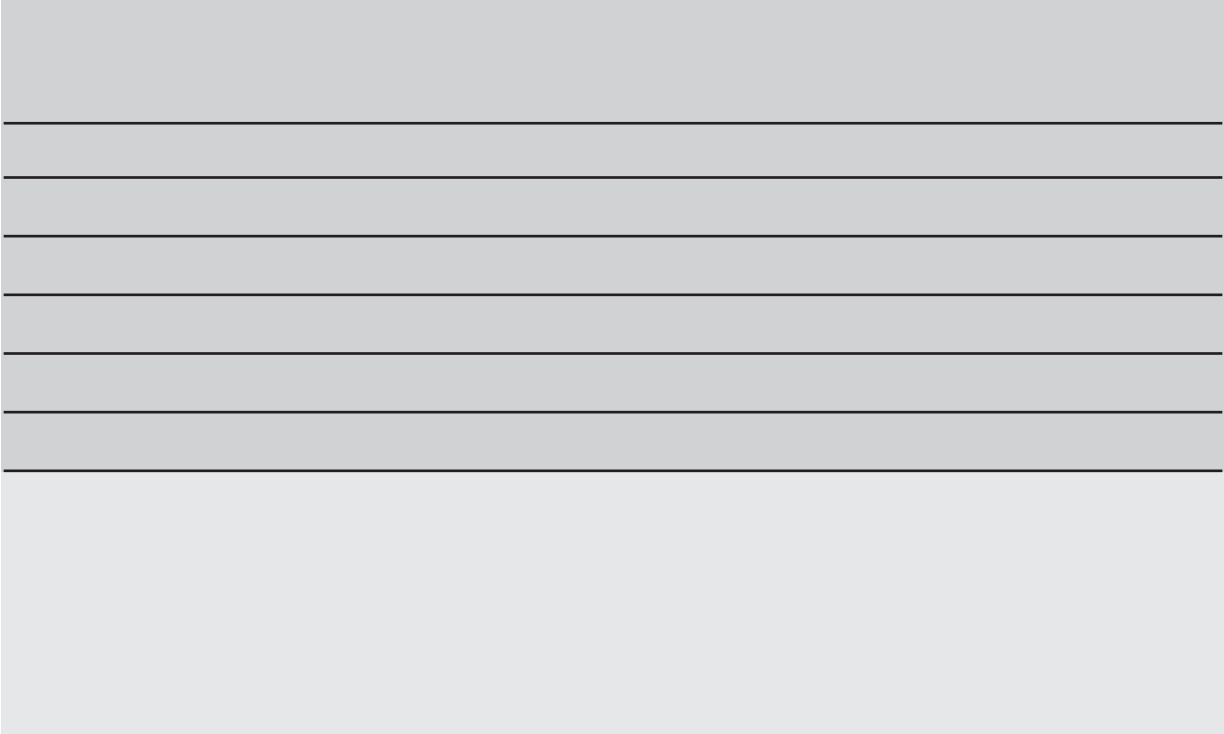


Custom Products Manual

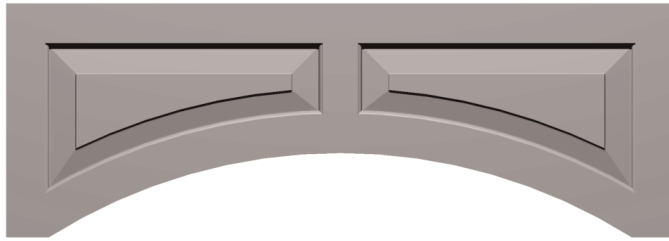
Effective Spring 2005

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

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Custom Valances



Arched Valance

Valances 30" to 48" – Design Charge \$
Valances 51" to 72" – Design Charge \$

Arched Raised Valance Offering and Availability

Arched Raised Panel Valances are available only in three inch wide increments from 30" to 72".

Minimum size is 30" wide x 12-1/2" high. Framing width - 2-3/4" stiles, 2-5/16" rails, 2-1/2" upright mid-rail. The distance from the most narrow point to the widest point is always 4-1/2", regardless of valance width.

Horizontal grain panels are standard, vertical grain is available with a \$ per valance upcharge.

Design standard as shown. Individual designs, including applied moulding, must be ordered through Special Designs.

Species

Material Pricing Guide: All 3/4" and 1" species available, except 1" rustic knotty species.

Edge Profiles

Page 5.1 Machine edge, no other choices available.

Framing Beads

Page 5.2 All 3/4" and 1" available.

Panel Raise

Page 5.2 All 3/4" and 1" raises available.

Options

Page 5.8-5.13 Pegs, distressing, cross grain sanding, radius corners, wear sanding, putty pin holes, cut down in width only.

Custom Valances (continued)

Custom Straight, Scrolled, Scalloped and Roman Arch Valances are available in a 6" width (5" width in English Country). All valance material is priced using Material Pricing Guide, Category B, utilizing typical design and material pricing procedures.



Straight

Valances 12" to 60" – Design Charge \$
Valances 60 1/16" to 96" – Design Charge \$



Scrolled

Valances 12" to 60" – Design Charge \$
Valances 60 1/16" to 96" – Design Charge \$



Scalloped

Valances 12" to 60" – Design Charge \$
Valances 60 1/16" to 96" – Design Charge \$



Roman Arch

Valances 12" to 60" – Design Charge \$
Valances 60 1/16" to 96" – Design Charge \$



English Country (single pattern)

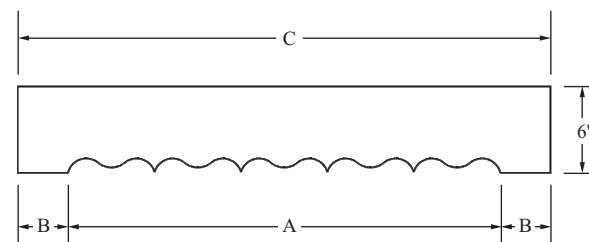
Design Charge \$



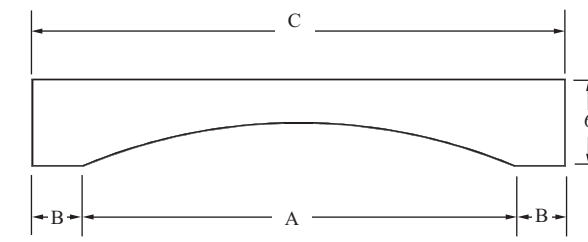
English Country (multiple pattern)

Design Charge \$
+ \$ per additional rout.

Scrolled Valance and Roman Arch Valance



Scrolled Valance



Roman Arch Valance

Scrolled Valance and Roman Arch Valance Matrix

A = Pattern length B = Straight run on left and right ends C = Overall length											
A	9"	11"	14"	19"	24"	30"	42"	54"	66"	78"	B
C	12"	–	–	–	–	–	–	–	–	–	1-1/2"
C	13"	–	–	–	–	–	–	–	–	–	2"
C	14"	–	–	–	–	–	–	–	–	–	2-1/2"
C	15"	17"	–	–	–	–	–	–	–	–	3"
C	16"	18"	21"	26"	31"	37"	49"	61"	73"	85"	3-1/2"
C	–	19"	22"	27"	32"	38"	50"	62"	74"	86"	4"
C	–	20"	23"	28"	33"	39"	51"	63"	75"	87"	4-1/2"
C	–	–	24"	29"	34"	40"	52"	64"	76"	88"	5"
C	–	–	25"	30"	35"	41"	53"	65"	77"	89"	5-1/2"
C	–	–	–	–	36"	42"	54"	66"	78"	90"	6"
C	–	–	–	–	–	43"	55"	67"	79"	91"	6-1/2"
C	–	–	–	–	–	44"	56"	68"	80"	92"	7"
C	–	–	–	–	–	45"	57"	69"	81"	93"	7-1/2"
C	–	–	–	–	–	46"	58"	70"	82"	94"	8"
C	–	–	–	–	–	47"	59"	71"	83"	95"	8-1/2"
C	–	–	–	–	–	48"	60"	72"	84"	96"	9"

Valance Matrix Instructions

Use matrices on the following pages to determine the specifications for a patterned valance. Find the desired valance length in one of the C rows. The top number (white numbers in a black box) in the column with the desired length is the pattern length. The pattern will be centered on the valance.

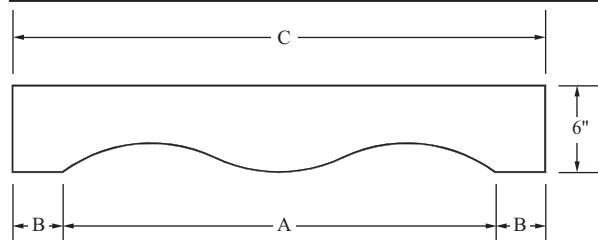
From the C block containing the desired valance length, the extreme right number in that row, which is under column B, is the size of the non-patterned area on the left and right side of the pattern.

Example: If ordering a scrolled valance with an overall length of 30" (dimension C), it can be seen that:

- 30" appears in the fifth C row, second column of the Matrix.
- Referring to the top of the column, in row A, a pattern length of 19" will be found.
- Referring back to the 30" C row, at the right end of the row, in column B, a straight, non-patterned run of 5-1/2" on both the left and right ends of the valance will be found.

The selected 30" valance will have a pattern 19" wide, centered on the valance, with 5-1/2" wide non-pattern areas at both ends of the valance.

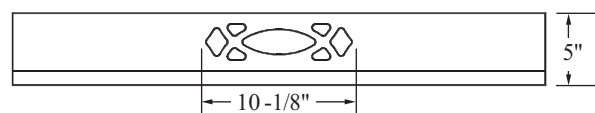
Scalloped Valance



Scalloped Valance Matrix

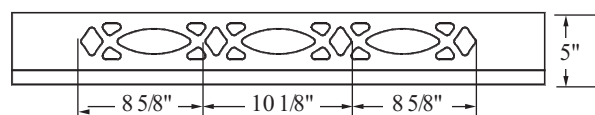
A = Pattern length B = Straight run on left and right ends C = Overall length											
A	9"	11"	14"	19"	24"	36"	48"	60"	72"	84"	B
C	-	-	-	-	-	37"	49"	61"	73"	85"	1/2"
C	-	-	-	-	-	38"	50"	62"	74"	86"	1"
C	12"	-	-	-	-	39"	51"	63"	75"	87"	1-1/2"
C	13"	-	-	-	-	40"	52"	64"	76"	88"	2"
C	14"	-	-	-	-	41"	53"	65"	77"	89"	2-1/2"
C	15"	17"	-	-	-	42"	54"	66"	78"	90"	3"
C	16"	18"	21"	26"	31"	43"	55"	67"	79"	91"	3-1/2"
C	-	19"	22"	27"	32"	44"	56"	68"	80"	92"	4"
C	-	20"	23"	28"	33"	45"	57"	69"	81"	93"	4-1/2"
C	-	-	24"	29"	34"	46"	58"	70"	82"	94"	5"
C	-	-	25"	30"	35"	47"	59"	71"	83"	95"	5-1/2"
C	-	-	-	-	36"	48"	60"	72"	84"	96"	6"

English Country Valances



Single Rout

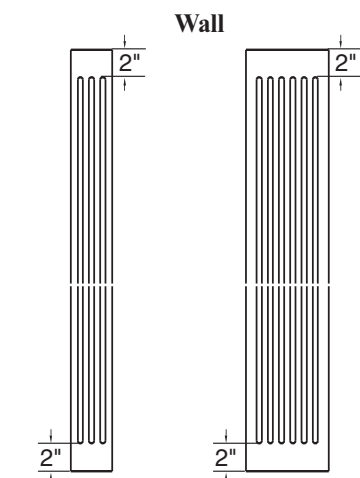
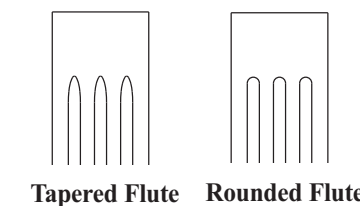
English Country Valance		
Number of Routs	Minimum Length	Maximum Length
1	12"	99"
2	20-1/2"	99"
3	29-1/2"	93"
4	38"	84"
5	46-1/2"	75"
6	55-1/2"	66"



Multiple Rout

Fluted Fillers

- Fluted fillers can be ordered in custom widths from 3" to 15-15/16" in all standard specie offerings including MDF.
- Choose from either Tapered or Rounded flutes. If not specified, flutes will be produced using the Tapered design.
- Non-fluted or "flat" areas are standard as shown, but can be customized to meet your design needs. Simple specify the flat dimensions desired. Specify "Flats to measure 0" to extend flutes the entire length of filler.
- Fluted filler pricing is determined using design plus material calculations. See the chart below to determine appropriate design charge. Calculate overall square footage of filler and refer to category B of the specie desired in the Material Pricing Guide to determine material charge.
- Number of flutes is indicated in the chart below. Custom flute spacing is available through our Special Designs Department.

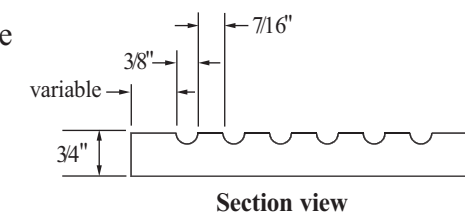


Fluted Filler Pricing

Filler Width	No. of Flutes	Under 60" in length	60" or greater in length
3" to 3-15/16"	3	\$	
4" to 4-15/16"	4		
5" to 5-15/16"	5		
6" to 6-15/16"	6		
7" to 7-15/16"	7		
8" to 8-15/16"	9		
9" to 9-15/16"	10		
10" to 10-15/16"	11		
11" to 11-15/16"	12		
12" to 12-15/16"	14		
13" to 13-15/16"	15		
14" to 14-15/16"	16		
15" to 15-15/16"	17		

Edge Profile Options

- Fluted fillers come standard with a Machine Edge, but can be ordered with a variety of edge profiles including B-2, C-2, LC-2, L-059, L-061, L-149, PRS-2, V-2 and L-686.
- Beveled edge profile selections include the L-151 (45 degree back bevel) and the L-423 (22-1/2 degree back bevel).
- Premium edge profiles include the LC-Inset and the Sophisticate edge. Upcharge applies.

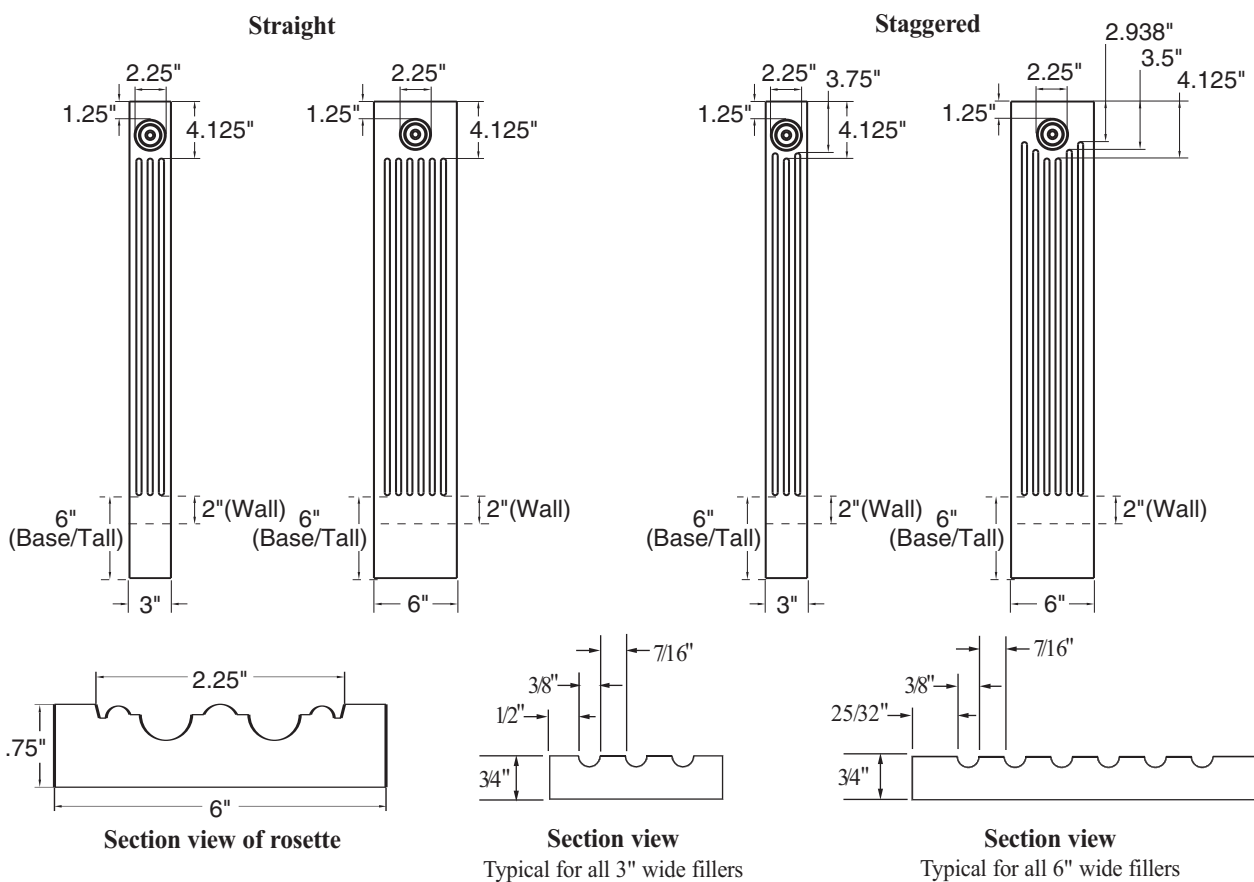


3" and 6" Fluted Fillers with Rosette

Fluted fillers can be ordered using the following specifications.

Width	Length	Species	Lead-Time
3" and 6"	Custom	Any Northwoods standard specie	10 days

Rosette fluted fillers can be ordered in a tapered or rounded flute design. Rosette fluted fillers will be manufactured as "tapered flute" unless otherwise specified.



Fluted Filler Pricing				
Description	3" Wide Fillers		6" Wide Fillers	
	Under 60" in Length	60" in Length or Greater	Under 60" in Length	60" in Length or Greater
Design Charge	\$			

- Use appropriate design and material charges.
- Use Material Pricing Guide Category B for all orders.

Rosettes may be added to the bottom of these fillers for an additional \$2.00. The position of the bottom rosette will mirror the placement of the top rosette.

Standard measurements for Wall and Base/Tall fluted fillers are identical with the exception of the length of the unfluted area on the bottom. Wall fillers are manufactured with a 2" unfluted area, Base/Tall fillers are manufactured with a 6" unfluted area.

Flat dimensions (length of unfluted area) at ends of fillers are standard as shown. Specify custom flat dimensions if desired. Specify "Flats to measure 0" to order flutes extending the entire length of the filler on the bottom only. Top flat may not measure less than 3-3/8".

Front Frames

- Front frames are constructed with blind mortise and tenon joinery.
- 3/4" thick framing is standard, 1" thick material is available with an upcharge.
- Standard framing width is 1-1/2".
- Minimum framing width is 3/4".
- Front frames are standard grade unless otherwise specified. Premium grade availability and pricing apply.
- Material is surfaced on four sides. Frames are sanded on front only with 180 grit paper.
- 1/32" offset on frame back at any joint is acceptable.
- 1/64" offset at any exterior joint on the outside perimeter of the frame is acceptable.
- Front frame exterior and interior opening dimensions can be ordered to the nearest 1/16". A tolerance of +/- 1/32" is acceptable.
- Acceptable tolerance for front frames under 12 sq. ft. is +/- 1/32" out of square. Acceptable tolerance for frames over 12 sq. ft. is +/- 1/16".
- Stiles or rails wider than 4-1/2" may have one glue joint. Framing wider than 6-1/2" may have two glue joints.
- Door and drawer front sizes must be specified for custom front frames ordered for use with Cabinet Systems.

Custom Front Frame Pricing				
Specie	Material Charge per Opening			
	1 or 2	3 or 4	5 or 6	7 or 8
Alder	\$			
Ash, White*				
Birch, White*				
Cherry*				
Hickory				
Lyptus				
Maple, Hard*				
Maple, Soft				
Oak, Red*				
Oak, White*				
Pine, Knotty				
Walnut				

Grey boxes: Indicates 15 day lead-time, all other standard species 10 days.

* Indicates premium specie availability — upcharges apply.

Pricing Instructions

- Front frame pricing is based on the number of openings and the external frame perimeter.
- Use frame perimeter (lineal inches) x specie price per lineal inch. Use the appropriate column to determine the material price, based on the number of openings.
- Add \$ for the first frame opening.
- Add \$ for each additional opening.

Front Frames (continued)

Options Pricing, Non-standard Framing			
Material Width	less than 36" long	36-1/16" to 60" long	60-1/16" and longer
3/4" to 1" <i>Special machining required</i>			
1-1/16" to 3"	No Upcharge		
3-1/16" to 5-5/16"			
6" to 7-7/16"			
7-1/2" and over	call for quote		

Northwoods reserves the right to quote any odd configurations, odd framing widths or large volume orders on a per-job basis.

Options

- Glue-in trimmable inserts: \$ per opening
- Groove for Cabinet Systems: \$0 per frame

Lead times

- Cherry, Hickory, Hard Maple, Soft Maple and Red Oak 3/4" thick front frames with framing widths under 5": 10 days
- Code Green expedite (limit 6 frames): 4-5 days
- All other species (includes 1" thick option and/or odd width framing) Expedites not available: 15 days

1/4" Short Grain Plywood Program

- 96" x 48" panel for island back or wall panel applications.
- Grain runs vertically in the 48" direction.
- 1/4" thick material with Grade A face veneers applied over MDF core with sound back.
- Finishing option is available; see Solid Wood Finishing for availability and pricing.
- Lead-times are 3 days unfinished; add 5-6 days for finishing.
- Oversize packaging fee applies.

1/4" x 96" x 48" Plywood Short Grain Panel	
Specie	Price
Cherry	\$
Hickory	
Maple, Hard	
Red Oak	

1/4" and 3/4" Plywood Program

- 1/4" thick sheet stock with Grade A face veneers applied over MDF core with sound back.
- 3/4" thick sheet stock with Grade A face veneer applied over plywood core with prefinished natural Birch back
- 1/4" and 3/4" sheet stock is available in full 4' x 8' sheets or as cut-to-size panels.
- Available unfinished or finished; see Solid Wood Finishing Program section for finish selections and pricing.
- Lead-time 4 days unfinished; add 5-6 days for finishing.

1/4" and 3/4" Plywood Program (continued)

- Oversized packaging charge of \$24.95 per item applies for large cut-to-size pieces or full 4' x 8' sheets of 1/4" or 3/4" material. Oversize packaging parameters and conditions are as follows:
 - The size exceeds 35" wide and 35" long
 - The size exceeds 48" wide or 85" long
 - A customer requests oversize packaging

Pricing Instructions

- Multiply actual square footage of panel by the appropriate specie material charge.
- Add the \$ design charge.
- Add options pricing if applicable.
- Apply trade discount to total.
- Add net packaging charges if applicable.

Options

- Cut-to-size charge: \$ per panel.
- Grooving available on 1/4" material only.
 - G-012, G-015 or G-056 groove profiles.
 - Spacing available in 1/2" increments starting at 1/2" up to 4".
- Panel Grooving charges:
 - Up to 24" wide and under 48" long: \$ per panel
 - Up to 24" wide and over 48" long: \$per panel
 - Over 24" wide and under 48" long: \$ per panel
 - Over 24" wide and over 48" in height: \$ per panel
- Grooving option adds 1 additional day to the lead-time.

End Skins

- 1/8" thick plywood with Grade A face veneers applied over veneer core with Lauan back.
- Fixed sizes configured for use with Northwoods Cabinet Systems as applied end panels.
- Finishing is available; see Solid Wood Finishing for availability and pricing.
- Lead-times 7 days unfinished; add 5-6 days for finishing.

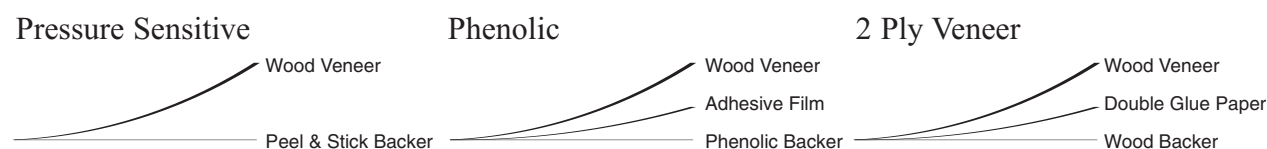
1/8" Veneer End Skins							
Specie	11-3/4" x 30"	11-3/4" x 42"	20-1/4" x 31-1/2"	23-1/4" x 34-1/2"	24" x 84"	24" x 92"	24" x 96"
Cherry	\$						
Hickory							
Maple, Hard							
Oak, Red							

1/4" Plywood Panel Program		
Specie	Material Charge	Design
Alder	\$	
Ash		
Birch, White		
Cherry		
Maple, Hard		
Hickory		
Knotty Pine		
Lyptus		
Quarter Sawn Red Oak		
Quarter Sawn White Oak		
Red Oak		
White Oak		
Walnut		

3/4" Plywood Panel Program		
Specie	Material Charge	Design
Alder		
Cherry		(list)
Maple, Hard		per panel
Lyptus		

Veneers

- Pressure sensitive veneers feature real wood veneer faces with a pre-glued adhesive backer and a protective layer that can simply be peeled away from backer prior to application. Thickness including backer is approximately 1/32" thick.
- Phenolic veneers feature real wood veneer faces with a phenolic backer. Thickness including backer is approximately 1/16" thick.
- The 2 ply veneers feature real wood veneer faces and a wood backer. 2 ply wood veneers allow staining of edges and reduces "black line" effect. Thickness including backer is slightly less than 1/16" thick.
- One end and one side of any veneer panel is guaranteed to be free from physical damage.
- Finishing available for all veneers. Stained veneers may vary slightly in color from solid wood products of the same specie. Finishing adds 5-6 days to standard lead-time.



Stock (3 day lead-time)			
Specie	Pressure Sensitive 24" x 96"	Phenolic Backed 36-1/2" x 96-1/2"	Wood* Backer 48-1/2" x 97"
Alder	\$		
Cherry			
Maple, Hard			
Oak, Red			

*Wood backed 2 ply veneers not available with Colourtone finishes. 4' x 8' phenolic back veneers will be substituted.

Extended Ship (10 day lead-time)			
Specie	Pressure Sensitive 24" x 96"	Phenolic Backed 36-1/2" x 96-1/2"	Wood* Backer 48-1/2" x 97"
Ash, White	\$		
Birch, White			
Hickory			
Lyptus			
Oak, White			
Pine, Knotty			
Walnut			

Specifications and Ordering Information

- Veneers are not guaranteed to perfectly match solid wood doors. Veneer is sliced from premium material; color and grain match will be more uniform than solid wood doors. Hickory veneers may contain mineral streaks and peck marks.
- Northwoods does not accept returns on veneers.
- Northwoods is not liable for the application of veneers. Use veneer manufacturer's application instructions for adhesive selection and recommended application steps.
- To order veneers, use the appropriate section on the Valance, Veneers and Fluted Filler Order Form or the miscellaneous portion of the Custom Order Form. Check the specie and write the desired quantity under your veneer choice. Use the special instructions section for finishing or other special notes.

Appliance Garage

Height: 18"
 Width: Appliance Garage (AG): 24" and 30"
 Corner Appliance Garage (CAG): 16-1/4" face on front
 Front thickness: AG: 3/4"
 CAG: 1"
 Door opening: AG2418 21" x 14-7/8"
 AG3018 27" x 14-7/8"
 CAG3318 13-1/2" x 14-7/8"
 Species: Cherry, Hard Maple, Soft Maple, Red Oak, Hickory.
 AG3018 not available in Hickory

Material Specifications

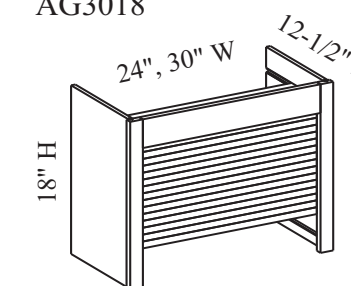
- 7 Ply plywood construction with Natural Birch pre-finished interior.
- Unfinished exterior unless finished option is specified.
- 1/2" exposed sides standard.
- Solid wood front frame.
- Matching specie tambour door with loose hand pull and a spring tension track system.
- Appliance garages come unassembled and require assembly with glue and a pin gun.

Options

- 11/16" matching species flush sides available.
- Cabinet exterior finished in any of Northwoods specific specie finishes, upcharges apply. See the Solid Wood Finishing section for pricing.
- Choice of Northwoods framed doors listed in Wood Doors and Drawer Fronts section. Custom doors can be selected and priced using the design plus material method.

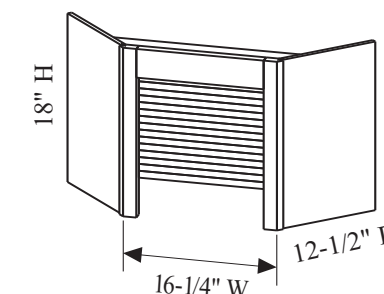
Appliance Garage

AG2418
AG3018



Corner Appliance Garage

CAG3318



Specie	Appliance Garage Pricing					
	AG2418		AG3018		CAG3318	
	w/tambour	w/o tambour	w/tambour	w/o tambour	w/tambour	w/o tambour
Cherry	\$					
Maple, Hard						
Maple, Soft						
Hickory						
Red Oak						

Appliance Garage Lead-times, Work Days

with tambour door7 standard, 4 expedite
 with custom door.....listed lead-time of custom door
 Finishing optionsadd 5 to 6 days