Must be ordered as separate left (**FF111** or **FF113**) and separate right (**FF112** or **FF114**) units. • Units will be shipped as a separate left and a separate right face frame to be assembled by customer. • The rails utilize a standard butt joint where they meet at the inside or outside corner, unless otherwise specified. See ***Section F.2*** for optional 45° Inside Corner Miter Joint (**MJ4**), or optional 45° Outside Corner Miter Joint (**MJ3**). • See ***Section F.3*** for optional Joint Assembly Methods. WalzCraft prefers the Hoffmann Dovetail Joint Assembly Method (**JAM1**) when using the 45° Inside Corner Miter Joint (**MJ4**) or the 45° Outside Corner Miter Joint (**MJ3**).
		When WalzCraft is finishing with a SolidTone® color, Outside Corner Face Frames ***must*** be shipped completely assembled. • Outside corner face frames are assembled first, then the joints are sanded and the entire frame is painted. • This procedure helps prevent any visible seams that may occur at the joints. • *Complete assembly is not necessary for inside corner face frames.*

Finish Options (Chapter R)

1	**Sanding**	After assembly, frames are sanded to 220 grit and fladder sanded to 180 grit.
2	**Stain**	Available on Assembled face frames using pocket screw joinery or domino tenon joinery.
		Available on Ready to Assemble face frames using pocket screw joinery.
		Not available on Ready to Assemble face frames using domino tenon joinery.
		Face Frames will be stained and sealed on the face, back and all edges, and top coated on the face and all edges only.
3	**Primed Only for Paint**	Available on Assembled face frames using pocket screw joinery or domino tenon joinery.
		Available on Ready to Assemble face frames using pocket screw joinery.
		Not available on Ready to Assemble face frames using domino tenon joinery.
		Face Frames will be primed on the face, back and all edges.
4	**SolidTone®**	Available on Assembled face frames only (see ***Section R.2***).
		Face Frames will be primed and painted on the face, back and all edges.
		To have the outside edges of your face frame finished to the same quality as the face (ie: edge will be exposed to view after installation), please indicate this in the ***Special Instructions*** box on the order form. • **Example:** "Finish Exposed Edge = L, R" • **L** = Left Outside Edge, **R** = Right Outside Edge, **T** = Top Outside Edge, **B** = Bottom Outside Edge • Additional charges will apply.
5	**3D Laminate**	Please submit your requests for assembled or RTA face frames to our Customer Support Team.

Functional Options (Chapter F)

1	**Miscellaneous Joinery - Dado/Rabbet Grooves**	Dado and rabbet groove options are available.
		When ordering, please specify the **MJ** option, along with the width, depth and placement from each outside edge of the face frame. See ***Miscellaneous Joinery Section F.2*** for all dado and rabbet groove options.
		Please provide dimensions for placement of dadoes as seen from the back.
		To determine your dado groove width, you will need to take into consideration the thickness of the sidewall material that you will be using to insert into the groove.

Profile Options (Chapter E)

1	**Outside Edge Profiles**	Assembled face frames are only available with a **D7** outside edge profile.
		All other requests should be submitted to our Customer Support Team.

Continued on next page...

J

▶ **For PRICING** ▶ *See Section J.2* in our current Wholesale Pricing Catalog.

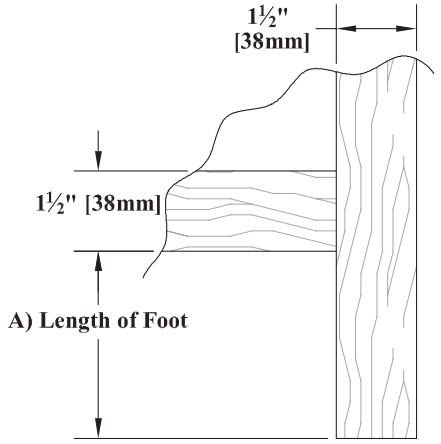
Technical Notes: Assembled & Ready to Assemble (RTA) Face Frames...continued		
	Sizes / Dimensions	
1	**Tolerances**	Assembled face frames will have a size tolerance +/- 1mm on the overall sizes and +/- 1mm within each opening.
2	**Stile & Rail Sizes**	When specifying the stile and/or rail widths, please provide WalzCraft with the overall dimension (ie: if profile is beaded, the width should include the bead).
		All face frames are drawn at 1½" [38.1mm] wide part sizes, unless otherwise noted.
		• **For part widths greater than 9" [228.6mm] up to 12" [304.8mm]** ◦ Parts will be made from two or more edge glued pieces and will incur additional fees. • **For part widths greater than 12" [304.8mm]** ◦ Please submit requests to our Customer Support Team; these will be subject to approval and may incur additional design charges. ◦ Other solutions may be available. Please **see *Section J.7*** for more information on Blind Corner Extensions.
3	**Thicknesses**	Assembled and Ready to Assemble face frames made from solid wood are available in ¾" [19.1mm], ⅞" [22.2mm], 1" [25.4mm], 1⅛" [28.6mm] and 1¼" [31.8mm] thicknesses, with some exceptions. Please see ***Section S.3*** for possible thickness restrictions based on wood species.
4	**Assembly Screws**	Parts less than 2" [50.8mm] wide will have one pocket screw per joint.

	Wood Specie Options (Chapter S)	
1	**Grain & Color Matching**	Assembled face frames are only grain and color matched on the faces. All natural wood characteristics are acceptable on the inside edges.

Assembled & Ready to Assemble Face Frames - END

J

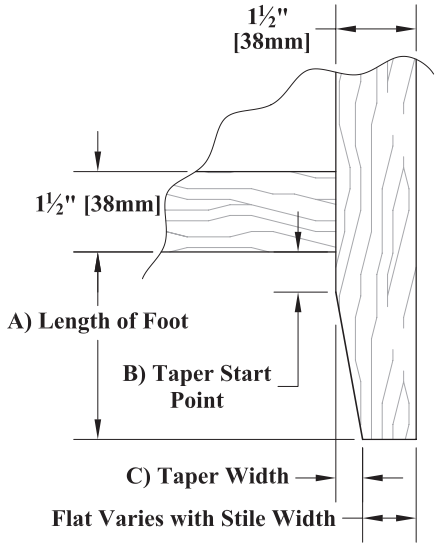
Square Foot Option for Face Frames - SFO100



Shown with foot length of 3½" [88.9mm].

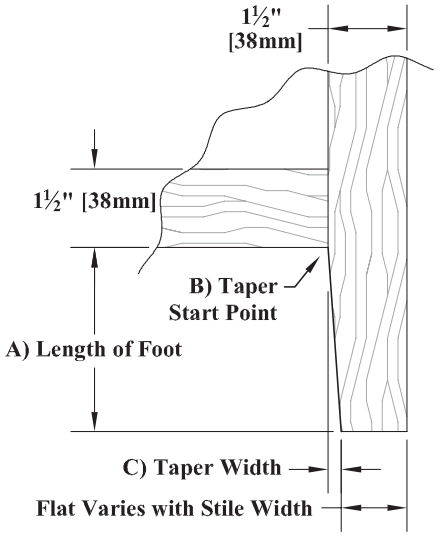
J

Tapered Foot Options for Face Frames - TFO100



Shown with foot length of 3½" [88.9mm], taper start point of ¾" [19.1mm], and taper width of ½" [12.7mm].

Tapered Foot Options for Face Frames - TFO200

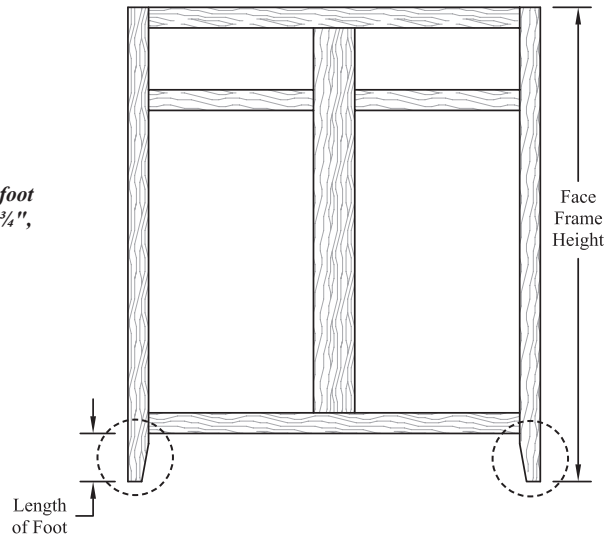


Shown with foot length of 3½" [88.9mm], taper start point of 0", and taper width of ¼" [6.4mm].

Continued on next page...

Example: FF108 Face Frame Configuration with Taper Foot Option (TFO100)

Shown with 1½" wide stiles, taper foot length of 3½", taper start point of ¾", and taper width of ½".



J

Ordering & Pricing Notes: Face Frame Options - Square / Tapered Foot		
Ordering Guidelines		
1	**Order Forms**	Please use ***Assembled & Ready to Assemble (RTA) Face Frame Order Forms (E•Z Forms #15 & 15.1)***.
		Fax your face frame configuration drawings along with your order forms to our Customer Support Team or email drawings to: **customersupport@WalzCraft.com**.
2	**Ordering Information**	**Length of Foot**: Typical lengths for this application are 3½" [88.9mm] or 4" [101.6mm].
		Taper Start Point (TFO100, TFO200): Please denote dimension from bottom of face frame, as shown in the illustration on previous page.
		Taper Width (TFO100, TFO200): Remaining flat dimension will vary with stile width.
Pricing		
1	**Pricing**	Please see ***Section J.3*** of the **Wholesale Pricing Catalog**.

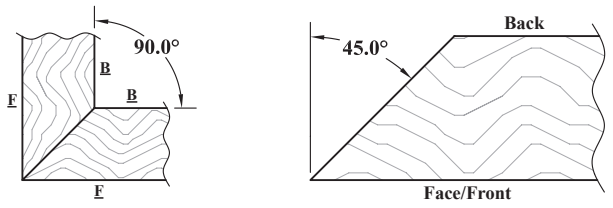
Technical Notes: Face Frame Options - Square / Tapered Foot		
Face Frame Options (Chapter J)		
1	**Integral Bevel / Bead Option**	When choosing face frame stock **FS101, FS103, FS105** or **FS107**, the bevel/bead will only be applied to edges of interior openings. It will not be applied to the outside edges of face frame or to Square / Tapered Foot option (see ***Section J.2*** for more information).

Sizes / Dimensions		
1	**Face Frame Height**	When applying the Square or Tapered Foot options to a face frame, the face frame height ***must include*** the length of the foot, as shown in the **FF108** Face Frame Configuration illustrated above.
2	**Maximum Foot Length**	The maximum foot length is 10" [254.0mm].

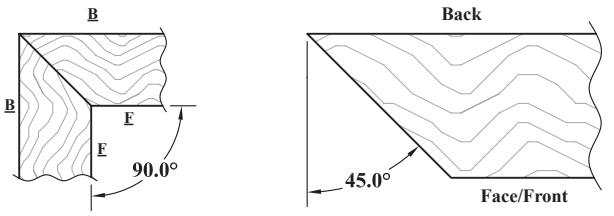
Square / Tapered Foot - END

Miscellaneous Joinery Options for Face Frames

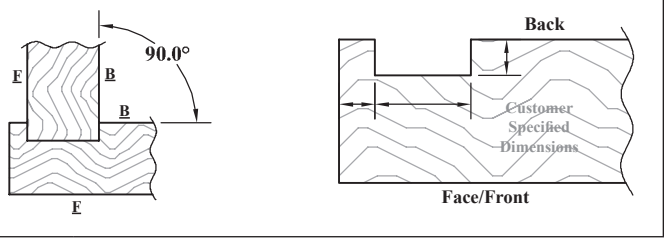
MJ3 — 90° Outside Corner (45° Miter Cut)



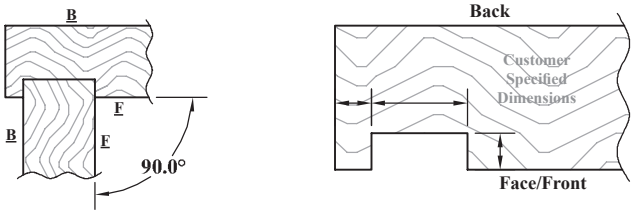
MJ4 — 90° Inside Corner (45° Miter Cut)



MJ10 — 90° Outside Corner (Dado Option)



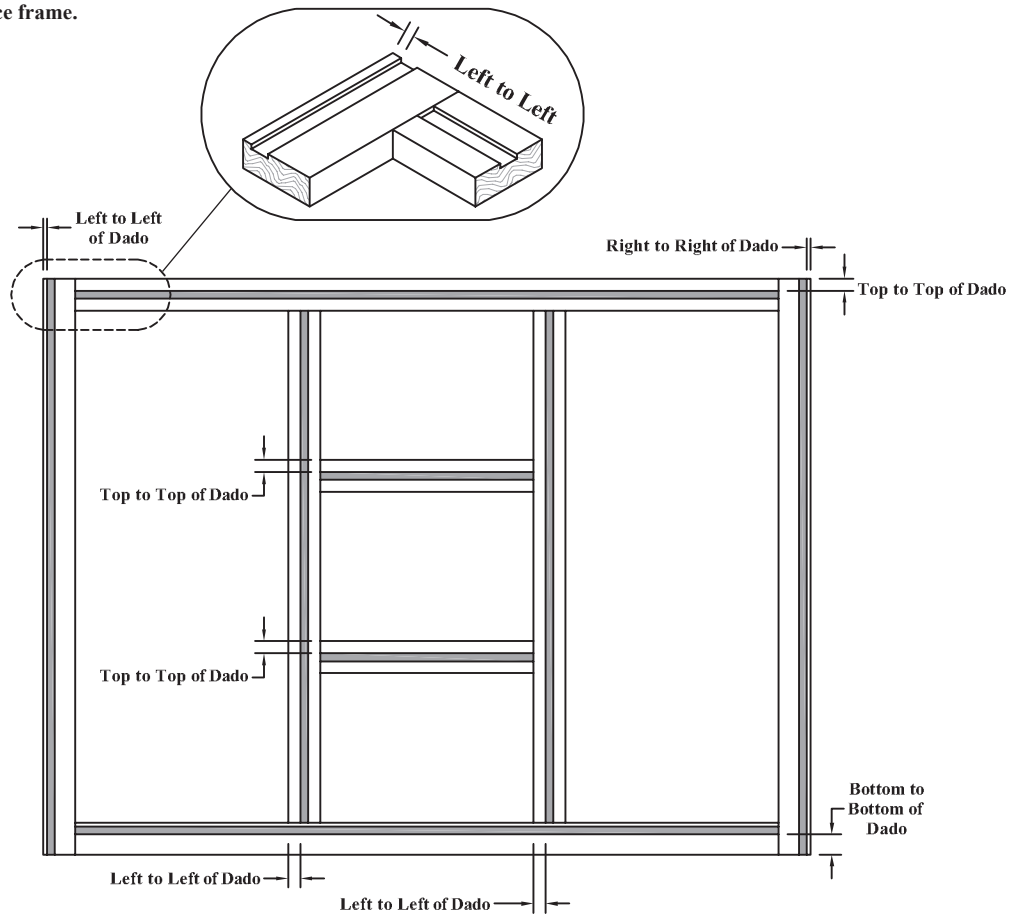
MJ18 — 90° Inside Corner (Dado Option)



J

Dado Groove Placement Guidelines

- **Dimensions required for dado placement.**
- **View from back side of face frame.**



Face Frame Configuration FF204 shown.

® WalzCraft® .com © (Phone) 1-800-237-1326 6:00AM - 5:30PM CST (24 Hour Fax) 1-608-781-3667

Ordering & Pricing Notes: Face Frame Options - Miscellaneous Joinery		
Ordering Guidelines		
1	**Order Forms**	Please use ***Assembled & Ready to Assemble (RTA) Face Frame Order Forms (E•Z Forms #15 & 15.1)***.
		Fax your face frame configuration drawings along with your order forms to our Customer Support Team at 1-608-781-3667 or email drawings to: **customersupport@WalzCraft.com**.
2	**Ordering Information**	Specify the MJ option, along with the width, depth and placement from each outside edge of the face frame. • See ***Miscellaneous Joinery Section F.2*** for all joinery options.
		To determine your dado groove width, you will need to take into consideration the thickness of the sidewall material that you will be using to insert into the groove.
Pricing		
1	**Pricing**	Please see ***Section J.4*** of our current **Wholesale Pricing Catalog**.

Continued on next page...

J

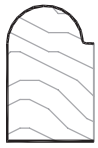
® WalzCraft® .com © (Phone) 1-800-237-1326 6:00AM - 5:30PM CST (24 Hour Fax) 1-608-781-3667

Beaded Applied Molding Options for Face Frames

¾" [19.1mm] Inset Bead



#825
PC: AM101
Sq Ft: .70



#1334
PC: AM101
Sq Ft: .70

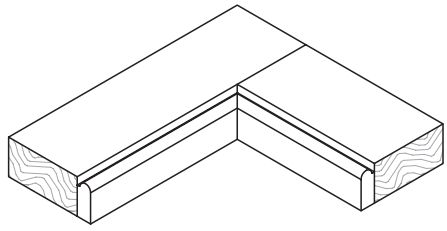
1" [25.4mm] Inset Bead



#834
PC: M103
Sq Ft: .70



#1352
PC: M103
Sq Ft: .70

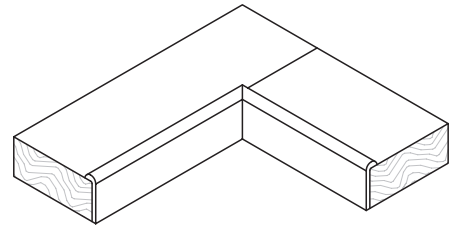




#846
PC: AM103
Sq Ft: .70



#851
PC: AM103
Sq Ft: .70



J

Ordering & Pricing Notes: Face Frame Options - Beaded Applied Molding

		Ordering Guidelines
1	**Order Forms**	Please use ***Assembled & Ready to Assemble (RTA) Face Frame Order Forms (E•Z Forms #15 & 15.1)***.
		Fax your face frame configuration drawings along with your order forms to our Customer Support Team or email drawings to: **customersupport@WalzCraft.com**.
2	**Ordering Information**	Beaded applied molding drawings above are to scale. Order with the bead factored into the overall width dimension of your face frame parts.
		Pricing
1	**Pricing**	Please see ***Section J.5*** of our current **Wholesale Pricing Catalog**.

Technical Notes: Face Frame Options - Beaded Applied Molding

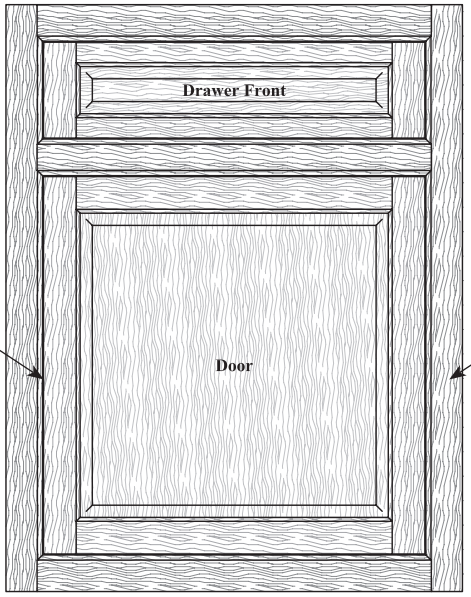
		Sizes / Dimensions
1	**Minimum Width of Parts**	Minimum width dimensions for assembled and ready to assemble face frames using the following beaded applied molding options are noted below:
		FS100 + #825 or #834 = 1 5/16" [23.8mm] (add an additional 5/16" [7.9mm] for center stile or center rail minimum).
		FS100 + #846 or #851 = ¾" [19.1mm] (add an additional ¼" [6.4mm] for center stile or center rail minimum).
		FS100 + #1334 or #1352 = 1 1/16" [27.0mm] (add an additional 7/16" [11.1mm] for center stile or center rail minimum).

Beaded Applied Molding - END

Inset Doors and Drawer Fronts

- When choosing to use inset doors and drawer fronts on your project, it is wise to recommend to the end user/homeowner that they maintain a controlled environment throughout the year with a consistent humidity level between 30% to 40% at all times. Any fluctuation in humidity levels will increase the likelihood that solid wood doors and drawer fronts will expand and/or contract. When these doors expand due to an increase in humidity, they may begin to rub and bind against the cabinet frame. The smaller the gap, the greater the risk of this occurring.
- With fluctuations in moisture as noted above, doors with miter joints can be susceptible to the "Barrel Effect". This is where a door will swell and be wider in the middle than at the top and bottom. The following door construction methods must maintain a minimum gap of 3.0mm, and will carry no warranty against the barrel effect: Miter doors (***Sections B.5, B.6***), Nexus doors (***Section B.20***).
- When producing your requested gap, WalzCraft always measures the product while in its ***unfinished*** stage. Please take into account that the thickness of the finish will reduce the gap ever so slightly. With finish being applied to the edges of the door, as well as the inside edges of the face frame, even the smallest amount of swelling could cause the door to rub.
- When WalzCraft pre-finishes your Inset/Pre-fit doors with a SolidTone®, the minimum allowable gap will be **2.0mm** or **3/32"** (.09375").

Assembled or Ready To Assemble (RTA) Face Frames with Inset Doors and/or Drawer Fronts *(Precision Sized to Fit Openings)*

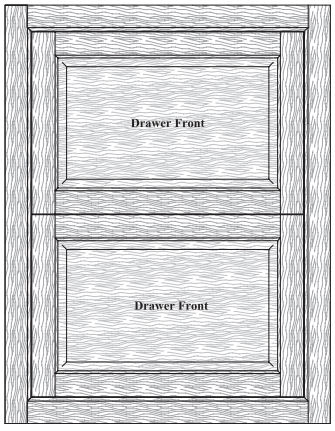


Gap Options available in Inches
- 1/16" • 3/32"
- 1/8" • 5/32"

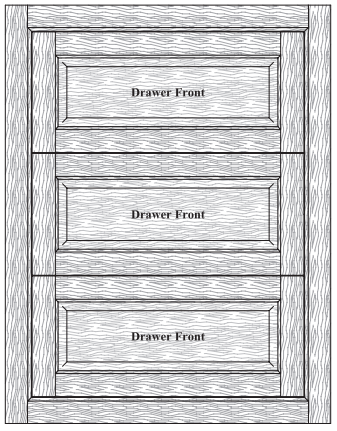
Gap Options available in MM
- 1.5mm • 2.0mm
- 2.5mm • 3.0mm

Shown with Style: 10 Drawer Front and Style: 10 Door*

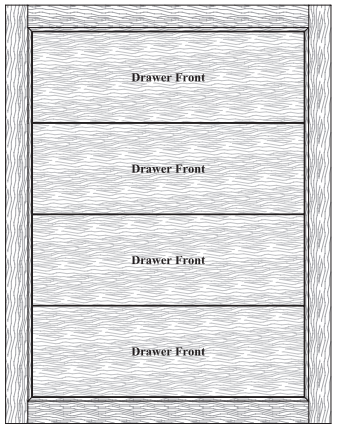
Additional Drawer Bank Configurations *(For Single Opening)*



Shown with Style: 10 Drawer Fronts*



Shown with Style: 10 Drawer Fronts*

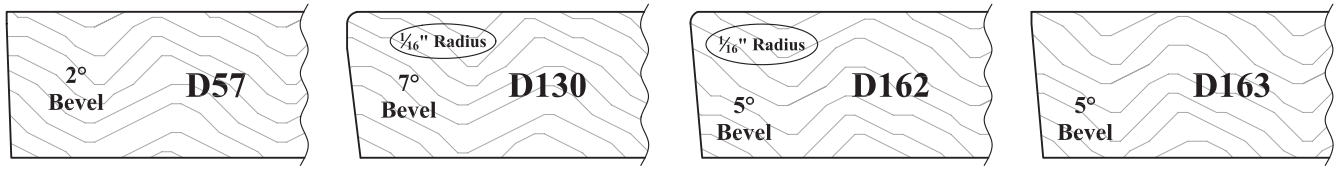


Shown with Style: 34SQA Drawer Fronts*

Continued on next page...

Outside Edge Profiles for Inset Doors and Drawer Fronts

• Using an outside edge profile with a slight back bevel, such as the D57, D130, D162 or D163 on pre-fit doors and drawer fronts will allow for adequate Face Frame clearance when opening.



Ordering & Pricing Notes: Face Frame Options - Inset/Pre-fit Doors

Ordering Guidelines

1	**Order Forms**	Please use ***Assembled & Ready to Assemble (RTA) Face Frame Order Forms (E•Z Forms #15 & 15.1)***.
		Fax your face frame configuration drawings along with your order forms to our Customer Support Team or email drawings to: **customersupport@WalzCraft.com**.
2	**Ordering Information**	Face Frames with precision sized components need to be clearly marked with the frame part sizes, opening width and height dimensions, as well as the overall width and height dimensions.
		Indicate on your drawings which openings are to receive a pre-fit door or drawer front, and the number of doors and drawer fronts per opening. There is no need to provide door and/or drawer front sizes, as these will be determined from the finished opening sizes (see ***Face Frame Options*** note below).
		Specify the gap in millimeters or inches, depending on how you order. • Note each gap: ◦ between the frame and your doors. ◦ between the frame and your drawer fronts. ◦ between two doors that will cover one opening. ◦ between all drawer fronts that will cover one opening. • **If ordering in millimeters** gap options are: **1.5mm, 2.0mm, 2.5mm, 3.0mm**. • **If ordering in inches** gap options are: **1/16"** (.0625"), **3/32"** (.09375"), **1/8"** (.125"), **5/32"** (.15625"). • When WalzCraft pre-finishes your Inset/Pre-fit doors with a SolidTone®, the minimum allowable gap will be **2.0mm** or **3/32"** (.09375").

Pricing

1	**Pricing**	Please see ***Section J.6*** of our current **Wholesale Pricing Catalog**.

Technical Notes: Face Frame Options - Inset/Pre-fit Doors

Face Frame Options (Chapter J)

1	**Precision Sized Doors and/or Drawer Fronts**	Steps to constructing face frames and doors/drawer fronts: • Face frames are built to your specifications. • Face frame openings are measured with calipers. • Customer specified gap is subtracted from face frame opening size and this dimension defines the door/drawer front sizes. ◦ When possible, doors and/or drawer fronts are trimmed to match the sizes calculated above.
2	**Door or Drawer Front Configurations**	A single face frame opening may consist of any one of the following configurations: • 1 drawer front • 1 door • 2 doors side by side • 2 doors stacked • 1 drawer bank (2, 3, or 4 drawers)
		Any other configuration of doors and drawer fronts within a single face frame opening may incur additional charges.

Profile Options (Chapter E)

1	**Outside Edge Profiles**	In a pre-fit situation, WalzCraft recommends that you use the **D57**, **D130**, **D162** or **D163** outside edge profiles, to allow the doors to swing open without hitting the face frame.

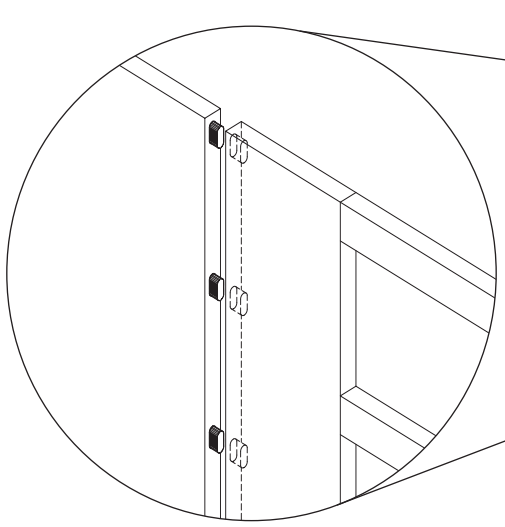
Inset/Pre-fit Doors & DFs - END

▶ **For PRICING** ▶ *See Section J.6 in our current Wholesale Pricing Catalog.*

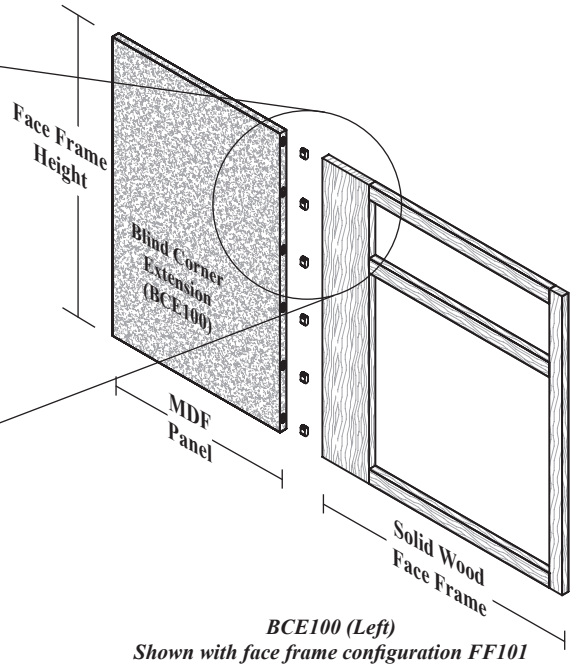
Blind Corner Extension for Face Frames - BCE100

Blind Corner Extensions (BCE100) are ¾" [19.1mm] or 1" [25.4mm] MDF panels applied to existing solid wood face frames using the domino tenon joinery method.

- ***Available with Assembled and Ready to Assemble (RTA) Face Frames.***

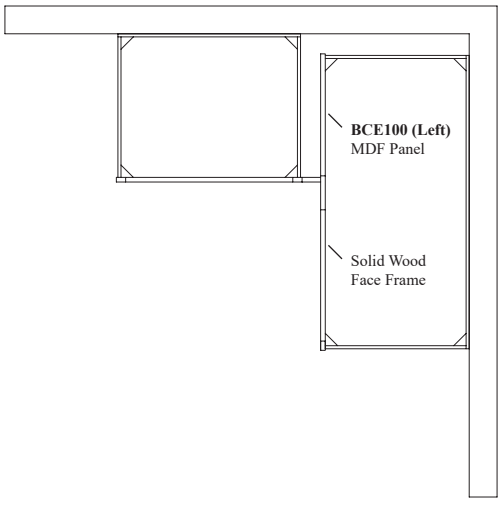


BCE100 (Left)
Domino Joinery - Detail View



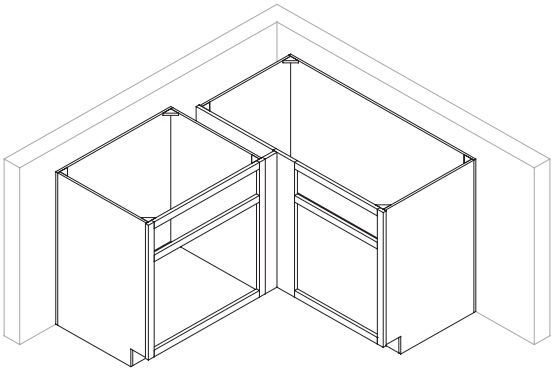
BCE100 (Left)
Shown with face frame configuration FF101

Blind Corner Extension - Example Plan View



BCE100 (Left) shown in a typical corner application.
Solid Wood Face Frame shown with wide Left Stile.

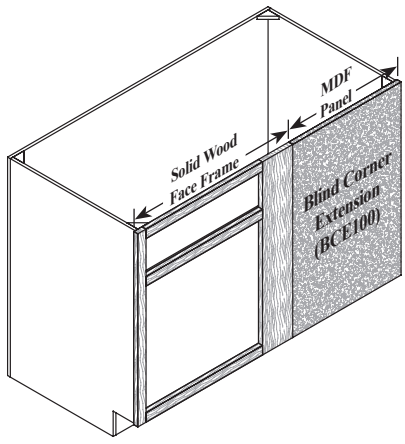
Blind Corner Extension - Model View



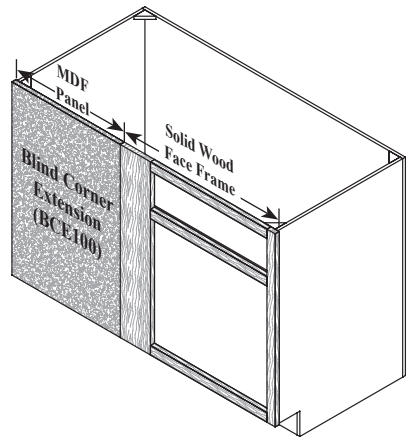
BCE100 (Left) shown in a typical corner application.
Both cabinets shown with FF101.

Continued on next page...

Example: FF101 Face Frame Configuration with Blind Corner Extension (BCE100)



Assembled Face Frame FF101
- **Blind Corner Extension (Right)**
- **Shown with wide Right Stile**



Assembled Face Frame FF101
- **Blind Corner Extension (Left)**
- **Shown with wide Left Stile**

J

Ordering & Pricing Notes: Face Frame Options - Blind Corner Extension

	Ordering Guidelines	
1	**Order Forms**	Please use ***Assembled & Ready to Assemble (RTA) Face Frame Order Forms (E•Z Forms #15 & 15.1)***.
		Fax your face frame configuration drawings along with your order forms to our Customer Support Team or email drawings to: **customersupport@WalzCraft.com**.
2	**Ordering Information**	**Direction of Extension (Left and/or Right)**: Please denote the side of the face frame to which the extension will be applied.
		Extension Width: Please denote dimension from the edge of the Solid Wood Face Frame to the outer edge of the MDF Panel, as shown in the illustration above.
	Pricing	
1	**Pricing**	Please see ***Section J.7*** of the **Wholesale Pricing Catalog**.

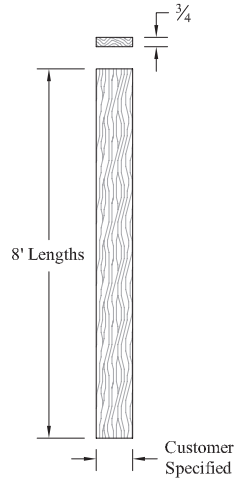
Technical Notes: Face Frame Options - Blind Corner Extension

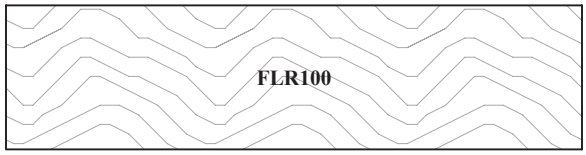
	Finish Options - Assembled and RTA (Chapter R)	
1	**Finish Types**	**Blind Corner Extensions (BCE100)** are available unfinished or finished with a Natural / Clear Coat, "Primed Only for Paint" or SolidTone® finish.
		Blind Corner Extensions (BCE100) are ***not available*** with Stains or SolidTone® Wood Grain finish.
	General Information	
1	**Ready to Assemble**	**Blind Corner Extensions (BCE100)** can be ordered with the MDF Panel attached to the face frame or unattached. Indicate either ***"Ship Extension Attached"*** (Assembled Face Frames only) or ***"Ship Extension Unattached"*** (Assembled & Ready to Assemble Face Frames) in the *Special Instructions* on your order form.
	Material Options	
1	**Material**	Only available with raw MDF.
2	**MDF - MR, Raw**	Not available with MDF - MR (Moisture Resistant), Raw.
	Profile Options (Chapter E)	
1	**Outside Edge Profiles**	Not available with an Outside Edge Profile.
	Sizes / Dimensions	
1	**Maximum Sizes**	The maximum size of a raw MDF product is 48"W x 96"H [1219.2mm x 2438.4mm].
2	**Minimum Sizes**	The minimum **Extension Width** is 1½" [38.1mm].
3	**Thicknesses**	Extensions available in ¾" [19.1mm] and 1" [25.4mm] thicknesses.

Blind Corner Extension - END

▶ **For PRICING** ▶ *See Section **J.7*** in our Wholesale Pricing Catalog.

Cabinet Fillers - Square





Matches Face Frame Stock - FS100

J

Ordering & Pricing Notes: Cabinet Fillers - Square

Ordering Guidelines

1	**Order Forms**	Please use ***Face Frame Stock Order Form (E•Z Form #9)***.
2	**Ordering Information**	Indicate quantity, part number and size (Thickness x Width x Length).

Pricing

1	**Pricing**	Please see ***Section J.8*** of our current **Wholesale Pricing Catalog**.

Technical Notes: Cabinet Fillers - Square

Design Options (Chapter G)

1	**Additional Profiles**	Not available with additional profiles or miscellaneous joinery. For solid wood stock with profiles and/or miscellaneous joinery options, please see ***Section G.16 - Profiled Stock***.

Finish Options (Chapter R)

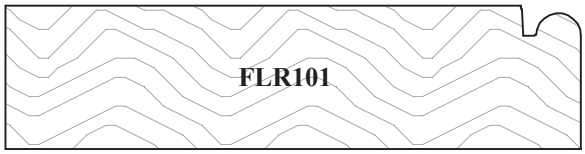
1	**Finishing**	Finishing is available. Cabinet Fillers will be stained and sealed on two sides and all edges, and top coated on the face and all edges.
2	**3D Laminate**	3D Laminate (RTF) Cabinet Fillers (**FLR100** only) are made of a solid wood core (Maple - Paint Grade) and are not subject to the same thickness limitations as MDF.
		As a standard, WalzCraft will apply the 3D Laminate material to the face and two long edges only.
		3D Laminate cabinet fillers are only available with a D33 outside edge profile.

Sizes / Dimensions

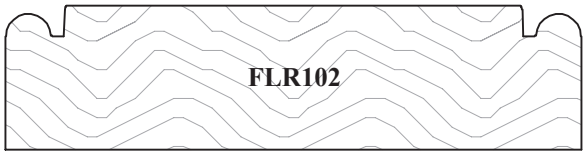
1	**Thickness**	Square fillers made from solid wood are available in ½" [12.7mm], ⅝" [15.9mm], ¾" [19.1mm], ⅞" [22.2mm], 1" [25.4mm], 1⅛" [28.6mm] or 1¼" [31.8mm] thicknesses, with some exceptions. See ***Section S.3*** for possible thickness restrictions based on wood species.
2	**Width**	Cabinet Fillers are available in a minimum width of a ½" [12.7mm] and a maximum width of 9" [228.6mm].
		9" [228.6mm] Maximum Width: WalzCraft makes every attempt to produce these parts from one solid piece of wood. Due to lumber availability and/or wood species, widths under 9" [228.6mm] may need to be made from two or more edge glued pieces. • For widths over 9" [228.6mm], please refer to our **GUPFS** product found in ***Section M.16***.
3	**Length**	Available in 8' [2438.4mm] Lengths, Cut to Length and Random Lengths. • Cabinet fillers with 3D Laminate are only available in 8' [2438.4mm] lengths (not available cut to length or in random lengths).
		The minimum length for Cut-to-Length pieces is 3" [76.2mm].
		Random length sizes vary between 36" [914.4mm] and 96" [2438.4mm] long. When measured, we round down to the next nearest ½ foot.
		Cabinet fillers have a standard length of up to 96" [2438.4mm]. Lengths greater than 8' [2438.4mm] are subject to availability. *Please note that the choice of wood species and grade can impact the availability of lengths greater than 8' [2438.4mm].* • Lengths longer than 8' [2438.4mm] are not available for cabinet fillers with 3D Laminate.

▶ **For PRICING** ▶ *See Section **J.8*** in our current Wholesale Pricing Catalog.

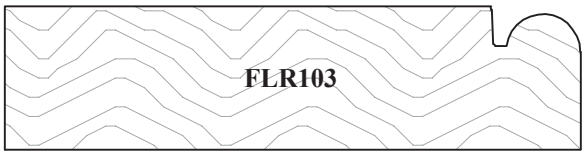
Cabinet Fillers - Beaded



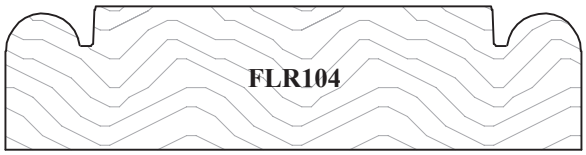
Matches Face Frame Stock - FS101



Matches Face Frame Stock - FS102



Matches Face Frame Stock - FS103



Matches Face Frame Stock - FS104

Ordering & Pricing Notes: Cabinet Fillers - Beaded

J

		Ordering Guidelines
1	**Order Forms**	Please use ***Face Frame Stock Order Form (E•Z Form #9)***.
2	**Ordering Information**	Indicate quantity, part number and size (Thickness x Width x Length).
		Pricing
1	**Pricing**	Please see ***Section J.8*** of our current **Wholesale Pricing Catalog**.

Technical Notes: Cabinet Fillers - Beaded

		Design Options (Chapter G)
1	**Additional Profiles**	Not available with additional profiles or miscellaneous joinery. For solid wood stock with profiles and/or miscellaneous joinery options, please see ***Section G.16 - Profiled Stock***.
		Face Frame Options (Chapter J)
1	**Bead Location**	Bead is applied to one or two long edges only. Bead is not available on the ends.
		Finish Options (Chapter R)
1	**Finishing**	Finishing is available. Cabinet Fillers will be stained and sealed on two sides and all edges, and top coated on the face and all edges.
2	**3D Laminate**	The above cabinet fillers are not available with 3D Laminate (RTF).
		Sizes / Dimensions
1	**Thickness**	Beaded fillers made from solid wood are available in ¾" [19.1mm], ⅞" [22.2mm] , 1" [25.4mm], 1⅛" [28.6mm] or 1¼" [31.8mm] thicknesses. with some exceptions. See ***Section S.3*** for possible thickness restrictions based on wood species.
2	**Width**	Cabinet Fillers are available in a minimum width of a ½" [12.7mm] and a maximum width of 9" [228.6mm]. **9" [228.6mm] Maximum Width:** WalzCraft makes every attempt to produce these parts from one solid piece of wood. Due to lumber availability and/or wood species, widths under 9" [228.6mm] may need to be made from two or more edge glued pieces. • For widths over 9" [228.6mm], please refer to our **GUPFS** product found in ***Section M.16***.
3	**Length**	Available in 8' [2438.4mm] Lengths, Cut-to-Length and Random Lengths. The minimum length for Cut-to-Length pieces is 3" [76.2mm]. Random length sizes vary between 36" [914.4mm] and 96" [2438.4mm] long. When measured, we round down to the next nearest ½ foot. Cabinet fillers have a standard length of up to 96" [2438.4mm]. Lengths greater than 8' [2438.4mm] are subject to availability. *Please note that the choice of wood species and grade can impact the availability of lengths greater than 8' [2438.4mm].* • Lengths longer than 8' [2438.4mm] are not available for cabinet fillers with 3D Laminate.

Cabinet Fillers - END

▶ **For PRICING** ▶ *See Section **J.8*** in our current Wholesale Pricing Catalog.

J

® WalzCraft® .com © (Phone) 1-800-237-1326 6:00AM - 5:30PM CST (24 Hour Fax) 1-608-781-3667