

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

Technical Notes: Convex/Concave Products

Cabinet Door & Drawer Front Options (Chapter B)

1	Door and Drawer Front Styles	<p>Raised Panel Styles: 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 are the only options available for Convex or Concave. Frame and mullion options in these door styles are also available.</p> <p>Flat Panel Styles: 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 are the only options available for Convex or Concave. Vertical grain only. Frame and mullion options in these door styles are also available. Door and drawer front styles with a 1/4" flat center panel are only available in radii 12" [304.8] or greater.</p> <p>Door Styles 20, 30, 2000, 2020, 2500, 2525, 3000, 3030, 3500, 3535, 4000 & 5000 are only available with a 12", 18" or 24" radius and have a maximum rail width of 23". Not available with Applied Moldings.</p> <p>Door styles 10FM, 10FM*, 40FM and 40FM* are only available in radii 12" and greater.</p> <p>Slab Styles: 1270, 1270*, 34SQA*, Raw MDF 500 & 500*, 60 and 60*.</p> <p>Door Styles 60 and 60* are only available with Edgeband Treatment options EBT201, EBT201-R, EBT401 and EBT401-R.</p>
2	Lite Pattern Options	LP001, LP108, LP109, LP110 and LP118 are the <i>only</i> lite pattern options available.
3	Style #1270 Doors and Drawer Fronts	The radius may be affected by expansion, contraction and moisture issues. Style #1270 Doors & Drawer Fronts are constructed with NO battens and will carry no warranty against warpage.

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 Curved 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.

Face Frame Options (Chapter J)

1	Face Frame Construction	<p>Convex/Concave Face Frames with a radius of 24" or greater will be constructed with Pocket Screw Joinery.</p> <p>Convex/Concave Face Frames with a radius under 24" will be constructed with Domino Tenon Joinery where all rails meet the stiles.</p> <ul style="list-style-type: none"> • Pocket Screw joinery will be used where center stiles meet the rails. <p>Convex/Concave face frames are not available Ready to Assemble (RTA).</p>
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Finish Options (Chapter R)

1	3D Laminate (RTF)	3D Laminate (RTF) is not an option for Curved Products.
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Functional Options (Chapter F)

1	Hinge Boring	HBP100 only. Please see <i>Section F.1</i> .
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► For PRICING ► See Section D.1 in our current Wholesale Pricing Catalog.

Technical Notes: Convex/Concave Products...continued

General Information (Chapter A)

1	Standard and Non-Standard Part Sizes	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

1	Center Panel Grain Direction Options	WalzCraft prefers that ALL convex/concave solid wood slabs and solid wood center panels have a vertical grain direction, including paint grades , 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"> • ¼" [6.4mm] flat panel wood veneers • ⅝" [15.9mm] solid wood raised panels • ⅜" [9.5mm] RVSCP-PR324 (Reversed Solid Center Panel) Profile
		RVSCP-PR324 solid wood reversed center panels are also available in ⅜" [9.5mm] Raw MDF.
		Raw MDF is not an option 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 face only . <ul style="list-style-type: none"> • The center panel will be recessed below the stiles and rails on the back side of the door.
		Horizontal grain will only be available with: <ul style="list-style-type: none"> • ¼" [6.4mm] Flat Panel wood veneer doors and drawer fronts <ul style="list-style-type: none"> ◦ Only available for radii 12" [304.8mm] or greater. ◦ Only available for arc lengths 31½" [800mm] or less. ◦ Maximum interior visual opening height is 47⅞" [1197mm]. • Style 60 Slab veneer doors
2	Pre-Finishing Options	Finishing Options for convex/concave doors or drawer fronts with Vertical grain on the center panel: <ul style="list-style-type: none"> • Stain Pre-finishing • Priming for Paint only • SolidTone® finish • SolidTone® WoodGrain
		Finishing Options for convex/concave doors or drawer fronts with Horizontal grain on the center panel: <ul style="list-style-type: none"> • Stain Pre-finishing • SolidTone® WoodGrain

Sizes / Dimensions

1	Thickness	Available in ¾" [19.1mm], 1" [25.4mm], 1⅞" [28.6mm] and 1¼" [31.8mm] thicknesses. Raw MDF Style 500 and 500* are only available in a ¾" [19.1mm] thickness.
2	Door / Face Frame Maximum Height	Maximum height for doors and face frames is 96" [2438.4mm].
3	6" Radii	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	Maximum Rail Size	The maximum rail size for Convex / Concave doors and drawer fronts is 13".

