CONSTRUCTION

			CASEWORK GRADES				
			PREMIUM GRADE		CUSTOM GRADE		ECONOMY (grade not approved)
PARTS	SURFACE	DESCRIPTION	BJC	NAAWS	BJC	NAAWS	NAAWS
Joinery - Drawers	All Corners	Multiple dovetail (all corners) or French dovetail front/dadoed back, glued under pressure	X	X	X	X	X
		Doweled, glued under pressure (min. 32 mm dowel spacing to 102 mm [4"] high, 64 mm dowel spacing above 102 mm [4"])	X	X	X	X	X
		Lock shoulder, glued and pin nailed	X	X	X	X	X
		Miterfolded from a single panel in one machining process	X	X	X	X	X
		Lock shoulder, glued and pin nailed			X	X	X
		Square Shoulder, nailed or stapled					X
	Bottoms	Bottoms shall be set into sides, back and front, 6.4 mm [1/4"] deep groove with minimum 9 mm [3/8"] standing shoulder	X	X	X	X	X
		Bottoms shall be set into sides and front, 6.4mm [1/4"] deep groove with minimum 9 mm [3/8"] standing shoulder				X	X
		Bottom installation technique mill option					X
Joinery - Body Members	Tops, exposed ends and bottoms (finished ends on casework shall be integral, not applied secondarily)	Stop dado*, glued with pressure, and either nailed, stapled or screwed (fasteners will not be visible on exposed parts)	X	X	X	X	X
		Doweled, glued with pressure; approx. 1 per 75 mm of joint [4/foot]	X	X	X	X	X
		European assembly screws (37 mm from end, 128 mm on center, fasteners will not be visible on exposed parts)	X	X	X	X	X
		Fully concealed interlocking mechanical system	X	X	X	X	X
		Spline or biscuit, glued with pressure (approx. 1 per 100 mm of joint)			X	X	X
		Through dado, glued with pressure; or exposed European assembly screws with trim caps					X
	Exposed end corner details and face frame attachment	Mitered joint: lock miter or spline or biscuit, glued under pressure (no visible fasteners)	X	X	X	X	X
		Non-mitered joints, i.e. 90 degree applications: butt joint glued under pressure (no visible fasteners)	X	X	X	X	X
		Fully concealed interlocking mechanical system	X	X	X	X	X
		Butt joint, glued and finish nailed			X	X	X
		Butt joint, finish nailed					X
	Cabinet backs - Wall hung	In all Grades, wall hung cabinet backs must not be relied upon to support the full weight of the cabinet and its anticipated load for hanging/mounting purposes. Hanging/mounting mechanisms should transfer load to case body member(s).	X	X	X	X	X
		Captured in grooves on cabinet sides and bottom; securely fastened	X	X	X	X	X
		Side bound, captured in groove or rabbetts; securely fastened			X	X	X
		Full overlay, plant-on backs: min. 12.7 mm [1/2"] thick attached with min. #8 low root, high thread (not "drywall") screws spaced max. 200 mm [8"] on center. Anchor strips not required for backs 12.7 mm [1/2"] or thicker, so attached. Edge of back not exposed on finished ends	X	X	X	X	
		Full overlay, plant-on backs: min. 12.7 mm [1/2"] thick attached with min. #8 low root, high thread (not "drywall") screws spaced max. 200 mm [8"] on center. Anchor strips not required for backs 12.7 mm [1/2"] or thicker, so attached. Edge of back exposed on finished ends					X
	Cabinet backs - Floor standing	Side bound, captured in grooves; securely fastened to top and bottom	X	X	X	X	X
		Side bound, placed in rabbets; securely fastened in rabbets			X	X	X
		Full overlay, plant-on backs: min. 12.7 mm [1/2"] thick attached with min. #8 low root, high thread (not "drywall") screws spaced max. 200 mm [8"] on center. Anchor strips not required for backs 12.7 mm [1/2"] or thicker, so attached. Edge of back not exposed on finished ends	X	X	X	X	
		Full overlay, plant-on backs: min. 12.7 mm [1/2"] thick attached with min. #8 low root, high thread (not "drywall") screws spaced max. 200 mm [8"] on center. Anchor strips not required for backs 12.7 mm [1/2"] or thicker, so attached. Edge of back exposed on finished ends					X

		Mill option, back required when specified or when exposed to view					X
	Anchor strips for cabinet backs	Anchor strips (for cabinet backs less than 12.7 mm [1/2"] thick)	X	X	X	X	
Fitting	Doors, Drawers and Removable Panels	1/8" gap between doors, drawers, panels, and frames Door to door; door to drawer; drawer to drawer	X	X	X	X	X
		1/32"+/- gap tolerance	X	X			
		1/16" +/- gap tolerance			X	X	
		3/32" +/- gap tolerance					X
	Factory Assembled Joints	Maximum .005" as measured with a feeler gauge	X	X			
		Maximum .010" as measured with a feeler gauge			X	X	
		Maximum .015" as measured with a feeler gauge					X
	Exposed Parts	1/64" maximum gap between fixed exposed parts	X	X			
		1/32" maximum gap between fixed exposed parts			X	X	
		1/16" maximum gap between fixed exposed parts					X
		3" maximum length of gap in fixed exposed parts	X	X			
		5" maximum length of gap in fixed exposed parts			X	X	
		8" maximum length of gap in fixed exposed parts					X
	Semi-Exposed Parts	1/32" maximum gap between fixedsemi-exposed parts	X	X			
		1/16" maximum gap between fixed semi-exposed parts			X	X	
		1/8" maximum gap between fixed semi-exposed parts					X
		6" maximum length of gap in fixed semi-exposed parts	X	X			
		8" maximum length of gap in fixed semi-exposed parts			X	X	
		12" maximum length of gap in fixed semi-exposed parts					X
		1/16" maximum gap between each end of adjustable shelf and case side	X	X	X	X	
		1/8" maximum gap between each end of adjustable shelf and case side					X
	Edge Joint Quality	All adhesive residue shall be removed from all Exposed and Semi-exposed surfaces in all Grades.	X	X	X	X	X
		All laminate and PVC edges shall be machined flush, filed, sanded, or buffed to remove machine marks and eased (sharp corner removed). Cleanup at easing shall be such that no overlap of the member eased is visible. Chipout of the laminate shall be invisible when viewed at 610 mm [24"].	X	X			
		All laminate and PVC edges shall be machined flush and eased (sharp corner removed). Cleanup at easing may show a maximum visible overlap of no more than .13 mm [.005"] for a length of no more than 25.4 mm [1"] in any 610 mm [24"] run. Chipout of the laminate shall be invisible when viewed at 1219 mm [48"]			X	X	
		All laminate and PVC edges shall be eased (sharp corner removed). Cleanup at easing may show a maximum visible overlap of no more than .13 mm [.005"] for a length of no more than 50.8 mm [2"] in any 1219 mm [48"] run. Chipout of the laminate shall be invisible when viewed at 1829 mm [72"].					X
		Removal of color/pattern of face material due to overmachining limited to 1.6 mm [1/16"] x 38.1 mm [1-1/2"] and shall not occur within 1829 mm [72"] of a similar occurrence.	X	X			
		Removal of color/pattern of face material due to over-machining limited to 1.6 mm [1/16"] x 76 mm [3"] and shall not occur within 1524 mm [60"] of a similar occurrence.			X	X	
		Removal of color/pattern of face material due to over-machining limited to 2.4 mm [3/32"] x 102 mm [4"] and shall not occur within 1219 mm [48"] of a similar occurrence.					X
	Edgebanding Tolerance	.001" maximum variation of flushness with adjacent surfaces	X	X			
		.005" maximum variation of flushness with adjacent surfaces			X	X	
		.010" maximum variation of flushness with adjacent surfaces					X
		All edgebanding must be free of delamination, bubbles, and all adhesive residue	X	X	X	X	X