

MATERIALS

MATERIALS				CASEWORK GRADES						
PARTS	SURFACE	CONDITION	DESCRIPTION	PREMIUM GRADE		CUSTOM GRADE		ECONOMY (grade not approved)		
				BJC	NAAWS	BJC	NAAWS	NAAWS		
Exposed Parts (In general, this is all surfaces that are visible and exposed to view with any doors and drawers in the closed position)	Faces	General	High-pressure laminate, nominal 0.7 mm [.028"] thick (core: particleboard or MDF)	X	X	X	X	X		
			Thermoset decorative overlay (color and pattern selections limited; core: particleboard or MDF)				X	X		
		Blending of laminate across multiple cabinet faces in one elevation (grained/patterned decorative laminate)	Continuous pattern (not necessarily balance and/or center matched), material permitting	X	X	X	X	X		
			No match required					X		
		Direction and matching of wood grain or pattern on individual cabinet	Continuous vertical figure across doors and drawer fronts and selection for pleasing blend of figure and color per elevation	X	X	X	X	X		
			Continuous vertical figure across doors of individual cabinet; drawer fronts may be horizontal or vertical figure without sequence (not required from cabinet to cabinet)			X	X	X		
	No match required					X				
	Edges	Body Members (including face frames)	0.5 mm PVC edgeband, color matched to laminate (core: close grain)	X	X	X	X	X		
			Filled and sanded					X		
		Shelves (exposed)	3.0 mm PVC edgeband, color matched to laminate (core: close grain)	X		X				
			0.5 mm PVC edgeband, color matched to laminate (core: close grain)		X	X	X	X		
			Filled and sanded					X		
		Non-Flush Overlay Style Cabinet Doors and Drawer Fronts	0.5 mm PVC edgeband, color matched to laminate (core: close grain)	X	X	X	X	X		
			Filled and sanded					X		
		Flush Overlay Style Cabinet Doors and Drawer Fronts (drawer fronts are separate panels that are attached to the drawer body)	3.0 mm PVC edgeband, color matched to laminate (core: particleboard or medium density fiberboard [MDF], veneer core not permitted for doors)	X		X				
			Edgebanded laminate, same pattern, color and thickness both face and back (core: particleboard or medium density fiberboard [MDF], veneer core not permitted for doors)		X	X	X	X		
			Edgebanded laminate, with laminate of same nominal thickness on back (core: particleboard or medium density fiberboard [MDF], veneer core not recommended)				X	X		
			Edgebanded thermoset decorative overlay both face and back, (core: particleboard or medium density fiberboard [MDF], veneer core not recommended)				X	X		
		Semi-Exposed Parts (In general, this is all surfaces that are not visible when doors and drawers are in the pen position)	Faces	All Parts Except For Drawer Bodies and Backs of Flush Doors (drawer body = sides, back, front, bottom)	High-pressure laminate (mill option color), nominal 0.7 mm [.028"] thick	X	X	X	X	X
					Thermoset decorative overlay, solid color or nominal 0.5 mm [.020"] Cabinet liner on particleboard core		X	X	X	X
Particleboard (sealed or painted), or paper impregnated decorative overlay									X	
Drawer Sides and Backs	Single species solid lumber with a Section 100-G-1 hardness rating of Medium or better (minimum 12.7 mm [1/2"] finished thickness)			X	X	X	X	X		
	7 ply all hardwood veneer core plywood, no voids (minimum 12.7 mm [1/2"] thickness); No edge band required			X	X	X	X	X		
	High pressure decorative laminate (HPDL) on 7 ply veneer core substrate (minimum 12.7 mm [1/2"] thickness)			X	X	X	X	X		
	Edgebanded HPDL or thermoset decorative overlay on particleboard core (minimum 12.7 mm [1/2"] thickness)			X		X	X	X		
Medium density particleboard or medium density fiberboard (minimum 9.5 mm [3/8"] thickness)								X		
								X		
Drawer Bottom	Veneer core panel product, "B" face hardwood veneer			X	X	X	X	X		
	Thermoset decorative overlay panel product		X	X	X	X	X			
	Hardboard (smooth side visible inside)					X	X			
Edges	Body members (including face frames)		0.5 mm PVC edgeband, color matched to laminate (core: close grain)	X	X	X	X	X		
			Filled and sanded					X		
	Shelves (semi-exposed)	0.5 mm PVC edgeband, color matched to laminate (core: compatible species)	X	X	X	X	X			
		Filled and sanded					X			
Concealed Parts	Faces	All concealed conditions	Thermoset decorative overlay, solid color or nominal 0.5 mm [.020"] Cabinet liner on particleboard core	X		X				
			Mill Option		X		X	X		
Notes	Flush cabinet door limits - 19 mm [3/4"] medium density particleboard or medium density fiberboard core up to 762 mm [30"] width by 2032 mm [80"] height, with like materials and thicknesses both faces. Veneer core doors will not be guaranteed against warping, telegraphing, or delamination. Larger doors require special design, engineering, and fabrication. Design teams and manufacturers shall work together to develop sound solutions.									
	The application of any thickness of HPDL over the top of existing HPDL is not permitted.									
	The application of any thickness of HPDL over the top of existing thermoset (melamine) is discouraged according to NAAWS and not permitted by BJC standards.									