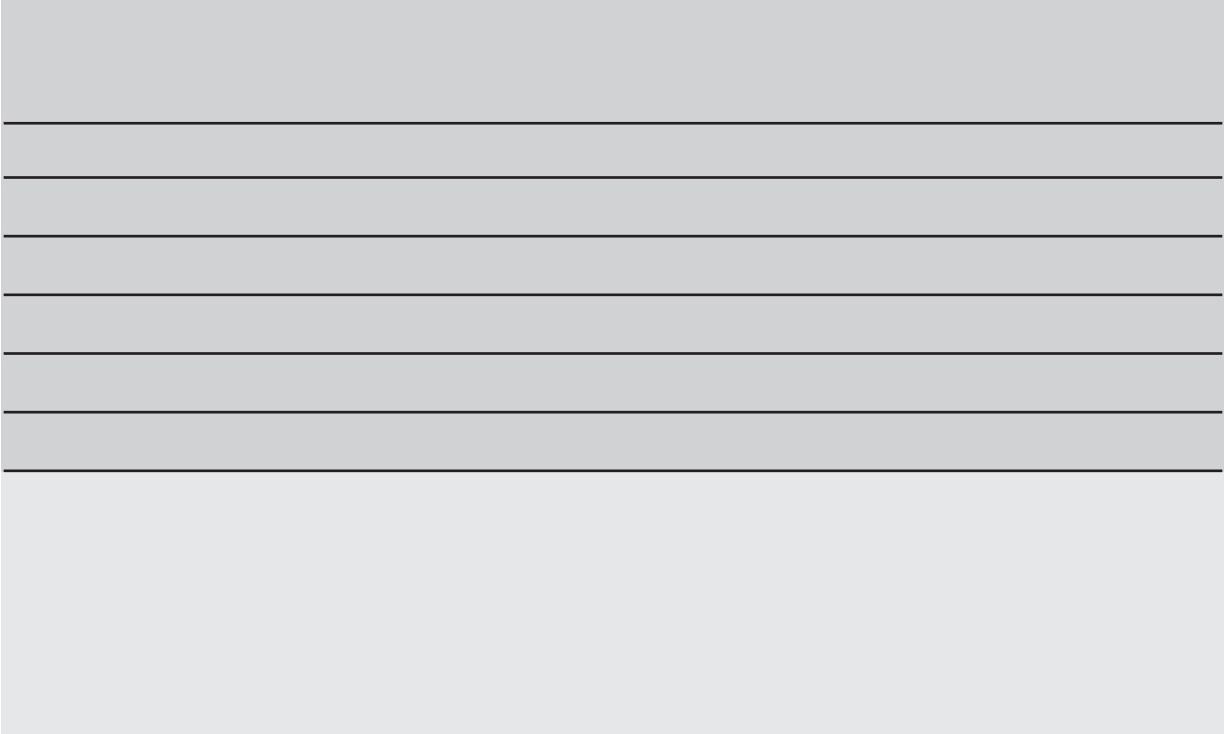


# Custom Products Manual





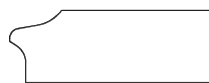








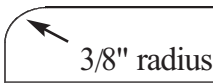

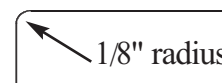








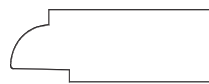
*Effective Spring 2005*

Northwoods International Enterprises Inc.  
(519) 421-4583  
1-866-777-4666  
Fax: 416-913-1709



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## Edge Profiles

				
<b>B</b> 3/4" only Rabbit: 7/16" deep 3/8" high	<b>B-2*</b> 3/4" and 1"	<b>C</b> 3/4" only Rabbit: 7/16" deep 3/8" high	<b>C-2</b> 3/4" and 1"	<b>CFP</b> 3/4" and 1"
				
<b>E</b> 1" only Rabbit: 7/16" deep 3/8" high	<b>E-2</b> 3/4" and 1"	<b>FP</b> 3/4" only	<b>J-2</b> 3/4" and 1"	<b>H</b> 3/4" only Rabbit: 7/16" deep 3/8" high
			 ↖ 3/8" radius	
<b>H-2</b> 3/4" and 1"	<b>Bullnose</b> 3/4" only	<b>LC-2*</b> 3/4" and 1"	<b>L-059*</b> 3/4" and 1"	<b>L-061</b> 3/4" and 1"
 ↖ 1/8" radius				
<b>L-149*</b> 3/4" and 1"	<b>PRS</b> 3/4" only Rabbit: 7/16" deep 3/8" high	<b>PRS-2*</b> 3/4" and 1"	<b>Round-2</b> 3/4" only	<b>V</b> 3/4" only Rabbit: 7/16" deep 3/8" high
				
<b>V-2*</b> 3/4" and 1"	<b>O</b> 3/4" only	<b>Machine Edge w/ Rabbit</b> 3/4" and 1" Rabbit: 7/16" deep 3/8" high	<b>Machine Edge*</b> 3/4" and 1"	<b>FEP</b> 3/4" only Designed for use on a "finished end panel." Can be used with Northwoods Cabinet Systems. Rabbit: 11/16" deep 1/8" high

**Premium Edge Profiles:**  
 \$14 additional charge per door.  
*These two profiles require 2 additional working days.*

	
<b>LC-Inset*</b> 3/4" and 1"	<b>Sophisticate</b> 3/4" and 1"



**L-253**  
3/4" and 1"  
5 degree back bevel



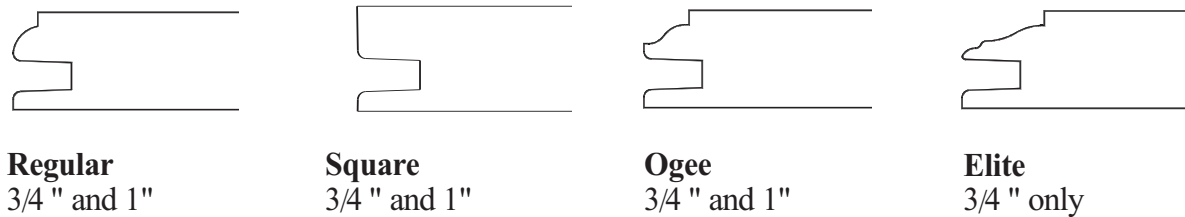
**L-686**  
3/4" and 1"  
5 degree back bevel

Images shown are not to scale.

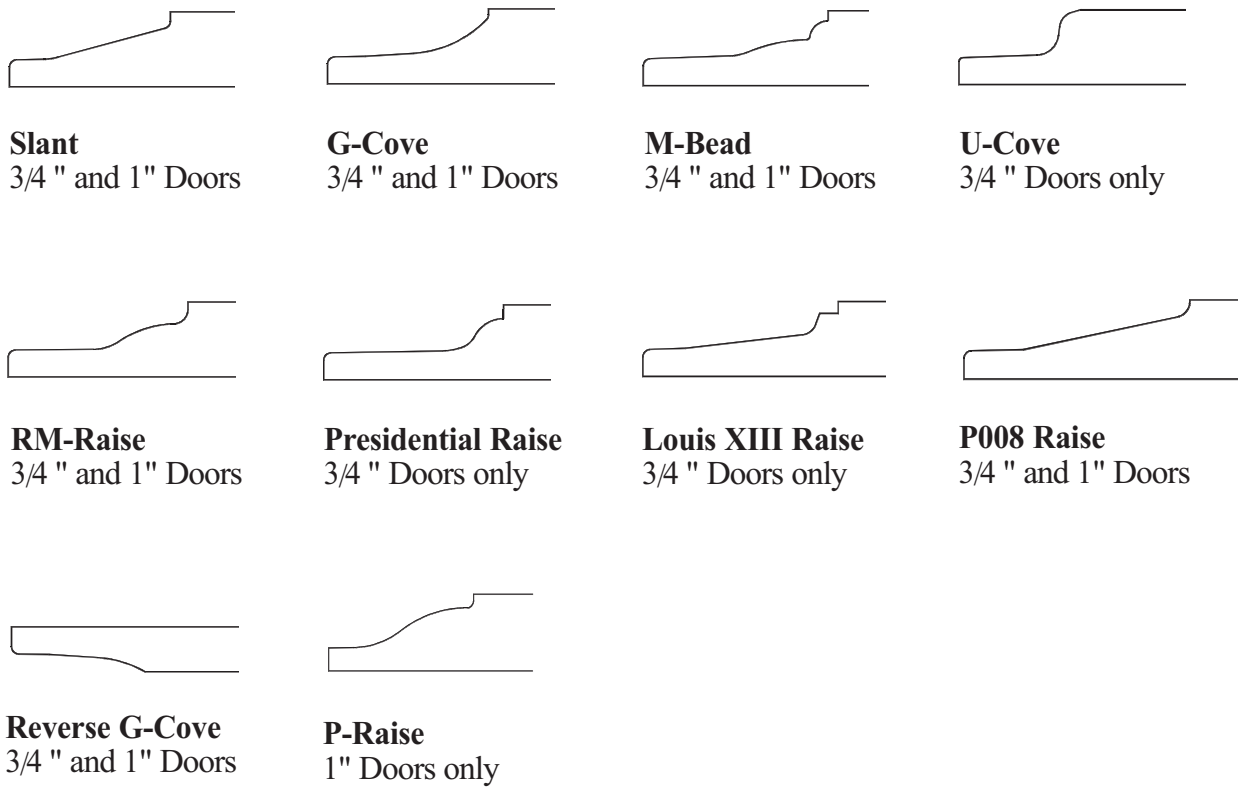
\* Drilling for concealed hinges is available on doors with these profiles.

Not all framing beads and panel raises are available with all door designs. Design charges include choice of framing bead and panel raise.

**Framing Beads**



**Panel Raises**



All published raises are available in hybrid products. Hybrid products consist of MDF panel and solid wood framing.

3/4" panel raises measure 5/8" finished thickness except reverse G-cove which measures 3/8" thick. 1" panel raises measure 3/4" finished thickness except reverse G-cove which measures 1/2" thick.

Images shown are not to scale.

**Mullion Doors**

**Mullion Products**

Northwoods offers a wide variety of mullion configurations and options. Mullions illustrated on the following pages are only a representation of the available patterns. Contact your Sales Representative or our Special Designs department for additional mullion information.

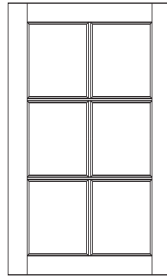
**Pricing**

To calculate mullion door square foot material charges use 9" for the width, regardless of actual width multiplied by the actual height, divided by 144. Multiply total square footage by the appropriate material charge found in the Material Pricing Guide. Add the material to the design charge of the desired door. Add appropriate lite charges indicated in the chart below.

- For TW and CRP designs, use the CRP design charge and category B material charges. For example TW-20 and CRP-20 both use the CRP-20 design charge.
- Available miter and applied moulding door styles use actual design charge plus appropriate material category as indicated in Wood Doors and Drawer Fronts section.
- See the MDF/RTF section for mullion pricing instructions.

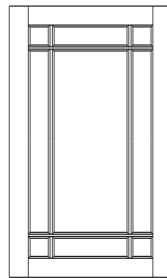
Mullion Design Options		
Design	Price	Design Notes
Regular and Ogee bead mullions Square bead mullions		<ul style="list-style-type: none"> <li>• Fitted for one piece of glass per door.</li> </ul>
Special (mullion bead differs from framing bead) Odd mullion configuration, add <i>Odd mullion configuration RTF/MDF doors will be priced by our Special Design Department.</i>		<ul style="list-style-type: none"> <li>• Fitted for one piece of glass per door.</li> <li>• Special mullions apply to all Miter designs except CRP-10 Miter.</li> </ul>
True Divided Lites Regular and Ogee bead mullions Square bead mullions Special (mullion bead differs from framing bead) Odd mullion configuration, add:		<ul style="list-style-type: none"> <li>• Fitted for individual pieces of glass per lite.</li> <li>• These doors have 7/8" wide mullions unless otherwise specified.</li> <li>• Glass retainer moulding not supplied.</li> </ul>
Mullion Width Details		Retainer Moulding Options
Framing Bead	Mullion Width	
Regular/Elite	5/8" wide for 3/4" thick doors 3/4" wide for 1" thick doors	<ul style="list-style-type: none"> <li>• Mullion doors come standard with retainer moulding groove.</li> <li>• Non-grooved framing is available. Simply specify "No rout for retainer moulding" in the special instructions portion of the order form.</li> </ul>
Square Bead	5/8"	
Ogee	7/8"	
MDF/RTF Beads	3/4"	
Glass Moulding <i>specify moulding number</i>		
<b>Clear</b> (standard) for 1/8" glass only 	#906, for 1/8" glass only 	#52, for varying glass thickness. Use on radius doors. 
	#907, for 1/4" glass 	Use #83 (similar to #52) on TW-10916, 209 series and Barcelona. 

*Mullion Doors (continued)*



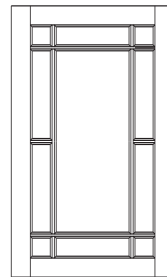
**Standard Lite Mullion**

- Specify 4-lite, 6-lite, 8-lite, 10-lite or 12-lite when ordering.
- All lites will be evenly spaced unless otherwise requested. Odd mullion configuration charges will apply if custom spacing is requested.
- All standard 3/4" and 1" framing beads available.
- Mullion profiles available in Regular, Ogee and Square. Elite frame bead receives Regular mullion profile.
- Clear plastic retainer moulding standard unless otherwise specified. Wood retainer moulding or "no retainer moulding" options available.
- True divided lite option available. Upcharge applies.



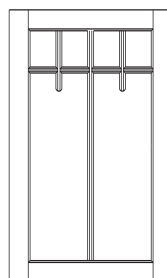
**9-Lite Offset Mullion**

- 9-lite mullion features 2" x 2" corner lites standard.
- All standard 3/4" and 1" framing beads available.
- Mullion profiles available in Regular, Ogee and Square. Elite frame bead receives Regular mullion profile.
- Clear plastic retainer moulding standard unless otherwise specified. Wood retainer moulding or no moulding options available.
- Odd mullion configuration upcharge applies.
- True divided lite option available. Upcharge applies.



**11-Lite Offset Mullion**

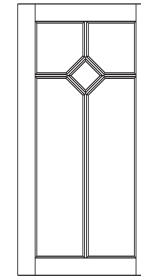
- 11-lite mullion features 2" x 2" corner lites standard.
- All standard 3/4" and 1" framing beads available.
- Mullion profiles available in Regular, Ogee and Square. Elite frame bead receives Regular mullion profile.
- Clear plastic retainer moulding standard unless otherwise specified. Wood retainer moulding or no moulding options available.
- Odd mullion configuration upcharge applies.
- True divided lite option available. Upcharge applies.



**Odyssey Mullion**

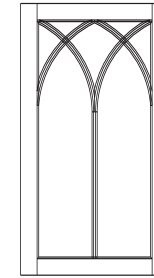
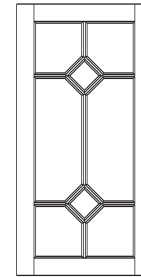
- A six lite design with two mullion strips extending below horizontal mullion.
- A dimensioned sketch must accompany each Odyssey mullion order.
- All standard 3/4" and 1" framing beads available.
- Mullion profile available in Regular, Ogee and Square. Elite frame bead receives Regular mullion profile.
- Clear plastic retainer moulding standard unless otherwise specified. Wood retainer moulding or "no moulding" options available.
- True divided lite option available. Upcharge applies.

*Mullion Doors (continued)*



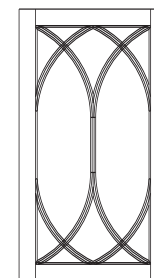
**Diamond & Double Diamond Mullion**

- Features a 4"x 4" diamond lite centered left and right in opening and 4-1/2" from top rail. Double Diamond mullion features two 4"x 4" Diamond lites centered left and right in opening and 4-1/2" from top and bottom rails.
- All standard 3/4" and 1" framing beads available.
- Mullion profiles available in Regular, Ogee and Square. Elite frame bead receives Regular mullion profile.
- Clear plastic retainer moulding standard unless otherwise specified. Wood retainer moulding or "no moulding" options available.
- Diamond mullions will be quoted through Special Designs. Additional lead-time required.



**Arched Lite Mullion Arched Mullion**

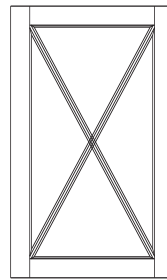
- Arched lite mullions feature seven radius lites.
- All standard 3/4" and 1" framing beads available.
- Mullion profiles available in Regular and Square only.
- Clear plastic retainer moulding standard unless otherwise specified. Wood retainer moulding or "no moulding" options available.
- Arched Lite mullion will be quoted through Special Designs. Additional lead-time required.
- An autocad drawing will be faxed to customer for approval prior to manufacturing process beginning.



**Double Arched Lite Mullion Double Arched Mullion**

- Double arched lite mullions feature 12 radius lites.
- All standard 3/4" and 1" framing beads available.
- Mullion profiles available in Regular and Square only.
- Clear plastic retainer moulding unless otherwise specified. Wood retainer moulding or "no moulding" options available.
- Double Arched mullions quoted through Special Designs. Additional lead-time required.
- An AutoCAD drawing will be faxed to customer for approval prior to manufacturing.

*Mullion Doors (continued)*



**X-lite Mullion X Mullion**

- Features diagonal mullion pattern.
- All standard 3/4" and 1" framing beads available.
- Mullion profiles available in Regular, Ogee and Square. Elite frame bead receives Regular mullion profile.
- Clear plastic retainer moulding standard unless otherwise specified. Wood retainer moulding or "no moulding" options available.
- X-lite mullions quoted through Special Designs. Additional lead-time required.
- An AutoCAD drawing will be faxed to customer for approval prior to manufacturing.

*Frame Only products*

Most Northwoods door styles are available with a frame only option to match your solid panel door designs. Frame only doors are a perfect accent and can accommodate a wide array of decorative glass and wire mesh inserts.

**Pricing**

To calculate frame only door square foot material charges use 9" for the width, regardless of actual width, multiplied by the actual height, divided by 144. Multiply total square footage by the appropriate material charge found in the Material Pricing Guide. Add the material charge to the design charge of the desired door style.

- For all TW series designs use the corresponding CRP design charge and category B material charges. For example TW-20 and CRP-20 both use the CRP-20 design charge.
- See the MDF/RTF section for frame only pricing instructions.

Retainer Moulding Options	
<p>Regular bead shown</p> <ul style="list-style-type: none"> <li>• Frame only doors come standard with glass retainer moulding groove.</li> </ul>	<ul style="list-style-type: none"> <li>• Non-grooved framing is available. Simply specify "No rout for retainer moulding" in the special instructions portion of the order form.</li> </ul>
Glass Moulding <i>specify moulding number</i>	
<p>Clear (standard) for 1/8" glass only</p>	<p>#906, for 1/8" glass only</p>
<p>#907, for 1/4" glass</p>	<p>#52, for varying glass thickness. Use on radius doors.</p>
<p>Use #83 (similar to #52) on TW-10916, 209 series and Barcelona.</p>	

*Appliance Panel Options*

Appliance panel selection must be noted when ordering. See offering and availability pages in the Wood Doors and Drawer Fronts section for appliance panel options and specific designs.

Apply over plywood and glue in strips options will have the following margins unless otherwise specified:

- Refrigerator panel – 1/2" margin on all sides.
- Other appliance panels – 1-1/2" bottom margin and 1/2" on all sides.
- Margins up to 3" available with glue in strip option.
- Northwoods uses an composite core plywood as a backer for its solid wood appliance panels.

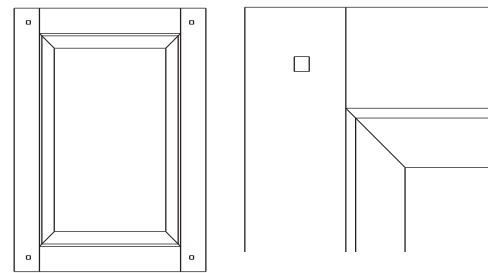
For apply over plywood and glue in strips methods:

List overall size of panel when ordering. Specify required reveal/margin. Refer to the appliance manufacturer's specifications for this information.

To see if the chosen door design can be manufactured as an appliance panel, refer to the Offering and Availability pages in the Wood Doors and Drawer Fronts section.

Appliance Panel	Insert Panel
<p>Appliance panels are used on the main surface area of the appliance. For example, the door of a dishwasher would receive an appliance panel.</p>	<p>Insert panels are used in smaller, complementary areas of the appliance, such as over access panels of a refrigerator or dishwasher.</p>
<p><b>Appliance Panel Edge Profile</b> 2-11/16" Stiles and Rails standard. Add \$ per design charge. Only available in 3/4" thickness.</p>	<p>For appliance panel edge profile. 3/4"slab with an appliance edge profile \$ design charge. Material Category B.</p>
<p><b>Glue in strips</b> 5 sq. ft or under – Add \$ list to design charge. Over 5 sq. ft. – Add \$ list to design charge. Multiple doors on one panel; \$ per extra door.</p>	<p>For glue in strips and apply over plywood options. Insert profiles will match the panel raise ordered on the doors. \$ design charge. Material Category B.</p>
<p><b>Apply over plywood</b> 5 sq. ft or under – Add \$ list to design charge. Over 5 sq. ft. – Add \$ list to design charge. Multiple doors on one panel; \$ per extra door.</p>	

Options



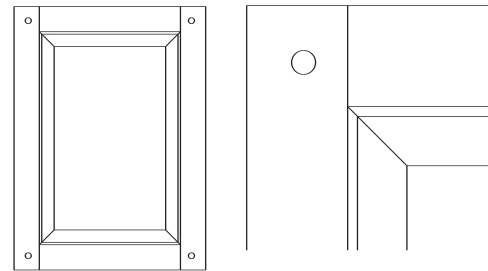
**5/16" Square Pegs**

\$ . per peg

Specify quantity, location and specie. If location is not specified, pegs will be located 1-3/16" from inside of framing bead to center of peg.

All species available.

Add 1 day to lead-time.



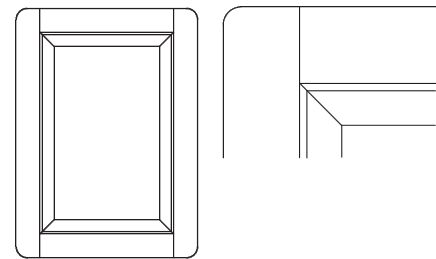
**1/2" Round Pegs**

\$ . per peg

Specify quantity, location and specie. If location is not specified, pegs will be located 1-3/16" from inside of framing bead to center of peg.

Pegs available in Red Oak, Cherry, Walnut or Hard Maple.

Add 1 day to lead-time.



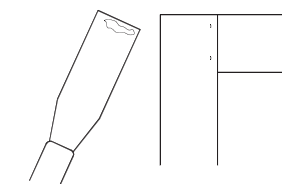
**Radius Corners**

\$ per door.

Specify 1/8", 1/4", 1/2", or 1" radius.

Available with B-2, C-2, H-2, LC-2, L-059, O, L-149, Machine Edge, PRS-2 and V-2 edge profiles only.

Add 1 day to lead-time.

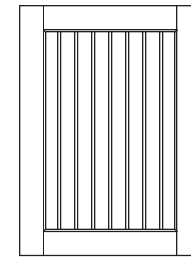


**Putty Pin Holes**

\$ per door.

No additional lead-time required.

Options (continued)



Groove width: 1/4"  
Groove depth: 1/16"

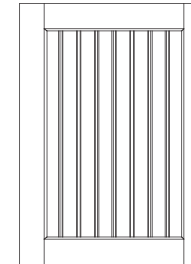
**G-012 Rout**

\$ per panel.

1-1/2" spacing from center of groove to center of groove standard. Groove pattern begins from center of panel.

Custom spacing available.

Add 1 day to lead-time.



Groove width: 3/8"  
Groove depth: 1/8"

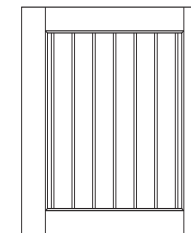
**G-056 Rout**

\$ per panel.

1-1/2" spacing from center of groove to center of groove standard. Groove pattern begins from center of panel.

Custom spacing available.

Add 1 day to lead-time.



Groove width: 1/4"  
Groove depth: 1/8"

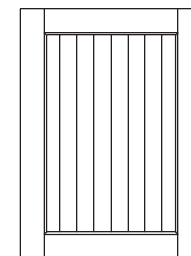
**G-121 Rout**

\$ per panel.

1-1/2" spacing from center of groove to center of groove standard. Groove pattern begins from center of panel.

Not available with 1/4" panels.

Add 1 day to lead-time.



3/4" or 1-1/2" spacing  
1/2" spacing

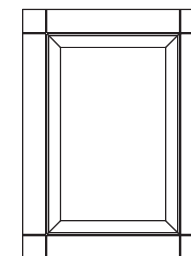
**G-015 Panel Groove Rout**

\$ per panel.

1/2", 3/4" or 1-1/2" spacing.

On 1/2" grooving base of groove is square.

Add 1 day to lead-time.



**Camelot Rout**

\$ per door.

Rout available on stiles only. Must be specified when ordering.

On designs with Cathedral top or bottom rails, rout is available on stiles only.

Cannot be used with applied moulding, Madison, miter designs or Presidential series.

Add 1 day to lead-time.

Options (continued)



**Distressing**  
Add 1 day to lead-time.

Distressing, descriptions and charges		
Description of Levels	Design Charge	Material Charge
<b>Level 1</b> A random distribution of nicks and impressions.		\$ per sq. ft.
<b>Level 2</b> Level 1 plus simulated wormholes, razor cuts and cut joints.		

**Cross Grain Sanding**

The cross grain sanding option is available on unfinished doors and drawer fronts. See radius options for radius pricing.

Please note, even with cross grain removal, Northwoods doors are not finish-room ready. To prepare for finishing, Northwoods recommends a light hand sanding in addition to cross grain removal.

This option is automatically included at no charge on prefinished products. Prices below are per panel for unfinished doors, Wainscoting and Appliance Panels, and per piece for other unfinished products such as drawer fronts and valances.

Face, back and edge profile	\$	Edge profile only	\$
Face and edge profile only	\$	Face only	\$.
Face and back only	\$		

No additional lead-time required.

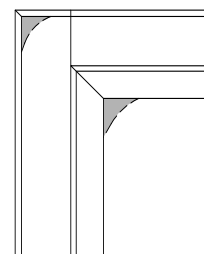
**Antiquing**

\$ design charge. \$ per square foot.

Antiquing is a random post-stain sanding of exposed corners and edges. Provides a complementary worn look to our distressing.

To achieve a heavier level antiquing, combine this option with the wear sanding option also found in this section.

No additional lead-time required.



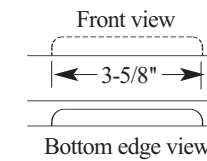
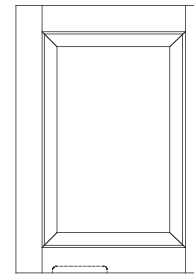
**Wear Sanding**

\$ per panel

The wear sanding option provides an aged appearance to unfinished doors and drawer fronts. On raised panel designs, sanding is applied to the corners of the panel and the outside corners of the framing. Flat panel, mullions and frame only designs will receive sanding on the outside corners of the frame. Sanding will be random and each corner will vary in appearance. Wear sanding is available with all published panel raises and edge profiles.

No additional lead-time required.

Options (continued)



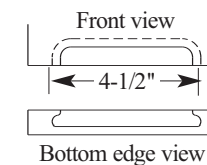
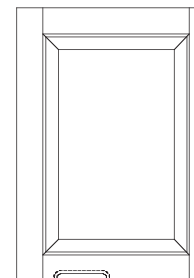
**Back Routed Hand Pull**

\$ per door.

Specify location: top or bottom and left, right or centered. Rout is 3-5/8" wide and 3/8" deep. When specifying left or right hand, pull will start 3" in from edge of door. Hand pull is centered on doors less than 10" wide.

Available with all edge profiles without Rabbet except Bullnose, CFP, E-2, FP, L-253, L-686 and Round-2.

Add 1 day to lead-time.



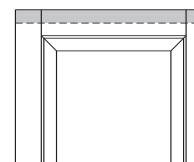
**Face Routed Hand Pull**

\$ per door.

Specify location: top or bottom and left, right or centered. Rout is 4-1/2" wide and 1/2" deep. When specifying left or right, hand pull will start 3" in from edge of door. Hand pull is centered on doors less than 10" wide.

Available with all edge profiles without Rabbet except Bullnose, CFP, E-2, FP, J-2, L-253, L-686, LC-Inset, O and Sophisticate.

Add 1 day to lead-time.



**Cut Down (Width or Height)**

\$ per door.

The cut down option is for mortise and tenon drawer fronts and doors that are manufactured to the minimum size and cut down to achieve a smaller size. This option is not available for mitered designs.

No additional lead-time required.

**Non-standard Width Framing**

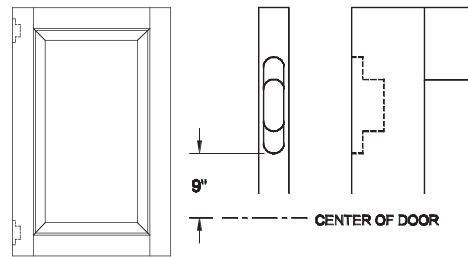
Madison, Presidential series doors	
Additional charges for wider framing	
Framing Width	Cost per stile and rail
Std. width to 6-7/16"	\$
6-1/2" to 8-3/4"	
8-13/16" to 14-15/16"	
15" and over	Quote from Special Designs

Use this pricing for wider stiles, rails and middle rails on multiple panel Madison and Presidential door designs.

Non-standard Width Framing, 1-1/4" minimum size		
Only available on mortise and tenon constructed doors.		
Width		Cost per stile and rail
1-1/4" to std. width		\$
std. width to 6-7/16"		
6-1/2" to 8-3/4"		
8-13/16" to 14-15/16"		
15" and over		Quote from Special Designs

Stiles 8-13/16" to 15" wide automatically receive a mullion-type spline as a structural reinforcement. Charge for spline is \$ per stile.

Options (continued)



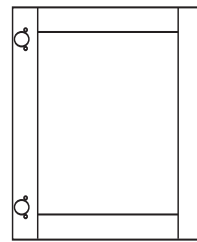
**Soss Hinge Boring**

\$ per door.

The routs are placed 9" off center, measured from the vertical center of the door to the start of the rout.

Not available on doors over 42" high or under 25-1/8" high.

Add 1 day to lead-time.



**Concealed Hinge Boring: Pattern "A" 2.5mm**

\$ per door.

Boring consists of a 35mm diameter hole, 13.5mm deep with a 2.5mm tab dimension from the edge of the door

Insert holes are 8mm in diameter, 11.9mm deep, located 9.5mm from the center of the 35mm bore to the center of the 8mm insert bore.

Distance between insert bores is 45mm.

When ordering Pattern "A", specify with or without insert holes.

Doors 9" - 42" long receive two bores.

Doors 42-1/16" - 72" receive three bores with one hole centered.

Doors 72 -1/16" and longer receive four bores with center holes set 25" in from each end.

Boring available on the following edge profiles only: B-2, LC-Inset, L-O59, LC-2, L-149, PRS-2, Machine Edge and V-2. Not available with rabbeted or partial inset edge profiles.

Pattern "A" accommodates the following manufacturers' hinge models:

Blum: Compact 33

Grass: Tech, 300, and 3000 Series

Amerock: CM2042

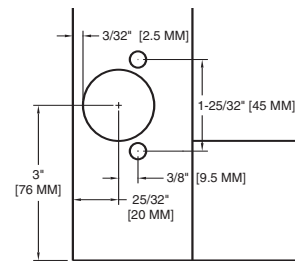
Mepla: ACC162 (screw-in version)

Salice: "S" Series

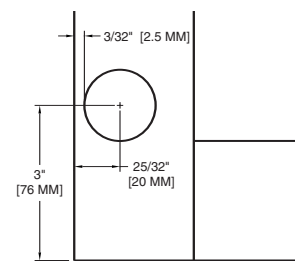
Hettich: TB and Optimat TB Series

Add 1 day to lead-time.

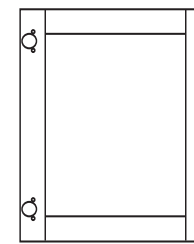
With insert holes



Without insert holes



Options (continued)



**Concealed Hinge Boring: Pattern "B" 5mm**

\$ per door.

Boring consists of a 35mm diameter hole, 13.5mm deep with a 5mm tab dimension from the edge of the door.

Insert holes are 8mm in diameter, 11.9mm deep, located 9.5mm from the center of the 35mm bore to the center of the 8mm insert bore.

Distance between insert bores is 45mm.

When ordering Pattern "B", specify with or without insert holes.

Doors 9" - 42" long receive two bores.

Doors 42-1/16" - 72" receive three bores with one hole centered.

Doors 72-1/16" and longer receive four bores with center holes set 25" in from each end.

Boring available on the following edge profiles only: B-2, LC-Inset, L-O59, LC-2, L-149, PRS-2, Machine Edge and V-2. Not available with rabbeted or partial inset edge profiles.

Pattern "B" accommodates the following manufacturers' hinge models:

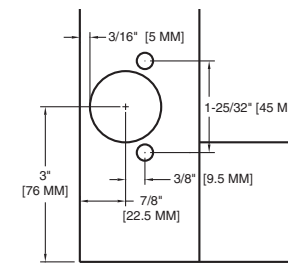
Blum: 107, 120, 120+, 170, Diagonal 20, 30, 37, 45 Angle 25 and Clip Top Series

Grass: Tech, 300, and 3000 Series

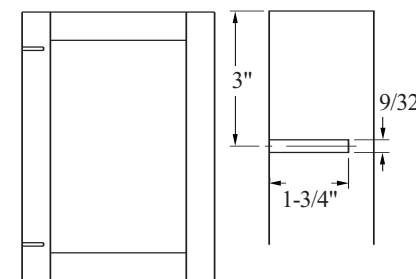
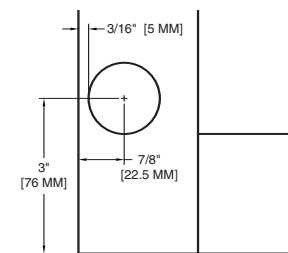
Salice: 200 Series (use 2mm mounting plate)

Add 1 day to lead-time.

With insert holes



Without insert holes



**Knife Hinge Slot**

\$ per door

Knife hinge slot is 9/32" wide, 37/64" deep and 1-3/4" long. Placement is 3" from the edge of the door to the center of slot.

Doors 9" - 35-15/16" receive 2 slots.

Doors 36" - 51-15/16" receive 3 slots with one centered.

Doors 52" and greater receive 4 hinges with center slots set 25" in from each end.

Knife hinge slot will accommodate the following hinges:

Youngdale #5 and #6 hinges.

Amerock #2603, #2605 and #2606 hinges.

Hinge slot available with the following edge profiles only: B-2, C-2, E-2, J-2, H-2, LC-Inset, LC-2, L-149, Machine Edge, PRS-2 and V-2. Not available with rabbeted or partial inset edge profiles.

Knife hinge slot is not available on framing less than 2-5/16" in width. Cut down framing option is not available.

Knife hinge slot is not available with frame only or mullion designs, doors under 9", Batten designs, CRP-10605 and CRP-10446.

Add 1 day to lead-time.