

Door Face Veneer Standards

The face grading requirements for flush doors are described in the following pages. It is not correct to refer to veneers (or any raw material) using the terms "custom," "premium" or "economy" grades. These grade designations *only* apply to complete products.

FACE MATERIAL REQUIREMENTS

Veneers for Transparent Finishes

- **Custom Grade Doors.** "A" grade faces are standard for Custom Grade doors. Veneer is required to be of sufficient thickness (minimum 1/50" at 12% MC) to preclude sand-through, show-through of core, and glue bleed.
- **Premium Grade Doors.** "A" grade faces are standard for Premium Grade doors (WDMA). Veneer is required to be of sufficient thickness (minimum 1/50" at 12% MC) to preclude sand-through, show-through of core, and glue bleed.
- **Economy Grade Doors.** "B" grade faces are accepted for Economy Grade doors. Veneer is required to be of sufficient thickness (minimum 1/50" at 12% MC) to preclude sand-through, show-through of core, and glue bleed.

Veneer Grade Descriptions

- **Grade AA.** The veneer shall be smooth, tight-cut and full-length. When the face consists of more than one veneer component or piece, the edges shall appear parallel and be edge matched. Rotary-cut faces may be whole piece or multi-piece with edge joints tight with no sharp color contrasts at the joints. Species specified for natural color will allow color contrasts, but must be book matched or conform to the type of matching as specified. The components of plain-sliced (flat-cut) and multi-piece rotary faces will be book matched, unless otherwise specified with a running, balanced, or center matched arrangement. Unless otherwise specified, components in plain-sliced faces will have a matching arrangement selected by the manufacturer. Plain-sliced faces will consist of two or more components and rotary faces will consist of one or more components with no component less than 5 inches (127mm) wide except for outside components which may be less than 5 inches (127mm) to allow for certain types of matching or panel edge trim loss. No plain-sliced components will have a split heart. No full quarter-cut is allowed in plain-sliced faces. The width of any single component in quarter-cut, rift-cut or comb grain faces shall not be less than 3 inches (76mm) except for outside components which may be less than 3 inches (76mm) to allow for certain types of matching or door edge trim loss.
- **Grade A.** The veneer shall be smooth, tight-cut and full-length. When the face consists of more than one veneer component or piece, the edges shall appear parallel and be edged matched. Rotary-cut faces may be whole piece or be multi-piece with edge joints tight; however, no sharp color contrasts are permitted at the joints and the face will provide a good general appearance. Species specified for natural color will allow color contrasts, but must be book matched or conform to the type of matching as specified. The components of plain-sliced (flat-cut) and multi-piece rotary faces will be book matched, unless otherwise specified with a running, balanced, or center matched arrangement. Unless otherwise specified, components in plain-sliced faces will have a matching arrangement selected by the manufacturer. Plain-sliced faces will consist of two or more components and rotary faces will consist of one or more components with no component less than 4 inches (102mm) wide except for outside components which may be less than 4 inches (102mm) to allow for certain types of matching or panel edge trim loss. Split heart is permitted if manufactured cathedral is achieved. No full quarter-cut is allowed in plain-sliced faces. The width of any single component in quarter-cut, rift-cut or comb grain faces shall not be less than 3 inches (76mm) except for outside components which may be less than 3 inches (76mm) to allow for certain types of matching or door edge trim loss. In some species sapwood is permitted; in other species it may be permitted by agreement between buyer and seller.
- **Grade B.** The veneer shall be smooth, tight-cut and full-length. Slip or book matched veneers are available if specified by the buyer. If not specified, multi-piece faces will be pleasingly matched. Sharp color contrasts at the joints are not permitted. Species specified for natural color will allow color contrasts, but must be pleasingly matched or conform to the type of matching as specified. Plain-sliced faces will consist of two or more components with no component less than 3 inches (76mm) wide and rotary faces will consist of one or more components with no component less than 4 inches (102mm). Outside components may be less than 3 inches (76mm) for plain-sliced faces and 4 inches (102mm) for rotary faces to allow for certain types of matching or door edge trim loss. Some full quarter-cut is permitted in plain sliced faces. For some species, unlimited sapwood is allowed and in other species a percentage of sapwood is allowed.